

PRODUCT DESCRIPTION

A single component, fast drying, gloss enamel finish.

INTENDED USES

Formulated as the finish coat of a two coat, quick drying alkyd system for airless spray application to primed steel in fabrication works or at site.

PRACTICAL INFORMATION FOR INTERLAC 645

Colour	Wide range via the Chromascan system
Gloss Level	Gloss
Volume Solids	41%
Typical Thickness	50 microns (2 mils) dry equivalent to 122 microns (4.9 mils) wet
Theoretical Coverage	8.20 m ² /litre at 50 microns d.f.t and stated volume solids 329 sq.ft/US gallon at 2 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	
			<i>Minimum</i>	<i>Maximum</i>
5°C (41°F)	30 minutes	2 hours	4 hours	Extended ¹
15°C (59°F)	25 minutes	105 minutes	4 hours	Extended ¹
25°C (77°F)	20 minutes	90 minutes	4 hours	Extended ¹
40°C (104°F)	10 minutes	60 minutes	2 hours	Extended ¹

¹ See International Protective Coatings Definitions and Abbreviations

REGULATORY DATA

Flash Point	>23°C (>73°F)	
Product Weight	1.21 kg/l (10.1 lb/gal)	
VOC	445 g/kg	EU Solvent Emissions Directive (Council Directive 1999/13/EC)

See Product Characteristics section for further details

**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.

Primed Surfaces

Interlac 645 should always be applied over a recommended anti-corrosive coating scheme. The primer surface should be dry and free from all contamination and Interlac 645 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 Interlac 645.

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 0.38-0.45 mm (15-18 thou) Total output fluid pressure at spray tip not less than 176 kg/cm ² (2503 p.s.i.)	
Air Spray (Pressure Pot)	Recommended	Gun	DeVilbiss MBC or JGA
		Air Cap	704 or 765
		Fluid Tip	E
Brush	Suitable - Small touch-up areas only	Typically 25-50 microns (1.0-2.0 mils) can be achieved	
Roller	Suitable - Small touch-up areas only	Typically 25-50 microns (1.0-2.0 mils) can be achieved	
Thinner	International GTA007	Do not thin more than allowed by local environmental legislation	
Cleaner	International GTA007		
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	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.		

**PRODUCT
CHARACTERISTICS**

When applying Interlac 645 in confined spaces ensure adequate ventilation.

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

This product is not intended for use in aggressive, corrosive environments, or on heavily pitted or contaminated steel.

Interlac 645 is not designed for continuous water immersion.

Interlac 645 is not suitable for exposure to acid or alkaline environments.

Avoid over-application as this will greatly increase drying and handling times and may affect long term film performance. Premature exposure to ponding water will cause a colour change, especially in dark colours.

Interlac 645 is recommended as an alternative for brush and roller application methods.

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**

The following primers are recommended for Interlac 645:

Interprime 205

Interprime 306

Interprime 466

For other suitable primers, consult 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 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	Unit Size		
	20 litre		26 kg
STORAGE	Shelf Life	24 months minimum 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 International Paint representative that this data sheet is current prior to using the product.

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