Interplus® 356

Surface Tolerant Epoxy

PRODUCT DESCRIPTION

A low VOC, two component, internally flexibilized, high build, low temperature curing (down to 23°F, -5°C), surface tolerant epoxy primer. Metallic pigmented, with aluminium and lamellar micaceous iron oxide, for increased corrosion resistance.

INTENDED USES

A high performance maintenance coating for use on a wide variety of surfaces including hand or power tool cleaned rusty steel.

Specifically designed for use at low temperatures or where rapid overcoating is essential.

Ideal for use in conjunction with wet abrasive blasting and ultra high pressure water blasting.

Interplus 356 is particularly useful in the maintenance of offshore structures and other aggressive environments such as refineries, chemical plants, coastal structures, pulp and paper mills and bridges when dry abrasive blasting is not possible.

PRACTICAL INFORMATION FOR INTERPLUS 356

Color	Aluminum Gray
Gloss Level	Matte
Volume Solids	70%
Typical Thickness	3-5 mils (75-125 microns) dry equivalent to 4.3-7.2 mils (107-179 microns) wet
Theoretical Coverage	225 sq.ft/US gallon at 5 mils d.f.t and stated volume solids 5.60 m²/liter at 125 microns d.f.t and stated volume solids
Practical Coverage	Allow appropriate loss factors
Method of Application	Airless Spray, Air Spray - blasted steel Brush, Roller - hand or power tool prepared steel

Drying Time

			Overcoating Interval with recommended topcoats	
Temperature	**Touch Dry**	**Hard Dry**	*Minimum*	*Maximum*
41°F (5°C)	8 hours	18 hours	10 hours	Extended[1]
59°F (15°C)	2 hours	10 hours	6 hours	Extended[1]
77°F (25°C)	90 minutes	6 hours	4 hours	Extended[1]
104°F (40°C)	45 minutes	3 hours	2 hours	Extended[1]

[1] See International Protective Coatings Definitions & Abbreviations

REGULATORY DATA

Flash Point (Typical)	Part A 111°F (44°C); Part B 81°F (27°C); Mixed 104°F (40°C)	
Product Weight	12.6 lb/gal (1.51 kg/l)	
VOC	2.54 lb/gal (305 g/lt) 198 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

The performance of this product will depend upon the degree of surface preparation. The surface 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.

Accumulated dirt and soluble salts must be removed. Dry bristle brushing will normally be adequate for accumulated dirt. Soluble salts should be removed by fresh water washing.

Abrasive Blast Cleaning

Interplus 356 may be applied to a surface abrasive blast cleaned to a minimum Sa1 (ISO 8501-1:2007) C or D grade rusting, or SSPC SP7.

Hand or Power Tool Preparation

Hand or power tool clean to a minimum St2 (ISO 8501-1:2007) or SSPC-SP2.

Note, all scale must be removed and areas which cannot be prepared adequately by chipping or needle gun should be spot blasted to a minimum standard of Sa2 (ISO 8501-1:2007) or SSPC-SP6 Typically this would apply to C or D grade rusting in this standard.

On steel surfaces operating at in-service temperatures up to 212°F (100°C) cleaning to a minimum St3 (ISO 8501-1:2007) or SSPC-SP3 is required for optimum performance.

Ultra High Pressure Hydroblasting/Abrasive Wet Blasting

May be applied to surfaces prepared to Sa2½ (ISO 8501-1:2007) or SSPC-SP6 which have flash rusted to no worse than Grade HB2½M (refer to International Hydroblasting Standards) or Grade SB2½M (refer to International Slurry Blasting Standards). It is also possible to apply to damp surfaces in some circumstances. Further information is available from International Protective Coatings.

