

# Interfine 629

Two pack acrylic finish

**Product Description**

A two pack high gloss acrylic finish designed to exhibit the following features;

- Safer to use, no isocyanates.
- Good gloss and colour retention in severe environments.
- Cures down to 2°C.
- Recoatable, easy to maintain.
- Fast drying, fast handling.

**Intended Uses**

As a high performance topcoat for existing structures and new construction where a high gloss, weather resistant finish is required. Typical applications are (but not restricted to);

- Shopping complexes and sporting arenas.
- Tank exteriors.
- Handrails.
- General steelwork and equipment where aesthetic appearance is required.

**Practical Information for Interfine 629**

<b>Colour</b>	Wide range of colours via the Chromascan system			
<b>Gloss Level</b>	Full Gloss			
<b>Volume Solids</b>	50%			
<b>Typical Thickness</b>	60-75 microns (2.4-3 mils) dry equivalent to 120-150 microns (4.8-6.0 mils) wet			
<b>Theoretical Coverage</b>	6.6 m <sup>2</sup> /litre at 75 microns d.f.t and stated volume solids 269 sq.ft/US gallon at 3 mils d.f.t and stated volume solids			
<b>Practical Coverage</b>	Allow appropriate loss factors			
<b>Method of Application</b>	Airless spray, Conventional spray, Brush and Roller			
<b>Drying Time</b>	Overcoating Interval with Self			
Temperature	Touch Dry	Hard Dry	<i>Minimum</i>	<i>Maximum*</i>
10°C (50°F)	60 minutes	18 hours	18 hours	Extended*
15°C (59°F)	40 minutes	10 hours	10 hours	Extended*
25°C (77°F)	20 minutes	6 hours	6 hours	Extended*
40°C (104°F)	10 minutes	2 hours	2 hours	Extended*

\* See International Protective Coatings Definitions & Abbreviations

**Regulatory Data**

<b>Flash Point</b>	Base (Part A) 23°C (73°F)	C/A (Part B) 24°C (75°F)	Mixed 23°C (73°F)
<b>Product Weight</b>	1.15 kg/l (9.6 lb/gal)		
<b>VOC</b>	514 g/l	UK - PG6/23(92), Appendix 3	

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## 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 8504:1992.

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

Accumulated dirt and soluble salts must be removed by fresh water washing.

Interfine 629 should always be applied over a recommended anti-corrosive coating scheme. The primer surface should be dry and free from all contamination, and Interfine 629 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 8501-1:1988), SSPC-SP6, Abrasive Blasting, or SSPC-SP11, Hand/Power Cleaning) and patch primed prior to the application of Interfine 629.

## 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

1 parts : 1 part by volume

### Working Pot Life

10°C (50°F)	15°C (59°F)	25°C (77°F)	40°C (104°F)
10 hours	8 hours	4 hours	2 hours

### Airless Spray

Suitable  
Thin sparingly

- Tip range 0.38-0.48 mm (15-19 thou)
- Total output fluid pressure at spray tip not less than 106 kg/cm<sup>2</sup> (1.500 p.s.i.)

### Air Spray (Pressure Pot)

Suitable  
Thin up to 20%

Gun	DeVilbiss MBC or JGA
Air Cap	704 or 765
Fluid Tip	E

### Brush

Suitable  
Typically 100 microns (4 mils) can be achieved

### Roller

Suitable  
Typically 75 microns (3 mils) can be achieved

### Thinner

International GTA713

### Cleaner

International GTA713

### Work Stoppages

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 recommence 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.

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## Product

Available in a wide range of colours produced via the Chromascan system.

## Characteristics

Interfine 629 is indefinitely recoatable with itself provided existing surface is clean, dry and free from contamination

In hot or windy conditions thinner GTA713 must be used for spray reductions to improve flow out and reduce dry spray. In these conditions ensure full thickness is applied in one coat.

Use only recommended thinner. Durability and performance will be affected with incorrect thinner.

Do not apply Interfine 629 in thin coats. Wet coating thickness must always exceed 110 microns. In hot conditions recommendation is to apply at high end of film thickness range.

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

Avoid contact with alkaline materials.

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## Systems

### Compatibility

The following primers are recommended for Interfine 629:

Intercure 200  
Intergard 251  
Interprime 198

The following high build epoxies are recommended for Interfine 629:

Intergard 475  
Intergard 475 HS  
Intercure 420

Interfine 629 can also be applied over epoxy mastic coatings such as Interseal 670 HS, Interseal 2020 and Interplus 356.

For other suitable primers/intermediates, please consult International Protective Coatings.

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## Additional Information

Further information regarding industry standards, terms and abbreviations used in this data sheet can be found in the following sections of the International Protective Coatings data manual:

- 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.

<b>Pack Size</b>	20 litre unit	Interfine 629 Base Interfine 629 Curing Agent	10 litres in a 20 litre steel container 10 litres in a 10 litre steel container
	5 gallon unit	Interfine 629 Base Interfine 629 Curing Agent	2.5 gallons in a 5 gallon steel container 2.5 gallons in a 3 gallon steel container
	For availability of other pack sizes contact International Protective Coatings		
<b>Shipping Weight</b>	U.N. Shipping No. 1263		
	20 litre unit	15 kg (33 lb) Base (Part A)	11 kg (24.2 lb) Curing Agent (Part B)
	5 gallon unit	14.2 kg (31.2 lb) Base (Part A)	10.4 kg (22.9 lb) Curing Agent (Part B)
<b>Storage</b>	Shelf Life		
	24 months minimum at 25°C (77°F). Subject to re-inspection thereafter. Store in dry, shaded conditions away from sources of heat and ignition.		

## Disclaimer

*The information given in this sheet is not intended to be exhaustive and any person using the product for any purpose other than that specifically recommended in this sheet without first obtaining written confirmation from us as to the suitability of the product for the intended purpose does so at his own risk. Any warranty, if given, or specific Terms & Conditions of Sale are contained in International's Terms & Conditions of Sale, a copy of which can be obtained on request. Whilst we endeavour to ensure that all advice we give about the product (whether in this sheet or otherwise) is correct we have no control over either the quality or 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 whatsoever or howsoever arising from the performance of the product or for any loss or damage (other than death or personal injury resulting from our negligence) arising out of the use of the product. The information contained in this sheet is liable to modification from time to time in the light of experience and our policy of continuous product development.*

*It is the user's responsibility to check that this sheet is current prior to using the product. Issue date: 29/03/2000*

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