

Isocyanate-Free Finish

PRODUCT DESCRIPTION A two pack, epoxy acrylic isocyanate-free cosmetic finish providing good long term durability. Interfine 691 offers equivalent performance to typical recoatable polyurethane cosmetic finishes.

INTENDED USES For use as a cosmetic finish on above water areas.
For use at Newbuilding, Maintenance & Repair or On Board Maintenance.

PRODUCT INFORMATION

Colour	GFB000-White, GFY999-Black ; and a range of colours
Finish/Sheen	Gloss
Part B (Curing Agent)	GFA691
Volume Solids	53% ±3% (ISO 3233:1998)
Mix Ratio	2.00 volume(s) Part A to 1 volume(s) Part B
Typical Film Thickness	50 microns dry (94 microns wet)
Theoretical Coverage	10.60 m ² /litre at 50 microns dft, allow appropriate loss factors
Method of Application	Airless Spray, Roller, Brush, Conventional Spray
Flash Point (Typical)	Part A 29°C; Part B 28°C; Mixed 29°C
Induction Period	Not required

Drying Information	-5°C	5°C	25°C	35°C
Touch Dry [ISO 9117/3:2010]	6 hrs	4 hrs	2 hrs	60 mins
Hard Dry [ISO 9117-1:2009]	26 hrs	22 hrs	8 hrs	6 hrs
Pot Life	8 hrs	8 hrs	7 hrs	6 hrs

Overcoating Data - see limitations	Substrate Temperature							
	-5°C		5°C		25°C		35°C	
Overcoated By	Min	Max	Min	Max	Min	Max	Min	Max
Interfine 691	26 hrs	ext	22 hrs	ext	8 hrs	ext	6 hrs	ext

Note Drying and overcoating times quoted are measured at 50 microns dry, at higher film thickness times will be increased.

REGULATORY DATA

VOC	409 g/lit as supplied (EPA Method 24) 285 g/kg of liquid paint as supplied. EU Solvent Emissions Directive (Council Directive 1999/13/EC)
------------	--

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 colour and normal manufacturing tolerances.

Isocyanate-Free Finish

SYSTEMS AND COMPATIBILITY

Interfine 691 should only be applied over epoxy anticorrosive primers or tiecoats. The primer to be used will depend upon vessel area and application location. Typical primer/tie coats include:

Intergard 263
Intergard 269
Intergard 400
Intershield 300
Intershield 803

The following primers may be overcoated with Interfine 691 only after application of a suitable tiecoat:

Interbond 201
Interbond 501
Intertuf 262

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

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.

NEWBUILDING/MAJOR REFURBISHMENT

Interfine 691 should always be applied over a recommended primer coating scheme. The primer surface should be dry and free from all contamination, and Interfine 691 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) and primed prior to the application of Interfine 691

REPAIR/OBM

Interfine 691 should always be applied over a recommended primer coating scheme. The primer surface should be dry and free from all contamination, and Interfine 691 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) and primed prior to the application of Interfine 691

Interfine 691 may be applied directly over aged Interfine 691 following thorough fresh water washing and degreasing provided the coating to be overcoated is in an intact and tightly adherent condition. Loose or flaking coatings should be removed back to a firm edge and Interfine 691 or an appropriate primer should be used to repair the area before application of the full coat.

Consult International Paint for application of Interfine 691 over other existing coatings.

Consult your International Paint representative for specific recommendations.

Isocyanate-Free Finish

APPLICATION

Mixing	Material is supplied in 2 containers as a unit. Always mix a complete unit in the proportions supplied. (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.
Thinner	Not recommended. Use International GTA007 only in exceptional circumstances (max 5% by volume). DO NOT USE ANY OTHER THINNER. DO NOT thin more than allowed by local environmental legislation.
Airless Spray	Recommended Tip Range 0.33-0.45 mm (13-18 thou) Total output fluid pressure at spray tip not less than 155 kg/cm ² (2200 p.s.i.)
Conventional Spray	Use suitable proprietary equipment. Thinning may be required.
Brush	Suitable.
Roller	Suitable.
Cleaner	International GTA007
Work Stoppages and Cleanup	Do not allow material to remain in hoses, gun or spray equipment. Thoroughly flush all equipment with International GTA007. 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. Clean all equipment immediately after use with International GTA007. 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. Do not exceed pot life limitations. All surplus materials and empty containers should be disposed of in accordance with appropriate regional regulations/legislation.
Welding	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."

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 vapour 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

Isocyanate-Free Finish

LIMITATIONS

This product is not recommended for use in immersed conditions.

For brush and roller application, and in some colours, two coats of Interfine 691 may be required to give uniform coverage, especially when applying Interfine 691 over dark undercoats and when using certain lead-free bright finish colours such as yellows and oranges. Best practice is to use a colour compatible intermediate or anticorrosive coating under Interfine 691.

High relative humidity, fog or condensation occurring during or immediately after Interfine 691 application may result in a matt finish and a film with inferior properties. Premature exposure to ponding water (eg. on external decks) will cause colour change, especially in dark shades. Low temperatures will increase these effects.

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. Apply in good weather. Temperature of the surface to be coated must be at least 3°C above the dew point. For optimum application properties bring the material to 21-27°C, unless specifically instructed otherwise, prior to mixing and application. Unmixed material (in closed containers) should be maintained in protected storage in accordance with information given in the STORAGE Section of this data sheet. Technical and application data herein is for the purpose of establishing a general guideline of the 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 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 from our website.

UNIT SIZE	Unit Size	Part A		Part B	
		Vol	Pack	Vol	Pack
	15 lt	10 lt	20 lt	5 lt	5 lt

For availability of other unit sizes consult International Paint

UNIT SHIPPING WEIGHT (TYPICAL)	Unit Size	Unit Weight
	15 lt	21.03 Kg

STORAGE	Shelf Life	12 months minimum at 25°C. Subject to re-inspection thereafter. Store in dry, shaded conditions away from sources of heat and ignition. Do not store above 35°C

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 or 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.

All trademarks mentioned in this publication are owned by, or licensed to, the AkzoNobel group of companies.

© AkzoNobel, 2015

www.international-marine.com