

Alkyd

PRODUCT DESCRIPTION

A single component, fast drying, high build alkyd primer.

INTENDED USES

As a shop applied post-fabrication primer specifically designed for a blast, fabricate and prime steel production route, and where fast drying and rapid handling properties are required.

Suitable for use in mild to moderate corrosive environments such as those typically found in commercial buildings, schools, hospitals, etc.

PRACTICAL INFORMATION FOR INTERPRIME 306

Colour	Limited range
Gloss Level	Matt
Volume Solids	45%
Typical Thickness	50-100 microns (2-4 mils) dry equivalent to 111-222 microns (4.4-8.9 mils) wet
Theoretical Coverage	6 m ² /litre at 75 microns d.f.t and stated volume solids 241 sq.ft/US gallon at 3 mils d.f.t and stated volume solids
Practical Coverage	Allow appropriate loss factors
Method of Application	Airless Spray, Air Spray, Brush, Roller

Drying Time

Temperature	Touch Dry	Hard Dry	Overcoating Interval with recommended topcoats	
			Minimum	Maximum
5°C (41°F)	45 minutes	4 hours	24 hours	Extended ¹
15°C (59°F)	30 minutes	2.5 hours	10 hours	Extended ¹
25°C (77°F)	20 minutes	1.5 hours	4 hours	Extended ¹
40°C (104°F)	10 minutes	1 hour	1 hour	Extended ¹

¹ See International Protective Coatings Definitions and Abbreviations

REGULATORY DATA

Flash Point (Typical)	26°C (79°F)		
Product Weight	1.36 kg/l (11.3 lb/gal)		
VOC	4.05 lb/gal (486 g/l) 354 g/kg	EPA Method 24 EU Solvent Emissions Directive (Council Directive 1999/13/EC)	

See Product Characteristics section for further details

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SURFACE PREPARATION

All surfaces to be coated should be clean, dry and free from contamination. Prior to paint application all surfaces should be assessed and treated in accordance with ISO 8504:2000.

Oil or grease should be removed in accordance with SSPC-SP1 solvent cleaning.

Abrasive Blast Cleaning

Abrasive blast clean to Sa2½ (ISO 8501-1:2007) or SSPC-SP6.

Surface defects revealed by the blast cleaning process should be ground, filled, or treated in the appropriate manner.

Interprime 306 is suitable for application to blast cleaned surfaces which were initially to the above standard but have been allowed to deteriorate under good shop conditions for up to 7-10 days. The surface may deteriorate to Sa2 standard but must be free from loose powdery deposits.

Primed Surfaces

Interprime 306 can be applied over approved anti-corrosive primers. The primer surface should be dry and free from all contamination and Interprime 306 must be applied within the overcoating intervals specified (consult the relevant product data sheet).

Areas of breakdown, damage etc., should be prepared to the specified standard (e.g. Sa2½ (ISO 8501-1:2007) or SSPC-SP10 Abrasive Blasting, or SSPC-SP11, Power Tool Cleaning) and patch primed prior to the application of Interprime 306.

APPLICATION

Mixing	This material is a one component coating and should always be mixed thoroughly with a power agitator before application.		
Mix Ratio	Not applicable		
Airless Spray	Recommended	Tip Range 0.33-0.58 mm (13-23 thou) Total output fluid pressure at spray tip not less than 141 kg/cm ² (2005 p.s.i.)	
Air Spray (Pressure Pot)	Recommended	Gun Air Cap Fluid Tip	DeVilbiss MBC or JGA 704 or 765 E
Brush	Suitable - small areas only	Typically 50 microns (2.0 mils) can be achieved	
Roller	Suitable - small areas only	Typically 50 microns (2.0 mils) can be achieved	
Thinner	International GTA007	Do not thin more than allowed by local environmental legislation	
Cleaner	International GTA007		
Work Stoppages	Thoroughly flush all equipment with International GTA007. All unused material should be stored in tightly closed containers. Partially filled containers may show surface skinning and/or a viscosity increase of the material after storage. Material should be filtered prior to use.		
Clean Up	Clean all equipment immediately after use with International GTA007. It is good working practice to periodically flush out spray equipment during the course of the working day. Frequency of cleaning will depend upon amount sprayed, temperature and elapsed time, including any delays. All surplus materials and empty containers should be disposed of in accordance with appropriate regional regulations/legislation.		

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PRODUCT CHARACTERISTICS

Interprime 306 is designed to give good edge coverage in a one coat application, however, best results will be achieved by utilising a double spray pass technique on edges rather than attempting to achieve a single pass heavy application.

Maximum film build in one coat is best attained by airless spray. When applying by methods other than airless spray, the required film build is unlikely to be achieved. Application by air spray may require a multiple cross spray pattern to attain maximum film build. Low or high temperatures may require specific application techniques to achieve maximum film build.

