

**PRODUCT DESCRIPTION**

Intercure 4500 is a low VOC, high solids, rapid cure primer/finish, offering excellent anticorrosive protection and long term aesthetic durability in moderately corrosive environments (ISO 12944-2 C3). Based upon innovative polyaspartic resin technology, Intercure 4500 is designed to be applied as a single coat direct-to-metal using standard application equipment.

In replacing alternative two coat systems for C3 environments, Intercure 4500 offers corrosion protection and aesthetic performance in a single coat. Its rapid cure characteristics (even at low temperatures) and single coat application help optimise application time and reduce labour costs.

**INTENDED USES**

Low temperature rapid cure and early hardness development make Intercure 4500 ideal for fabrication shops looking to reduce heating costs and improve productivity, or for facilities located in colder climates. Intercure 4500 can offer significant benefits to OEM manufacturers where production and process efficiency are of major importance.

**PRACTICAL INFORMATION FOR INTERCURE 4500**

<b>Colour</b>	Limited colour range available			
<b>Gloss Level</b>	Semi-gloss			
<b>Volume Solids</b>	77% ± 2%			
<b>Typical Thickness</b>	150-200 microns (6-8 mils) dry equivalent to 195-260 microns (7.8-10.4 mils) wet			
<b>Theoretical Coverage</b>	4.40 m <sup>2</sup> /litre at 175 microns d.f.t and stated volume solids 176 sq.ft/US gallon at 7 mils d.f.t and stated volume solids			
<b>Practical Coverage</b>	Allow appropriate loss factors			
<b>Method of Application</b>	Airless Spray, Air Spray			
<b>Drying Time</b>	Overcoating interval with self			
<b>Temperature</b>	<b>Touch Dry</b>	<b>Hard Dry</b>	<i>Minimum</i>	<i>Maximum</i>
5°C (41°F)	60 minutes	3.5 hours <sup>1</sup>	3.5 hours	12 months
15°C (59°F)	45 minutes	2.5 hours <sup>1</sup>	2.5 hours	12 months
25°C (77°F)	30 minutes	2 hours <sup>1</sup>	2 hours	12 months
40°C (104°F)	15 minutes	1.5 hours <sup>1</sup>	1.5 hours	12 months

<sup>1</sup> The drying times quoted have been determined at the quoted temperature and 50% relative humidity.

**REGULATORY DATA**

<b>Flash Point</b>	Part A 50°C (122°F); Part B 158°C (316°F); Mixed 54°C (129°F)	
<b>Product Weight</b>	1.50 kg/l (12.5 lb/gal)	
<b>VOC</b>	1.87 lb/gal (225 g/l)	EPA Method 24

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.

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

**Steel Substrates**

Abrasive blast clean to Sa2½ (ISO 8501-1:2007) or SSPC-SP6. If oxidation has occurred between blasting and application of Intercure 4500, the surface should be reblasted to the specified visual standard.

Surface defects revealed by the blast cleaning process should be ground, filled, or treated in the appropriate manner.

A sharp, angular surface profile of 50-75 microns (2-3 mils) is recommended.

Areas of breakdown, damage etc., should be prepared to the specified standard (e.g. Sa2½ (ISO 8501-1:2007), or SSPC SP6, abrasive blasting), prior to the application of Intercure 4500.

**APPLICATION**

<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 part(s) : 1 part(s) by volume		
<b>Working Pot Life</b>	5°C (41°F) 3 hours	15°C (59°F) 2 hours	25°C (77°F) 40°C (104°F) 1 hour 45 minutes
<b>Airless Spray</b>	Recommended	Tip Range 0.38-0.48 mm (15-19 thou) Total output fluid pressure at spray tip not less than 176 kg/cm <sup>2</sup> (2503 p.s.i.)	
<b>Air Spray (Pressure Pot)</b>	Recommended	Gun Air Cap Fluid Tip	DeVilbiss MBC or JGA 704 or 765 E
<b>Brush</b>	Suitable - Touch up and small areas only	Typically 3.0-5.0 mils (75-125 microns) can be achieved	
<b>Roller</b>	Suitable - Touch up and small areas only		
<b>Thinner</b>	International GTA713 (or GTA056)	Do not thin more than allowed by local environmental legislation. Do not use alternative thinners.	
<b>Cleaner</b>	International GTA713 (or GTA056)	Do not use alternative cleaners.	
<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 recommences 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.		

**PRODUCT  
CHARACTERISTICS**

The detailed Intercure 4500 Application Guidelines should be consulted prior to use.

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 Intercure 4500 by brush or roller, it may be necessary to apply multiple coats to achieve the total specified system dry film thickness.

Apply in good climatic conditions. The temperature of the surface to be coated must be at least 3°C (5°F) above the dew point.

Application at excessively high relative humidity, or under conditions where condensation is likely to occur, may result in immediate or premature loss of gloss. It is recommended that relative humidity should not exceed 85% during application and cure. Application at humidities greater than 50% may result in faster drying times.

Care should be exercised to avoid application in excess of 350 microns (14 mils) dry film thickness.

Higher film thicknesses than recommended will result in higher gloss appearance.

When applying Intercure 4500 in confined spaces ensure adequate ventilation.

As with other fast dry coating systems care should be taken to prevent overspray contamination of previously coated work pieces.

Intercure 4500 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 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**

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Intercure 4500 has been developed as a direct-to-metal coating. Intercure 4500 is not normally topcoated with products other than itself.

**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](http://www.international-pc.com):

- Definitions & Abbreviations
- Surface Preparation
- Paint Application
- Theoretical & Practical Coverage
- Intercure 4500 Application Guidelines

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.**

PACK SIZE	Unit Size	Part A		Part B	
		Vol	Pack	Vol	Pack
	20 litre	16 litre	20 litre	4 litre	5 litre
	5 US gal	4 US gal	5 US gal	1 US gal	1 US gal
For availability of other pack sizes, contact International Protective Coatings.					
SHIPPING WEIGHT	Unit Size	Part A		Part B	
	20 litre	26 kg		5.1 kg	
	5 US gal	57.1 lb		10.6 lb	
STORAGE	Shelf Life	12 months 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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