Interfine® 629

Acrylic

PRODUCT DESCRIPTION

A two pack high gloss acrylic finish designed to exhibit the following features;

Safer to use, no isocyanates.
Good gloss and colour rentention in severe environments.
Cures down to 2°C.
Recoatable, easy to maintain.
Fast drying, fast handling.

INTENDED USES

As a high performance topcoat for existing structures and new construction where a high gloss, weather resistant finish is required. Typical applications are (but not restricted to);

Commercial infrastructure and sporting arenas.
Tank exteriors.
Handrails.
General steelwork and equipment where aesthetic appearance is required.

PRACTICAL INFORMATION FOR INTERFINE 629

Colour	Wide range via the Chromascan system
Gloss Level	Full Gloss
Volume Solids	50%
Typical Thickness	60-75 microns (2.4-3 mils) dry equivalent to 120-150 microns (4.8-6 mils) wet
Theoretical Coverage	6.67 m²/litre at 75 microns d.f.t and stated volume solids 267 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

			Overcoating Interval with recommended topcoats	
Temperature	**Touch Dry**	**Hard Dry**	*Minimum*	*Maximum*
10°C (50°F)	3 hours	19 hours	19 hours	Extended[1]
25°C (77°F)	50 minutes	6 hours	6 hours	Extended[1]
40°C (104°F)	40 minutes	2 hours	2 hours	Extended[1]

[1] See International Protective Coatings Definitions and Abbreviations

REGULATORY DATA

Flash Point (Typical)	Part A 23°C (73°F); Part B 24°C (75°F); Mixed 23°C (73°F)
Product Weight	1.2 kg/l (10.0 lb/gal)
VOC	514 g/l UK - PG6/23(04), Appendix 3

See Product Characteristics section for further details

SURFACE PREPARATION

All surfaces to be coated should be clean, dry and free from contamination. Prior to 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.

Accumulated dirt and soluble salts must be removed by fresh water washing.

Interfine 629 should always be applied over a recommended anti-corrosive coating scheme. The primer surface should be dry and free from all contamination and Interfine 629 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-SP6, Abrasive Blasting, or SSPC-SP11, Power Tool Cleaning) and patch primed prior to the application of Interfine 629.

APPLICATION

Mixing

Material is supplied in two containers as a unit. Always mix a complete unit in the proportions supplied. Once the unit has been mixed it must be used within the working pot life specified.

(1) Agitate Base (Part A) with a power agitator.

(2) Combine entire contents of Curing Agent (Part B) with Base (Part A) and mix thoroughly with power agitator.

Mix Ratio

1 part(s) : 1 part(s) by volume

Working Pot Life

10°C (50°F)	25°C (77°F)	40°C (104°F)
10 hours	4 hours	2 hours

Airless Spray

Suitable

Tip Range 0.38-0.48 mm (15-19 thou)
Total output fluid pressure at spray tip not less than 106 kg/cm² (1507 p.s.i.)

Air Spray (Pressure Pot)

Suitable
Thin up to 20%

Gun DeVilbiss MBC or JGA
Air Cap 704 or 765
Fluid Tip E

Brush

Suitable

Roller

Suitable

Thinner

International GTA713

Cleaner

International GTA713

Work Stoppages

Do not allow material to remain in hoses, gun or spray equipment. Thoroughly flush all equipment with International GTA713. Once units of paint have been mixed they should not be resealed and it is advised that after prolonged stoppages work recommences with freshly mixed units.

Clean Up

Clean all equipment immediately after use with International GTA713. 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

Available in a wide range of colours produced via the Chromascan system.

Interfine 629 is indefinitely recoatable with itself provided the existing surface is clean, dry and free from contamination.

In hot or windy conditions thinner GTA713 must be used for spray reductions to improve flow out and reduce dry spray. In these conditions ensure full thickness is applied in one coat.

Care should be exercised to avoid application of dry film thickness in excess of 125µm.

Level of sheen and surface finish are dependent on application method. Avoid using a mixture of application methods whenever possible.

Avoid contact with alkaline materials.

SYSTEMS COMPATIBILITY

The following primers/intermediates are recommended for Interfine 629:

Intercure 200	Intercure 200HS
Intercure 420	Intergard 251
Intergard 2511	Intergard 345
Intergard 251HS	Intergard 269
Intergard 345	Intergard 475HS
Interprime 4198	Interplus 1180
Interzone 954	

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 Safety Data Sheet and the container(s), and should not be used without reference to the Safety Data Sheet (SDS).

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 AkzoNobel for further advice.

PACK SIZE

Unit Size	Part A		Part B	
	Vol	Pack	Vol	Pack
20 litre	10 litre	20 litre	10 litre	10 litre
5 US gal	2.5 US gal	5 US gal	2.5 US gal	3 US gal

For availability of other pack sizes, contact AkzoNobel.

SHIPPING WEIGHT (TYPICAL)

Unit Size	Part A	Part B
20 litre	15 kg	11 kg
5 US gal	31.3 lb	22.9 lb

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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