

# Interthane 80HS

Polyurethane

## Product Description

Interthane 80HS is a high performance maintenance coating.  
 High solids, high build, fully recoatable.  
 Excellent brush and roller application  
 Airless application to 125 microns in one coat.  
 Eliminates need for multiple coats.  
 Excellent resistance to corrosive industrial or coastal environments.  
 May be applied directly to aged coatings including alkyds and epoxies.

## Intended Uses

Interthane 80HS has been specifically designed for roller or brush application. This allows the application of a polyurethane coating whilst greatly reducing the health risks arising from isocyanates in spray mist form. Interthane 80HS provides superior gloss and colour retention even in severe industrial and coastal environments and is the ideal maintenance coating for:

High profile shopping and entertainment centres, sports complexes and arenas.  
 Bridges, structural steel, roofing and storage tanks.  
 Food and dairy processing plants.

## Practical Information for Interthane 80 HS

<b>Colour</b>	Wide range of colours available via the Chromascan System.			
<b>Gloss Level</b>	High Gloss			
<b>Volume Solids</b>	83%			
<b>Typical Thickness</b>	100-150 microns dry equivalent to 120-180 microns wet			
<b>Theoretical Coverage</b>	6.64 m <sup>2</sup> /litre at 125 microns d.f.t and stated volume solids			
<b>Practical Coverage</b>	Allow appropriate loss factors			
<b>Method of Application</b>	Brush, Roller, Power roller, Air Spray and Airless spray			
<b>Drying Time</b>	Overcoating Interval with Interthane 80HS by Self			
Temperature	Touch Dry	Hard Dry	<i>Minimum</i>	<i>Maximum</i>
10°C (50°F)	6 hours	24 hours	24 hours	Extended*
15°C (59°F)	6 hours	22 hours	22 hours	Extended*
25°C (77°F)	5 hours	18 hours	18 hours	Extended*
40°C (104°F)	2 hours	7 hours	7 hours	Extended*

\* See International Protective Coatings Definitions & Abbreviations

## Regulatory Data

<b>Flash Point</b>	Base (Part A) 13°C	C/A (Part B) 47°C	Mixed 27°C
<b>Product Weight</b>	1.33kg/l (White)		
<b>VOC</b>	215 g/l		

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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 8504:1992.

### Primed Surfaces

Interthane 80HS should always be applied over a recommended anti-corrosive coating scheme. The primer surface should be dry and free from all contamination, and Interthane 80HS 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 8501-1:1988), SSPC-SP6, Abrasive Blasting, or SSPC-SP11, Hand/Power Cleaning) and patch primed prior to the application of Interthane 80HS.

### Previously Painted Surfaces

Interthane 80HS is suitable for overcoating most tightly adherent aged coatings. Loose or flaking coatings should be removed back to a firm edge. Glossy finishes may require light abrasion to provide a physical "key". All remaining coating must be tested to ensure adequate adhesion. To ensure compatibility, application and evaluation of a test patch is required.

### Concrete

Interthane 80HS is not designed for application direct to concrete substrates, contact International Protective Coatings for details of a suitable epoxy primer/sealer.

## Application

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<b>Mixing</b>	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.			
<b>Mix Ratio</b>	4 parts : 1 part by volume			
<b>Working Pot Life</b>	5°C (41°F) 3 hours	15°C (59°F) 2.5 hours	25°C (77°F) 2 hours	40°C (104°F) 1 hour
<b>Airless Spray</b>	Suitable	- Tip range 0.38-0.58 mm (15-23 thou) - Total output fluid pressure at spray tip not less than 176 kg/cm <sup>2</sup> (2,500 p.s.i.)		
<b>Air Spray (Pressure Pot)</b>	Suitable	Gun Air Cap Fluid Tip	DeVilbiss MBC or JGA 704 or 765 E	
<b>Brush</b>	Suitable	Typically 100 microns WFT can be achieved		
<b>Roller</b>	Suitable	Typically 100 microns WFT can be achieved		
<b>Thinner</b>	International GTA713	Do not thin more than allowed by local environmental legislation. Refer to Product Characteristics.		
<b>Cleaner</b>	International GTA713			
<b>Work Stoppages</b>	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 recommence with freshly mixed units.			
<b>Clean Up</b>	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

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The maximum recoat time window for Interthane 80HS with itself is indefinite provided the film is sound, and intact. 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 Interthane 80HS.

Maximum film build in one coat is best attained by airless spray. When applying Interthane 80HS by brush or roller, it may be necessary to apply multiple coats to achieve the total specified system dry film thickness.

This product must only be thinned using specified thinners. The use of alternative thinners can severely inhibit the curing mechanism of the coating and film durability.

When thinning Interthane 80HS ensure that base and curing agent are mixed thoroughly before adding thinner. Addition of thinner before curing agent has been mixed in may result in surface defects such as pin-holing and "fish-eye".

When applying Interthane 80HS 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.

Interthane 80HS may yellow slightly when light colours are used for internal applications.

If subsequently exposed to sunlight this yellowing will disappear.

This product will not cure adequately below 5°C or at humidities above 85%. For maximum performance ambient curing temperatures should be above 10°C. Consult International Protective Coatings for details.

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

Part B is extremely sensitive to moisture. Keep tightly sealed and under cover when not in use. Use moisture traps in all lines.

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.

## Systems Compatibility

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The following primers are recommended for Interthane 80HS:

Intercure 200  
Intercure 420  
Intergard 251  
Intergard 475 HS  
Interplus 356  
Interseal 670 HS

Do not apply direct to zinc rich coatings

For other suitable primers/topcoats, please 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 sections of the International Protective Coatings data manual:

- 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.

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

<b>Pack Size</b>	20 litre unit	Base Curing Agent	16 litres in a 20 litre container 4 litres in a 4 litre container
	4 litre unit	Base Curing Agent	3.2 litres in a 4 litre steel container 0.8 litres in a 1 litre steel container
For availability of other pack sizes contact International Protective Coatings			
<b>Shipping Weight</b>	U.N. Shipping No. 1263		
	20 litre unit	24.1kg Base (Part A) 5.5kg Curing Agent (Part B)	
	4 litre unit	4.8kg Base (Part A) 1.1kg Curing Agent (Part B)	
<b>Storage</b>	Shelf Life	12 months minimum at 25°C (77°F). Subject to re-inspection thereafter. Store in dry, shaded conditions away from sources of heat and ignition.	

## Disclaimer

*The information given in this sheet is not intended to be exhaustive and any person using the product for any purpose other than that specifically recommended in this sheet without first obtaining written confirmation from us as to the suitability of the product for the intended purpose does so at his own risk. Any warranty, if given, or specific Terms & Conditions of Sale are contained in International's Terms & Conditions of Sale, a copy of which can be obtained on request. Whilst we endeavour to ensure that all advice we give about the product (whether in this sheet or otherwise) is correct we have no control over either the quality or 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 whatsoever or howsoever arising for the performance of the product or for any loss or damage (other than death or personal injury resulting from our negligence) arising out of the use of the product. The information contained in this sheet is liable to modification from time to time in the light of experience and our policy of continuous product development.*

*It is the user's responsibility to check that this sheet is current prior to using the product. Issue date: 13/03/2002*

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