Interthane® 329
Polyurethane

PRODUCT DESCRIPTION

A two component, high build, acrylic polyurethane primer/finish providing anti-corrosion barrier protection and long term recoatability.

INTENDED USES

Suitable for use in both new construction and as a maintenance finish which can be used in a wide variety of environments including offshore structures, chemical and petrochemical plants, bridges, pulp and paper mills, and in the power industry.

Particularly designed for use in areas where a high gloss is either not desired or where a semi-gloss is a preferred option.

Provides a versatile option where overcoating of intermediates in one coat is not possible using conventional high gloss polyurethane finishes.

PRACTICAL INFORMATION FOR INTERTHANE 329

Colour	Wide range via the Chromascan system
Gloss Level	Semi Gloss
Volume Solids	60%
Typical Thickness	100-150 microns (4-6 mils) dry equivalent to 167-250 microns (6.7-10 mils) wet
Theoretical Coverage	6 m²/litre at 100 microns d.f.t and stated volume solids 241 sq.ft/US gallon at 4 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	10 hours	Extended[1]
10°C (50°F)	75 minutes	22 hours	6 hours	Extended[1]
15°C (59°F)	60 minutes	16 hours	3 hours	Extended[1]
25°C (77°F)	45 minutes	7.5 hours	2 hours	Extended[1]

[1] See International Protective Coatings Definitions and Abbreviations

REGULATORY DATA

Flash Point	Part A 35°C (95°F); Part B 5°C (41°F); Mixed 28°C (82°F)	
Product Weight	1.30 kg/l (10.8 lb/gal)	
VOC	299 g/kg	EU Solvent Emissions Directive (Council Directive 1999/13/EC)

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.

Abrasive Blast Cleaning

Abrasive blast clean to Sa2½ (ISO 8501-1:2007) or SSPC-SP6. If oxidation has occurred between blasting and application of Interthane 329, 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.

Interthane 329 is suitable for application to blast cleaned surfaces which were initially to the above standard but have been allowed to deteriorate under good shop conditions for up to 7-10 days. The surface may deteriorate to Sa2 standard but must be free from loose powdery deposits.

Primed Surfaces

The primer surface should be dry and free from all contamination and Interthane 329 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 the product.

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 Binder (Part A) with a power agitator.

(2) Combine entire contents of Powder (Part B) with Binder (Part A) and mix thoroughly with a power agitator.

Mix Ratio

7 part(s) : 1 part(s) by volume

Working Pot Life

5°C (41°F)	10°C (50°F)	25°C (77°F)
6 hours	4.5 hours	2 hours

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)	Do not thin more than allowed by local environmental legislation	
Cleaner	International GTA713 (or International GTA056)		

Work Stoppages

Thoroughly flush all equipment with International GTA713. 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 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.

Like any polyurethane cured with aromatic isocyanate, this product can chalk or yellow when exposed outdoors. However, this does not affect the performance.

When applying Interthane 329 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 329 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 329 in confined spaces ensure adequate ventilation.

When overcoating after weathering or ageing, 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 329.

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 329 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.

SYSTEMS COMPATIBILITY

The following primers/intermediates are recommended for Interthane 329:

Intercure 200	Interplus 770
Intercure 200HS	Interseal 670HS
Intercure 420	Interzinc 315
Intercure 420HS	Interzinc 42
Intergard 251	Interzinc 52
Intergard 475HS	Interzinc 52HS
Interplus 256	Interzone 505
Interplus 356	Interzone 954

The following topcoats are recommended for Interthane 329:

Interfine 629HS
Interthane 329
Interthane 870
Interthane 990

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	Part A		Part B	
		Vol	Pack	Vol	Pack
	20 litre	17.5 litre	20 litre	2.5 litre	3.7 litre
	For availability of other pack sizes, contact International Protective Coatings.				
SHIPPING WEIGHT	Unit Size	Part A		Part B	
	20 litre	27 kg		2.9 kg	
STORAGE	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. Protect from freezing at all times during storage.			

Important Note

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