Interfine® 878

Acrylic Polysiloxane

PRODUCT DESCRIPTION

A high performance, two component, high solids finish which contains no free isocyanates, offers compliance to current VOC legislation, and affords extended lifetime to first maintenance when utilized as part of a high performance anti-corrosive system.
Interfine 878 offers superior gloss and color retention and provides significantly improved resistance to yellowing & chalking when compared to typical conventional topcoats including catalyzed acrylic, and polyurethane finishes.

INTENDED USES

Interfine 878 is a tough, hard wearing finish coat for application over properly primed surfaces, which exhibits good flexibility, abrasion resistance, and affords protection against spills and splashes of a range of chemicals such as acids, alkalis, solvents, and salt solutions. Suitable for application by spray and roller, in both factory new construction and site maintenance application situations, and is an ideal solution where legislation prevents the use of isocyanates, or restricts solvent emission levels.

For use in those market sectors where high standards of cosmetic appearance and aesthetics are a key requirement. These include high performance steel constructions such as sports stadia, bridges, offshore platforms, FPSO vessels, tank farms, chemical and petrochemical plants, pulp and paper mills, and the power industry, in addition to general industrial and commercial steelwork where aesthetics are important.

PRACTICAL INFORMATION FOR INTERFINE 878

Color	Wide range via the Chromascan® system
Gloss Level	High Gloss
Volume Solids	72%
Typical Thickness	2-3 mils (50-75 microns) dry equivalent to 2.8-4.2 mils (69-104 microns) wet
Theoretical Coverage	481 sq.ft/US gallon at 2.4 mils d.f.t and stated volume solids 12 m²/liter at 60 microns d.f.t and stated volume solids
Practical Coverage	Allow appropriate loss factors
Method of Application	Airless Spray, Air Spray, Roller

Drying Time

			Overcoating Interval with recommended topcoats	
Temperature	**Touch Dry**	**Hard Dry**	*Minimum*	*Maximum*
41°F (5°C)	6 hours	8 hours	8 hours	Extended[1]
59°F (15°C)	4.5 hours	6 hours	6 hours	Extended[1]
77°F (25°C)	3 hours	4 hours	4 hours	Extended[1]
104°F (40°C)	1.5 hours	2.5 hours	2.5 hours	Extended[1]

[1] See International Protective Coatings Definitions & Abbreviations
The drying times quoted have been determined at the quoted temperature and 50% relative humidity. Overcoating intervals for recommended primers and intermediates are dependent upon actual primer/intermediate used. Please see Systems Compatibility section.

REGULATORY DATA

Flash Point (Typical)	Part A 93°F (34°C); Part B 131°F (55°C); Mixed 95°F (35°C)	
Product Weight	11.2 lb/gal (1.34 kg/l)	
VOC	2.05 lb/gal (246 g/lt) 194 g/kg	EPA Method 24 EU Solvent Emissions Directive (Council Directive 2010/75/EC)

Coating hazard marker GB 30981.2-S-Pb≤90-C Qualified for GB 30981.2-2025

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 8504:2019.

Primed Surfaces

Interfine 878 should always be applied over a recommended anti-corrosive coating scheme. The primer surface should be dry and free from all contamination, and Interfine 878 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. SSPC-SP6 or Sa2½ (ISO 8501 -1:2007), Abrasive Blasting, or SSPC-SP11, Power Tool Cleaning) and patch primed prior to the application of Interfine 878.

