Interthane 138

Polyurethane

PRODUCT DESCRIPTION

Two component acrylic polyurethane finish giving excellent durability and long term 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, petrochemicals plants, bridges and in the power industry.

PRACTICAL INFORMATION FOR INTERTHANE 138

Colour	Wide range
Gloss Level	Glossy
Volume Solids	50 +/- 2% (depends on colour)
Typical Thickness	50 - 60 microns (2.0 – 2.4 mils) dry equivalent to 100 - 120 microns (4 – 4 .8 mils) wet
Theoretical Coverage	10.0 m^2 / litre at 50 microns d.f.t. and at 50% volume solids
Practical Coverage	Allow appropriate loss factors
Method of Application	Airless spray, Conventional Spray, Brush, Roller

Drying Time

Temperature	Touch Dry	Hard Dry	Overcoating Interval with Interthane 138 by Self *Minimum*	*Maximum*
15°C (59° F)	5 hours	16 hours	16 hours	Extended*
25°C (77° F)	2 hours	9 hours	9 hours	Extended*
40°C (104° F)	1 hour	5 hours	5 hours	Extended*

* See International Protective Coatings Definitions and Abbreviations

REGULATORY DATA

	Base (Part A)	C/A (Part B)	Mixed
Flash point	34° C (93 ° F)	49°C (120° F)	35° C (95 °F)

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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 8504:1994

Primed Surfaces

Interthane 138 should always be applied over a recommended anti-corrosive coating Scheme. The primer surface should be dry and free from all contamination., and Interthane 138 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. SA21/2 (ISO 8501-1:1988) or SSPC-SP6, Abrasive Blasting, or SSPC-SP11, Power Tool Cleaning) and patch primed prior to the application of Interthane 138.

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

9.0 parts : 1.0 part by volume

Working Pot Life

5° C (41°F)	15°C (59° F)	25°C (77°F)	40°C (104°F)
12 hours	4 hours	2 hours	45 minutes

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 / cm2 (2,200 p.s.i.)

Air Spray (Pressure Pot)

Recommended

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

Air Spray (Conventional)

Suitable

Use suitable proprietary equipment.

Brush

Suitable

Typically 30 – 40 microns (1.2 – 1.6 mils) can be achieved

Roller

Suitable

Typically 30-40 microns (1.2 – 1.6 mils) can be achieved

Thinner

International GTA733

Do not thin more than allowed by local environmental legislation.

Cleaner

International GTA733

Work Stoppages

Do not allow material to remain in hoses, gun or spray equipment. Thoroughly flush all equipment with International GTA733. Once units of paint have been mixed they should not be resealed and it is advised that after prolonged stoppages work commences with freshly mixed units.

Clean Up

Clean all equipment immediately after use with International GTA733 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 CHARACTERISTICS

Level of sheen and surface finish is dependent on application method. Avoid using a mixture of application methods whenever possible. Best results in terms of gloss and appearance will always be obtained with conventional air spray application.

For brush application, and in some colours, two coats of Interthane 138 May be required to give uniform coverage, especially when applying Interthane 138 over dark undercoats, and when using certain lead free bright colours such as yellows and oranges. Best practice is to use a colour compatible intermediate or anti-corrosive coating under the Interthane 138.

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 138.

Absolute measured adhesion of topcoats to aged Interthane 138 is less than that to fresh material, however, it is adequate for the specified end use.

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 temperature below 5 ° C (41° F).

When applying Interthane 138 in confined spaces, ensure adequate ventilation.

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.

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.

SYSTEMS COMPATIBILITY

The following primers / intermediates are recommended for Interthane 138:

Intergard 475 HS	Intergard 410
Intergard 251	Intergard 345
Intergard 269	Interseal 670 HS
Intergard 400	Interzinc 42
Interplus 256	Interzinc 52

Interthane 138 is designed to be topcoated with itself.

For other suitable primers / intermediates, 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.

Warning : Contains isocyanate. Wear air-fed hood for spray application.

PACK SIZE

20 litre unit — Interthane 138 Base 18 litres in a 20 litre container
Interthane 138 Curing Agent 2 litres in a 3.0 litre container

For availability of other pack sizes contact International Protective Coatings.

STORAGE

Shelf Life — 12 months minimum at 25 °C (77° F). Subject to re-inspection .hereafter. Store in dry, shaded conditions away from sources of heat and ignition.Curing agent is moisture sensitive. Store in a cool and dry place.