Interthane® 1070

Polyurethane

PRODUCT DESCRIPTION

A two component, high build, acrylic polyurethane primer/finish, containing zinc phosphate anti-corrosive pigmentation, providing excellent durability and long-term recoatability.

INTENDED USES

Suitable for use as a one-coat primer/finish for direct-to-metal applications.

Interthane 1070 provides a combination of anti-corrosive barrier protection, durability and cosmetic finish.

Ideal for use in moderately corrosive environments, for example, C3 category, as defined in ISO 12944-2:1998.

PRACTICAL INFORMATION FOR INTERTHANE 1070

Colour	Limited range
Gloss Level	Semi Gloss
Volume Solids	56% ± 2% (depends on colour)
Typical Thickness	150-200 microns (6-8 mils) dry equivalent to 268-357 microns (10.7-14.3 mils) wet
Theoretical Coverage	2.80 m²/litre at 200 microns d.f.t and stated volume solids 112 sq.ft/US gallon at 8 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*
5°C (41°F)	90 minutes	30 hours	30 hours	Extended[1]
15°C (59°F)	75 minutes	16 hours	16 hours	Extended[1]
25°C (77°F)	60 minutes	5 hours	5 hours	Extended[1]
40°C (104°F)	45 minutes	2.5 hours	2.5 hours	Extended[1]

[1] See International Protective Coatings Definitions and Abbreviations

REGULATORY DATA

Flash Point (Typical)	Part A 35°C (95°F); Part B 50°C (122°F); Mixed 35°C (95°F)	
Product Weight	1.41 kg/l (11.8 lb/gal)	
VOC	3.14 lb/gal (377 g/lt)	EPA Method 24
	275 g/kg	EU Solvent Emissions Directive (Council Directive 2010/75/EU)
	367 g/lt	Chinese National Standard GB23985

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

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.

Abrasive Blast Cleaning

Abrasive blast clean to a minimum of Sa2½ (ISO 8501-1:2007) or SSPC-SP6. If oxidation has occurred between blasting and application of Interthane 1070 the surface should be re-blasted to the specified visual standard. Surface defects revealed by the blast cleaning process should be ground, filled, or treated in the appropriate manner.

A surface profile of 50 microns (2 mils) is recommended.

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	7 part(s) : 1 part(s) by volume		
Working Pot Life	5°C (41°F) 7 hours	15°C (59°F) 3.5 hours	25°C (77°F) 2 hours	40°C (104°F) 45 minutes
Airless Spray	Recommended	Tip Range 0.43-0.58 mm (17-23 thou) Total output fluid pressure at spray tip not less than 155 kg/cm² (2204 p.s.i.)	
Air Spray (Pressure Pot)	Recommended	Gun Air Cap Fluid Tip	DeVilbiss MBC or JGA 704 or 765 E
Air Spray (Conventional)	Suitable	Use suitable proprietary equipment	
Brush	Suitable	Typically 50-75 microns (2.0-3.0 mils) can be achieved	
Roller	Suitable	Typically 50-75 microns (2.0-3.0 mils) can be achieved	
Thinner	International GTA713 (or International GTA056)	Thinning is not normally required. Consult the local representative for advice during application in extreme conditions. Do not thin more than allowed by local environmental legislation.	
Cleaner	International GTA713 (or International GTA056)		
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.		

PRODUCT CHARACTERISTICS

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

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.

When applying Interthane 1070 by brush or roller, it may be necessary to apply multiple coats to achieve the total specified system dry film thickness.

Applicators should be aware that the ability to apply Interthane 1070 in one coat will be affected by the temperature of the substrate. At higher steel temperatures, lower film builds and thinner coats are likely to be achieved.

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

Do not apply at steel temperatures below 5°C (41°F).

When applying Interthane 1070 in confined spaces ensure adequate ventilation.

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

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

Absolute measured adhesion of topcoats to aged Interthane 1070 is less than that to fresh material, however, it is adequate for the specified end use.

This product is not recommended for use in immersion conditions. When severe 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 colour 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

Interthane 1070 has been developed as a direct-to-metal coating.

Suitable topcoats are:

Interthane 990
Interthane 1070

For further advice on system compatibility contact International Protective Coatings.

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.

Warning: Contains isocyanate. Wear air-fed hood for spray application.

PACK SIZE	Unit Size	Part A		Part B	
		Vol	Pack	Vol	Pack
	20 litre	17.5 litre	20 litre	2.5 litre	3.7 litre
	5 US gal	4.38 US gal	5 US gal	0.63 US gal	1 US gal
	For availability of other pack sizes, contact AkzoNobel.				

SHIPPING WEIGHT (TYPICAL)	Unit Size	Part A	Part B
	20 litre	27 kg	3.1 kg
	5 US gal	55.1 lb	6.4 lb

STORAGE	Shelf Life	24 months (Part A) and 18 months (Part B) at 25°C (77°F). 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.

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