

## Water-Based Acrylic Finish

**PRODUCT DESCRIPTION** A one pack, waterborne, fire retardant acrylic finish.

**INTENDED USES** A durable waterborne cosmetic finish for above water areas.  
For use at Newbuilding, Maintenance & Repair or On Board Maintenance.

**PRODUCT INFORMATION**

<b>Color</b>	HF4510H-White and a range of colors
<b>Finish/Sheen</b>	Low Sheen
<b>Part B (Curing Agent)</b>	One pack
<b>Volume Solids</b>	45% ±2% (ASTM D2697-86)
<b>Mix Ratio</b>	One pack
<b>Typical Film Thickness</b>	2 mils dry (4.4 mils wet), 1.5 - 2.5 mils dry practical range equivalent to 3.3 - 5.6 mils wet
<b>Theoretical Coverage</b>	361 ft <sup>2</sup> /US Gal at 2 mils dft, allow appropriate loss factors
<b>Method of Application</b>	Airless Spray, Brush, Conventional Spray, Roller
<b>Flash Point</b>	Not applicable

Drying Information	50°F	73°F	95°F
Touch Dry [ASTM D1640 7.5.1]	60 mins	30 mins	15 mins
Hard Dry [ASTM D1640 7.7]	6 hrs	3.5 hrs	3.5 hrs

Overcoating Data - see limitations	Substrate Temperature					
	50°F		73°F		95°F	
Overcoated By	Min	Max	Min	Max	Min	Max
Intercryl 451	6 hrs	ext	4 hrs	ext	60 mins	ext

**Note** At 50% relative humidity - Dry time and recoat times of waterborne coatings will be longer at higher humidities and shorter at lower humidities.

**REGULATORY DATA** **VOC** 160 g/lit (1.34 lb/US gal) as supplied (EPA Method 24)

**Note:** VOC values are typical and are provided for guidance purposes only. These may be subject to variation depending on factors such as differences in color and normal manufacturing tolerances.

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### SYSTEMS AND COMPATIBILITY

Consult your International Paint representative for the system best suited for the surfaces to be protected.

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### SURFACE PREPARATIONS

Use in accordance with the standard Worldwide Marine Specifications.

All surfaces to be coated should be clean, dry and free from contamination.

High pressure fresh water wash or fresh water wash, as appropriate, and remove all oil or grease, soluble contaminants and other foreign matter in accordance with SSPC-SP1 solvent cleaning.

#### **Unpainted surfaces:**

Prepare surface and apply recommended primer. Apply one or more coats of Intercryl 451 as specified. (Consult the relevant primer data sheet for surface preparation and overcoating information.)

#### **Previously Painted Surfaces:**

Remove all mill scale, loose rust, loose paint and other foreign matter by "Hand or Power Tool Cleaning" (SSPC-SP2 or SP3, respectively).

Sand or "Brush Blast" (SSPC-SP7) any hard glossy areas until dull. Spot prime bare areas as recommended and apply one or more coats of Intercryl 451 as specified. Consult the relevant primer data sheet for specific surface preparation and overcoating information. Check integrity of existing coating system and apply a representative test patch to confirm compatibility. Consult your International Paint representative for procedures.