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

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

Working Pot Life

41°F (5°C)	59°F (15°C)	77°F (25°C)	104°F (40°C)
3.5 hours	2.5 hours	2 hours	1.5 hours

Airless Spray	Recommended	Tip Range 11-17 thou (0.28-0.43 mm) Total output fluid pressure at spray tip not less than 2204 psi (155 kg/cm²)	
Air Spray (Pressure Pot)	Recommended	Gun Air Cap Fluid Tip	DeVilbiss MBC or JGA 704 or 765 E
Brush	Suitable - Small areas only	Typically 1.0-2.0 mils (25-50 microns) can be achieved	
Roller	Suitable	Typically 2.0-3.0 mils (50-75 microns) can be achieved	
Thinner	International GTA007	Do not thin more than allowed by local environmental legislation	
Cleaner	International GTA007	Choice of cleaner may be subject to local legislation. Please consult your local representative for specific advice.	

Work Stoppages

Do not allow material to remain in hoses, gun or spray equipment. Thoroughly flush all equipment with International GTA007. 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 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

The technology utilized in Interfine 878 is covered by patent (US 6,281,321 and EP 0 941290).

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

Best results in terms of gloss and appearance will always be obtained by conventional air spray application.

For brush and roller application, and in some colors, two coats of Interfine 878 may be required to give uniform coverage, especially when applying Interfine 878 over dark undercoats, and when using certain lead free bright colors such as yellows and oranges. Best practice is to use a color compatible intermediate or anti-corrosive coating under the Interfine 878.

This product must only be thinned using the recommended International thinners. The use of alternative thinners, particularly those containing alcohols and ketones, can severely inhibit the curing mechanism of the coating.

Pot life times must not be exceeded even though the material may be still liquid and appear useable. It is good working practice that application should commence with full unopened units of material. Due to the moisture sensitivity with partially filled units of the curing agent component, there is a danger of reaction with atmospheric moisture which could adversely affect the performance of the final coating film.

Surface temperature must always be a minimum of 5°F (3°C) above dew point.

When applying Interfine 878 in confined spaces, ensure adequate ventilation.

Care must be taken when spray applying multiple coats of Interfine 878 to ensure that a continuous wet film is applied to ensure a satisfactory coalescence occurs. Failure to do so may downgrade appearance and performance.

Interfine 878 will cure satisfactorily at relative humidities between 40% and 85%. Curing will be slower at lower humidities and faster at higher humidities.

Condensation occurring during or immediately after application may result in a matte finish and an inferior film.

When overcoating after weathering, or aging, ensure the coating is fully cleaned to remove all surface contamination such as oil, grease, salt crystals and traffic fumes, before application of a further coat of Interfine 878.

Premature exposure to ponding water will cause color change, especially in dark colors and at low temperatures.

This product is not recommended for use in continuous immersion conditions.

Where prolonged chemical or solvent splashing is likely to occur contact International Protective Coatings for information regarding suitability.

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 color and normal manufacturing tolerances.

Low molecular weight reactive additives, which will form part of the film during normal ambient cure conditions, will also affect VOC values determined using EPA Method 24.

SYSTEMS COMPATIBILITY

Interfine 878 can be applied over a limited range of intermediates.

Absolute maximum overcoating intervals with Interfine 878 are dependent upon the primer / intermediate. Relevant primer/intermediate product data sheet and Interfine 878 Recommended Working Procedures should be consulted prior to use.

Suitable intermediates are:

Intercure 200	Interseal 670HS
Intercure 200HS	Interzone 505
Intergard 475HS	Interzone 954
Interplus 356	

For other suitable primer/intermediates, 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
- Interfine 878 Application Guidelines

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 liter	16.67 liter	20 liter	3.33 liter	5 liter
5 US gal	4.17 US gal	5 US gal	0.83 US gal	1 US gal

For availability of other pack sizes, contact AkzoNobel.

SHIPPING WEIGHT (TYPICAL)

Unit Size	Part A	Part B
20 liter	25.4 kg	3.7 kg
5 US gal	54.7 lb	7.7 lb

STORAGE

Shelf Life: Part A 12 months minimum at 77°F (25°C).
Part B 6 months minimum at 77°F (25°C). Subject to re-inspection thereafter.
Store in dry, shaded conditions away from sources of heat and ignition.

Disclaimer

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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