

Intercryl 853

Acrylic

Product Description

A heavy duty water borne acrylic coating
 Excellent weather resistance
 Outstanding gloss and colour retention over extended periods

Intended Uses

Primarily designed as a durable finish coat for use over water borne primers and intermediates where colour and gloss retention are important.
 Can also be used over some solvent based primers and intermediates.
 For exposure in a wide variety of environments, including offshore structures, bridges, refineries, petrochemical and chemical plants.
 Suitable for use in both new construction and maintenance applications

Practical Information for Intercryl 853

Colour	Limited pastel range			
Gloss Level	Gloss			
Volume Solids	41%			
Typical Thickness	25 microns dry equivalent to 61 microns wet			
Theoretical Coverage	16.4 m ² /litre at 25 microns 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▲	<i>Minimum</i>	<i>Maximum</i>
10°C (50°F)	120 minutes	36 hours	18 hours	Extended
15°C (59°F)	105 minutes	26 hours	12 hours	Extended
25°C (77°F)	90 minutes	12 hours	7 hours	Extended
40°C (104°F)	30 minutes	6 hours	5 hours	Extended

▲ Drying times are dependent upon ambient conditions. The figures quoted above have been determined at the quoted temperature and 60% relative humidity.

Regulatory Data

Flash Point	>65°C
VOC	83 g/l (Calculated) 185 g/l (Water reduced)

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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.

Oil or grease should be removed in accordance with SSPC-SP1 solvent cleaning.

Strict adherence to all cleanliness standards is essential for application of water based coatings.

Primed Surfaces

Intercryl 853 should always be applied over a recommended anti-corrosive coating scheme. The primer surface should be dry and free from all contamination, and Intercryl 853 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) or SSPC-SP6, Abrasive Blasting, or SSPC-SP11, Power Tool Cleaning) and patch primed prior to the application of Intercryl 853.

Concrete and Cement

Concrete should be cured for a minimum of 28 days prior to coating and Cement should be cured for a minimum of 14 days prior to coating. The moisture content of the concrete should be below 6%. All surfaces should be clean, dry and free from curing compounds, release agents, trowelling compounds, surface hardeners, efflorescence, grease, oil, dirt, old coatings and loose or disintegrating concrete.

All poured and pre-cast concrete must also be swept blasted (preferred) or acid etched to remove laitence. Large cracks should be filled with a suitable filler. When coating new tilt formed concrete, an epoxy sealer must be employed. When coating new cement thin the first coat up to 15% with fresh clean water

Galvanised

Degrease to SSPC-SP1 and remove any white zinc corrosion products by hand abrasion cleaning.

Weathered galvanised steel should have areas of red rust wire brushed to remove loose rust and spot primed with Interzinc 52 or Interplus 356 and degreased as above.

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		
Working Pot Life	Not applicable		
Airless Spray	Recommended	- Tip range 0.38-0.53 mm (15-21 thou) - Total output fluid pressure at spray tip not less than 126 kg/cm ² (1,800 p.s.i.)	
Air Spray (Pressure Pot)	Recommended	Gun	DeVilbiss MBC or JGA
		Air Cap	704 or 765
		Fluid Tip	E
Brush	Suitable for small areas	Typically 50-75 microns wft can be achieved	
Roller	Recommended	Typically 50-75 microns wft can be achieved	
Thinner	Clean water		
Cleaner	International GTA991		
Work Stoppages	Thoroughly flush all equipment with International GTA991. 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.		
Clean Up	Clean all equipment immediately after use with International GTA991. It is good working practice to periodically flush out spray equipment during the course of the working day. Frequency should 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

Apply by air or airless spray. Thoroughly flush equipment with International GTA991 thinner, or industrial alcohol, followed by water prior to use. To obtain maximum edge protection and film build, airless or air spray application is recommended.

Application by other methods, e.g. brush or roller, may require more than one coat.

With all water borne coatings careful control of application conditions is required to ensure good long term performance. International Protective Coatings have available a set of working procedures relating to the application of water borne paints which are available on request.

The following basic parameters must be adhered to:

Intercryl 853 must be protected from freezing at all times during storage.

The minimum steel temperature for application must be above 10°C, and be at least 3°C above dew point.

The relative humidity should be lower than 70% otherwise drying and overcoating times will be severely extended.

Good airflow is essential around the object being painted [minimum air speed 0.1m/sec].

Small, localised areas which are difficult to ventilate should be brush applied to prevent over-application.

Application below the minimum film forming temperature (M.F.F.T.) of the coating and/or poor ventilation will result in poor film coalescence and will result in a powdery cracked film which will require removal and re-application.

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

For brush and roller application, and in some colours, two coats of Intercryl 853 may be required to give uniform coverage.

Intercryl 853 must be fully hardened before being exposed to ponding water otherwise adhesion loss can occur.

Although Intercryl 853 is slightly thermoplastic above 50°C the polymer system is stable to continuous temperatures of 150°C with intermittent temperatures of 200°C.

Systems Compatibility

This product is primarily designed for use as a finish over water based priming systems such as:

Intergard 270
Intergard 401
Interprime 371
Interzinc 280

However, it is also suitable for application to a number of solvent-based products.

Intercure 200	Interseal 670 HS
Intercure 420	Interseal 2020
Intergard 251	Interzinc 12 (a mist coat may be required)*
Intergard 269	Interzinc 22 (a mist coat may be required)*
Intergard 475	Interzinc 42
Intergard 475 HS	Interzinc 52
Interprime 198	Interzinc 315

For other suitable primers/topcoats, consult International Protective Coatings.

* See relevant product data sheet for details.

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Acrylic

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.

Pack Size	20 litre unit	20 litres in a 20 litre steel container
	4 litre unit	4 litres in a 4 litre container
For availability of other pack sizes contact International Protective Coatings		
Shipping Weight	U.N. Shipping No. 1263	
	20 litre unit	27.1 kg
	4 litre unit	5.4 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. Protect from freezing at all times during storage.

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: 26/06/2001

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