In order to ensure good anti-corrosive performance, it is important to achieve a minimum system dry film thickness of 75 microns (3 mils). When applying Interprime 306 by brush or roller, it may be necessary to apply multiple coats to achieve the total specified system dry film thickness.

Surface temperature must always be a minimum of 3°C (5°F) above dew point. When applying Interprime 306 in confined spaces ensure adequate ventilation.

Interprime 306 is not designed for application to hand prepared steel, except for small touch-up areas.

Interprime 306 is not designed for continuous water immersion. Premature exposure to ponding water will cause a colour change, especially in dark colours.

Over-application of Interprime 306 will extend both the minimum overcoating periods and handling times, and may be detrimental to long term overcoating properties.

High dry film thickness can also retard through drying and lead to film defects on rapid application of cosmetic finishes.

This product is not intended for use in aggressive, corrosive environments, or on heavily pitted or contaminated steel. Where a durable cosmetic finish with good gloss and colour retention is required overcoat with recommended topcoats. Interprime 306 is suitable for use as a primer for the International range of acrylic intumescent products, in locations classed as no more corrosive than C3 (according to ISO 12944-2).

The maximum overcoating interval will be dependent upon the integrity of the exposed film. A film of 75 microns (3 mils) dry film thickness will normally be overcoatable after 6 months exposure provided it is adequately cleaned and any areas of mechanical damage repaired.

Interprime 306 is certified as M1 according to Spanish standards UNE 23.727-90 (Reaction to fire) and UNE 23721-90 (Radiation).

Note: VOC values are typical and are provided for guidance purpose only. These may be subject to variation depending on factors such as differences in colour and normal manufacturing tolerances.

SYSTEMS COMPATIBILITY

Interprime 306 is normally applied to blasted steel, however, the following prefabrication primers can also be used:

Interplate 180
Interplate 398

The following topcoats are recommended for Interprime 306:

Interchar 404	Interlac 645
Interchar 963	Interlac 658
Intercryl 700	Interlac 665

For other suitable primers/topcoats, consult International Protective Coatings.

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ADDITIONAL INFORMATION

Further information regarding industry standards, terms and abbreviations used in this data sheet can be found in the following documents available at www.international-pc.com:

- Definitions & Abbreviations
- Surface Preparation
- Paint Application
- Theoretical & Practical Coverage

Individual copies of these information sections are available upon request.

SAFETY PRECAUTIONS

This product is intended for use only by professional applicators in industrial situations in accordance with the advice given on this sheet, the Material Safety Data Sheet and the container(s), and should not be used without reference to the Material Safety Data Sheet (MSDS) which International Protective Coatings has provided to its customers.

All work involving the application and use of this product should be performed in compliance with all relevant national, Health, Safety & Environmental standards and regulations.

In the event welding or flame cutting is performed on metal coated with this product, dust and fumes will be emitted which will require the use of appropriate personal protective equipment and adequate local exhaust ventilation.

If in doubt regarding the suitability of use of this product, consult International Protective Coatings for further advice.

PACK SIZE	Unit Size	Vol	Pack
	20 litre	20 litre	20 litre
For availability of other pack sizes, contact International Protective Coatings.			
SHIPPING WEIGHT (TYPICAL)	Unit Size		
	20 litre	29 kg	
STORAGE	Shelf Life	24 months minimum at 25°C. Subject to re-inspection thereafter. Store in dry, shaded conditions away from sources of heat and ignition.	

Important Note

The information in this data sheet is not intended to be exhaustive; any person using the product for any purpose other than that specifically recommended in this data sheet without first obtaining written confirmation from us as to the suitability of the product for the intended purpose does so at their own risk. All advice given or statements made about the product (whether in this data sheet or otherwise) is correct to the best of our knowledge but we have no control over the quality or the condition of the substrate or the many factors affecting the use and application of the product. Therefore, unless we specifically agree in writing to do so, we do not accept any liability at all for the performance of the product or for (subject to the maximum extent permitted by law) any loss or damage arising out of the use of the product. We hereby disclaim any warranties or representations, express or implied, by operation of law or otherwise, including, without limitation, any implied warranty of merchantability or fitness for a particular purpose. All products supplied and technical advice given are subject to our Conditions of Sale. You should request a copy of this document and review it carefully. The information contained in this data sheet is liable to modification from time to time in the light of experience and our policy of continuous development. It is the user's responsibility to check with their local representative that this data sheet is current prior to using the product.

This Technical Data Sheet is available on our website at www.international-marine.com or www.international-pc.com, and should be the same as this document. Should there be any discrepancies between this document and the version of the Technical Data Sheet that appears on the website, then the version on the website will take precedence.

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