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<b>APPLICATION</b>	Apply by conventional or airless spray. Thoroughly flush equipment with International GTA991 Thinner, followed by water prior to using. To obtain maximum edge protection and film build, conventional or airless spray application is recommended. Application by other methods, brush or roll, may require more than one coat. Apply Intercryl 451 at 4.4 mils wet film thickness which will yield 2.0 mils dry film thickness. Consult the following equipment recommendations or utilize suitable equal.
<b>Mixing</b>	This material is a one pack coating. Always mix thoroughly with a power agitator before application.
<b>Thinner</b>	DO NOT THIN BEYOND YOUR STATES COMPLIANCY. Material is supplied at spray viscosity and normally does not need thinning. If thinning is necessary, clean, potable water is preferred. Thin only with amount necessary to obtain proper application and /or atomization (break-up) properties.
<b>Airless Spray</b>	Minimum 28:1 ratio pump; 0.013"- 0.017" (330-432 microns) orifice tip; 3/8" (9.5 mm) ID high pressure material hose; 60 mesh tip filter
<b>Conventional Spray</b>	DeVilbiss MBC-510 gun E tip and 704 air cap; 3/8" (9.5 mm) ID material hose; double regulated pressure tank with oil and moisture separator.
<b>Brush</b>	Use appropriate size ACE polyester brush.
<b>Roller</b>	Use All Purpose Roller cover with 3/8" (9.5 mm) smooth to medium nap. Prewash roller cover to remove loose fibres prior to use.
<b>Cleaner</b>	Potable Water or International GTA991
<b>Work Stoppages and Cleanup</b>	Clean all equipment immediately after use with water or International GTA991. It is good working practice to periodically flush out spray equipment during the course of the working day. Frequency will depend upon factors such as amount sprayed, temperature and elapsed time including work stoppages. Monitor material condition. All surplus materials and empty containers should be disposed of in accordance with appropriate regional regulations/legislation.
<b>Welding</b>	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. In North America do so in accordance with instruction in ANSI/ASC Z49.1 "Safety in Welding and Cutting."

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**SAFETY**

**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.**

**Prior to use, obtain, consult and follow the Material Safety Data Sheet for this product concerning health and safety information. Read and follow all precautionary notices on the Material Safety Data Sheet and container labels. If you do not fully understand these warnings and instructions or if you can not strictly comply with them, do not use this product. Proper ventilation and protective measures must be provided during application and drying to keep solvent vapor concentrations within safe limits and to protect against toxic or oxygen deficient hazards. Take precautions to avoid skin and eye contact (ie. gloves, goggles, face masks, barrier creams etc.) Actual safety measures are dependant on application methods and work environment.**

**EMERGENCY CONTACT NUMBERS:**

**USA/Canada - Medical Advisory Number 1-800-854-6813**

**Europe - Contact (44) 191 4696111. For advice to Doctors & Hospitals only contact (44) 207 6359191**

**R.O.W. - Contact Regional Office**

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### LIMITATIONS

Apply in good weather when air and surface temperatures are above 50°F. Surface temperature must be at least 5°F above dew point. Do not apply when relative humidity is above 85% or when inclement weather is predicted. The drying and overcoating times will be extended if the relative humidity is greater than 70%. Ensure good airflow around the painted object, minimum air speed 4 in/sec. Minor areas which are difficult to ventilate should be brush applied to prevent over application. Application below the minimum film forming temperature and/or poor ventilation will result in a powdery cracked film which will require removal and re-application. For optimum application properties, bring material to 70-80°F temperature range prior to mixing and application. Unmixed material (in closed containers) should be maintained in protected storage between 40 and 100°F. Keep from freezing. Overcoating information is given for guidance only and is subject to regional variation depending upon local climate and environmental conditions. Consult your local International Paint representative for specific recommendations. Technical and application data herein is for the purpose of establishing a general guideline of the coating and proper coating application procedures. Test performance results were obtained in a controlled laboratory environment and International Paint makes no claim that the exhibited published test results, or any other tests, accurately represent results actually found in all field environments. As application, environmental and design factors can vary significantly, due care should be exercised in the selection, verification of performance and use of the coating. In the overcoating data section 'ext' = extended overcoating period. Please refer to our Marine Painting Guide - Definitions and Abbreviations available on our website.

UNIT SIZE	Unit Size	
	Vol	Pack
	5 US gal	5 US gal
For availability of other unit sizes consult International Paint		
UNIT SHIPPING WEIGHT	Unit Weight	
	5 US gal	58 lb
STORAGE	Shelf Life	12 months minimum from date of manufacture when maintained in protected storage at 40-100°F. Subject to reinspection thereafter. Store in dry, shaded conditions away from sources of heat and ignition. Keep from freezing.

**WORLDWIDE AVAILABILITY** Consult International Paint.

### 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 representative that this data sheet is current prior to using the product.

This Technical Data Sheet is available on our website at [www.international-marine.com](http://www.international-marine.com) or [www.international-pc.com](http://www.international-pc.com), and should be the same as this document. Should there be any discrepancies between this document and the version of the Technical Data Sheet that appears on the website, then the version on the website will take precedence.

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