

Direct to Metal Polyaspartic

PRODUCT DESCRIPTION

Intercure 99 polyaspartic technology is applied as a single coat at 6-10 mils (150-250 microns) direct-to-metal using standard application equipment, reducing application time and labor costs compared to two coat applications in moderately corrosive environments (up to C3, ISO 12944-2).

Intercure 99 is a low VOC, high solids, rapid cure primer/finish, offering excellent anticorrosive protection and long term color and gloss durability – a combination that cannot be achieved with alternative fast cure, single coat primer finishes.

Intercure 99 may also be specified as a high build, durable intermediate/finish over approved anti-corrosive primers for more aggressive environments, i.e. ISO 12944 C4 and C5M.

INTENDED USES

Intercure 99 is ideal for use where a single coat high performance coating is required. For structural steel applications, a reduced number of coats aids in yard throughput and productivity. Fast cure single coat properties also make it ideal for applications such as wind towers, transformers, mining equipment and pumps where productivity and drying space are of prime importance.

PRACTICAL INFORMATION FOR INTERCURE 99

Color	Wide range via the Chromascan® system
Gloss Level	Gloss
Volume Solids	80% ± 3%
Typical Thickness	6-10 mils (150-250 microns) dry equivalent to 7.5-12.5 mils (188-313 microns) wet
Theoretical Coverage	183 sq.ft/US gallon at 7 mils d.f.t and stated volume solids 4.60 m ² /liter at 175 microns d.f.t and stated volume solids
Practical Coverage	Allow appropriate loss factors
Method of Application	Airless Spray, Air Spray
Drying Time	

Overcoating interval with self

Temperature	Touch Dry	Hard Dry	Minimum	Maximum
41°F (5°C)	1.5 hours	4 hours ¹	4 hours	Extended ²
59°F (15°C)	60 minutes	3 hours ¹	3 hours	Extended ²
77°F (25°C)	30 minutes	1.5 hours ¹	1.5 hours	Extended ²
104°F (40°C)	30 minutes	1.5 hours ¹	1.5 hours	Extended ²

¹ Drying times quoted relate to 50% R.H. increased humidity will result in faster dry times.

² See International Protective Coatings Definitions & Abbreviations

REGULATORY DATA

Flash Point (Typical)	Part A 122°F (50°C); Part B 316°F (158°C); Mixed 124°F (51°C)		
Product Weight	11.6 lb/gal (1.39 kg/l)		
VOC	1.83 lb/gal (220 g/l)	EPA Method 24	
	165 g/kg	EU Solvent Emissions Directive (Council Directive 1999/13/EC)	

See Product Characteristics section for further details

Direct to Metal Polyaspartic

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.

Abrasive Blast

Abrasive blast clean to SSPC-SP6 or Sa2½ (ISO 8501-1:2007). If oxidation has occurred between blasting and application of Intercure 99, 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 surface profile of 2-3 mils (50-75 microns) is recommended.

Primed Surfaces

Intercure 99 may be applied over approved anti-corrosive primers in some circumstances; please consult International Protective Coatings for further advice.

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 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.			
Mix Ratio	4 part(s) : 1 part(s) by volume			
Working Pot Life	41°F (5°C) 2 hours	59°F (15°C) 1.5 hours	77°F (25°C) 45 minutes	104°F (40°C) 45 minutes
Airless Spray	Recommended	Tip Range 15-19 thou (0.38-0.48 mm) Total output fluid pressure at spray tip not less than 2503 psi (176 kg/cm²)		
Air Spray (Pressure Pot)	Recommended	Gun Air Cap Fluid Tip	DeVilbiss MBC or JGA 704 or 765 E	
Air Spray (Conventional)	Recommended	Use suitable proprietary equipment.		
Brush	Suitable - Small areas only	Typically 3.0-5.0 mils (75-125 microns) can be achieved		
Roller	Suitable - Small areas only			
Thinner	International GTA713 (or International GTA056)	Do not thin more than allowed by local environmental legislation Do not use alternative thinners.		
Cleaner	International GTA713 (or International GTA056)	Do not use alternative cleaners.		
Work Stoppages	Do not allow material to remain in hoses, gun or spray equipment. Thoroughly flush all equipment with International GTA056. 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 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.			

Direct to Metal Polyaspartic

PRODUCT CHARACTERISTICS

The detailed Intercure 99 Application Guidelines should be consulted prior to use.

During the spray application of Intercure 99 at high relative humidity (>85%), a reduction in the quoted pot life time of the mixed material may occur. This can be resolved by placing sufficient solvent to cover the surface of the material during application. The addition of approx 3 ounces of GTA713 or GTA056 per 3 gallon mixed unit should suffice.

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

For tinted colors, a 5 minute induction time is recommended to fully develop color. Failure to allow induction, particularly at low temperatures, may result in inconsistency of the finished shade.

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. Lower or high temperatures may require specific application techniques to achieve maximum film build.

When applying Intercure 99 by brush or roller, it may be necessary to apply multiple coats to achieve the total specified system dry film thickness.

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

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.

Surface temperature must always be a minimum of 5°F (3°C) above dew point.

Application at humidities greater than 50% may result in faster drying times.

When applying Intercure 99 in confined spaces, ensure adequate ventilation.

Intercure 99 is not designed for continuous water immersion.

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

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 color and normal manufacturing tolerances.

SYSTEMS COMPATIBILITY

Intercure 99 may be applied direct to metal for atmospheric exposure in environments up to and including C3 (as defined in ISO12944 Part 2). When using Intercure 99 in atmospheric environments classed as C4 or C5, a recommended primer must be used.

Please consult International Protective Coatings for the latest technical advice.

Direct to Metal Polyaspartic

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
- Intercure 99 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 liter	16 liter	20 liter	4 liter	5 liter
For availability of other pack sizes contact International Protective Coatings					
SHIPPING WEIGHT (TYPICAL)	Unit Size	Part A		Part B	
	20 liter	24.8 kg		5.1 kg	
STORAGE	Shelf Life	12 months minimum at 77°F (25°C). Subject to re-inspection thereafter. Store in dry, shaded conditions away from sources of heat and ignition.			

Disclaimer

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.

Copyright © AkzoNobel, 2/5/2015.

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

SKE Beschichtungssysteme GmbH | Buchenring 11 | D-21272 Egestorf
 Fon +49 (0) 4175 / 808 99 -31 | Fax +49 (0) 4175 / 808 99 -32
 E-Mail: info@ske-beschichtungen.de | www.ske-beschichtungen.de