Aged Coatings

Interplus 356 is suitable for overlap onto most aged coating systems. Loose or flaking coatings should be removed back to a firm edge. Glossy epoxies and polyurethanes may require abrasion

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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

3 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)
8 hours	4 hours	2 hours	45 minutes

Airless Spray

Recommended

Tip Range 19-23 thou (0.48-0.58 mm)
Total output fluid pressure at spray tip not less than 3000 psi (211 kg/cm²)

Air Spray (Pressure Pot)

Recommended

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

Brush

Recommended

Typically 3.0-4.0 mils (75-100 microns) can be achieved

Roller

Recommended

Typically 2.0-3.0 mils (50-75 microns) can be achieved

Thinner

International GTA220 (or International GTA415)

May be necessary at low temperatures, see Product Characteristics. Do not thin more than allowed by local environmental legislation

Cleaner

International GTA822 (or International GTA415)

Work Stoppages

Do not allow material to remain in hoses, gun or spray equipment. Thoroughly flush all equipment with International GTA822. 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 GTA822. 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

In order to ensure good anti-corrosive performance, it is important to achieve a minimum system dry film thickness of 8 mils (200 microns) by application of multi-coats over hand prepared steel.

Apply in good climatic conditions. The temperature of the surface to be coated must be at least 5°F (3°C) above the dew point. When applying Interplus 356 by brush or roller, it may be necessary to apply multiple coats to achieve the total specified system dry film thickness.

Wet Blasted (Damp Surfaces)

If salt water is used in the wet blast process, the resulting surface must be thoroughly washed with fresh water before application of Interplus 356. With freshly blasted surfaces a slight degree of flash rusting is allowable, and is preferable to the surface being too wet. Puddles, ponding and accumulations of water must be removed.

To ensure good aged overcoating of Interplus 356 by other materials the surface must be clean, dry and free from contamination, particularly if the surface profile is rough due to the presence of micaceous iron oxide.

Low Temperature Curing

Interplus 356 is capable of curing at temperatures below 32°F (0°C). However, this product should not be applied at temperatures below 32°F (0°C) where there is a possibility of ice formation on the substrate.

			Minimum overcoating interval with recommended topcoats	
Temperature	Touch Dry	Hard Dry	*Minimum*	*Maximum*
23°F (-5°C)	24 hours	60 hours	60 hours	Extended*
32°F (0°C)	16 hours	36 hours	36 hours	Extended*

*See International Protective Coatings Definitions & Abbreviations

Touch dry times shown above are actual drying times due to chemical cure, rather than physical set due to solidification of the coating film at temperatures below 32°F (0°C).

At low temperatures, it may be necessary to thin Interplus 356 to enable airless spray application to be performed. Normally 5% thinning (by volume) with International GTA220 will be satisfactory for this purpose.

Interplus 356 is suitable for protection of steel operating at continuous dry temperatures of up to 302°F (150°C), with intermittent surges up to 392°F (200°C). Interplus 356 is not designed for continuous water immersion.

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.

SYSTEMS COMPATIBILITY

Interplus 356 will generally be applied to bare steel but is fully compatible for overlap onto most aged coatings, in addition to touch up repair of the following primers:

Intercure 200	Interzinc 12
Intergard 251	Interzinc 22
Intergard 269	Interzinc 42
InterH2O 280	Interzinc 52
Interseal 670HS	Interzinc 315

Recommended topcoats/intermediates are:

Intercure 420	Interplus 770
Interfine 629HS	Interplus 880
Interfine 878	Interseal 670HS
Interfine 979	Interthane 990
Interfine 1080	Interthane 990E
Intergard 475HS	Interzone 505
Intergard 740	Interzone 954
Interplus 356	

It should be noted that Interplus 356 is not suitable for overcoating with thin films of alkyd, chlorinated rubber, vinyl or acrylic finishes.

For other suitable topcoats/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

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	15 liter	20 liter	5 liter	5 liter
5 US gal	3 US gal	5 US gal	1 US gal	1 US gal

For availability of other pack sizes, contact AkzoNobel.

SHIPPING WEIGHT (TYPICAL)

Unit Size	Part A	Part B
20 liter	27.7 kg	5.3 kg
5 US gal	56.2 lb	8.8 lb

STORAGE

Shelf Life	18 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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