

Direct to Metal Polyaspartic

PRODUCT DESCRIPTION

A two component, low VOC, high solids, fast drying polyaspartic gloss primer/finish coating.

Intercure 3240G provides improved productivity at ambient temperature application whilst combining the anti-corrosive performance of epoxy coatings and high aesthetics of UV durable topcoats in a single coat application.

Intercure 3240G is applied as a single coat direct to correctly prepared substrates using manual mix (single leg) or automatic mix (plural leg) application equipment, reducing application time, energy consumption and labour costs when compared to two coat applications, or single coat applications which require force drying at high temperature.

INTENDED USES

Specifically designed as part of the International 3200 product series for use as a single or two coat primer/finish coating system to protect construction and mining heavy machinery, agricultural equipment, railcars, transportation vehicles, material handling and lifting equipment, pumps, valves, gear units and other small motors and machinery.

Intercure 3240G is particularly suited for use as a rapid drying system for fast handling times and maximizing production throughput at 20-25°C without the need for force drying at higher temperatures. This contributes to lower energy consumption in OEM fabrication and painting facilities.

The main features of Intercure 3240G are:

- Single coat application with fast handling times
- Good adhesion properties over correctly prepared substrates
- Rapid cure at 25°C to provide energy cost savings
- High solids and low VOC emissions
- Eliminates the need for costly baking ovens or solvent burners

PRACTICAL INFORMATION FOR INTERCURE 3240G

Colour	Colours available on request
Gloss Level	70-80 gloss units at 60° angle
Volume Solids	84% ± 2%
Typical Thickness	80-150 microns (3.2-6 mils) dry equivalent to 95-179 microns (3.8-7.2 mils) wet
Theoretical Coverage	7 m ² /litre at 120 microns d.f.t and stated volume solids 281 sq.ft/US gallon at 4.8 mils d.f.t and stated volume solids
Practical Coverage	Allow appropriate loss factors
Method of Application	Airless Spray, Air Assisted Airless Spray, Air Spray, Brush, Plural Component Airless Spray, Roller

Drying Time

Temperature	Touch Dry	Hard Dry	Overcoating Interval with recommended topcoats	
			Minimum	Maximum
5°C (41°F)	60 minutes	3.5 hours ¹	*	*
15°C (59°F)	45 minutes	2.5 hours ¹	*	*
25°C (77°F)	30 minutes	2 hours ¹	*	*
40°C (104°F)	15 minutes	90 minutes ¹	*	*

¹ The drying times quoted have been determined at the quoted temperature and 50% relative humidity.

* Intercure 3240G is designed as a single coat system.

REGULATORY DATA

Flash Point (Typical)	Part A 50°C (122°F); Part B 158°C (316°F); Mixed 52°C (126°F)	
Product Weight	1.53 kg/l (12.8 lb/gal)	
VOC	152 g/kg	EU Solvent Emissions Directive (Council Directive 1999/13/EC)

See Product Characteristics section for further details

Protective Coatings

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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 8504:2000. Oil or grease should be removed in accordance with SSPC-SP1 solvent cleaning.

Steel

Abrasive blast clean to a minimum of Sa2½ (ISO 8501-1:2007) SSPC-SP6. If oxidation has occurred between blasting and application of Intercure 3240G the surface should be re-blasted 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 40-60 microns (1.6-2.4 mils) is recommended. Lower surface profiles of 20-30 microns (0.8-1.2 mils) can be used to improve the overall aesthetics of the overall paint system.

Stainless Steel, Galvanised Steel and Aluminium

Remove dirt and oils by solvent cleaning or other suitable detergent/cleaner followed by a thorough water rinsing. Abrasive blast clean in accordance with SSPC SP16 Brush-off Blast Cleaning of Non-Ferrous Metals.

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	5°C (41°F) 3 hours	15°C (59°F) 2 hours	25°C (77°F) 40°C (104°F) 60 minutes 45 minutes
Plural Component Airless Spray	Recommended		
Airless Spray	Recommended	Tip Range 0.33-0.48 mm (13-19 thou) Total output fluid pressure at spray tip not less than 176 kg/cm ² (2503 p.s.i.) For air-assisted airless spray, use suitable proprietary equipment. Electrostatic spray application will require an appropriate trial.	
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 80-100 microns (3.2-4.0 mils) can be achieved	
Roller	Suitable - small areas only	Typically 80-100 microns (3.2-4.0 mils) can be achieved	
Thinner	International GTA713	Do not thin more than allowed by local environmental legislation. Do not use alternative thinners.	
Cleaner	International GTA713	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 GTA713. 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.		

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PRODUCT CHARACTERISTICS

Intercure 3240G is part of the International 3200 product series and is specifically designed for use where automated paint application and forced curing processes are in operation.

To ensure the correct use of International 3200 product series, it is recommended that the guidance in section 6.4 of ISO 12944 Part 5 (2007) is followed. Contact International Protective Coatings for further advice.

During the spray application of Intercure 3240G 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 in the can. The addition of approx 100 mls of GTA713 per 20 litre mixed unit should suffice.

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

The gloss levels quoted are typical values achieved with this product. This is subject to application method, dry film thickness and environmental conditions within a controlled OEM painting facility. It is always recommended that appropriate product application trials are carried out to ensure satisfactory levels are achieved.

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

Care should be exercised to avoid the application of dry film thicknesses in excess of 200 microns (8 mils). Higher film thicknesses than recommended will result in higher gloss appearance.

Surface temperature must always be a minimum of 3°C (5°F) above dew point. When applying Intercure 3240G in confined spaces ensure adequate ventilation.

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 colour and normal manufacturing tolerances.

SYSTEMS COMPATIBILITY

Intercure 3240G is designed as a single coat system for application directly to correctly prepared substrates.

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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 documents available at www.international-pc.com:

- 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.

PACK SIZE	Unit Size	Part A		Part B	
		Vol	Pack	Vol	Pack
	20 litre	16 litre	20 litre	4 litre	5 litre
For availability of other pack sizes, contact International Protective Coatings.					
SHIPPING WEIGHT (TYPICAL)	Unit Size	Part A		Part B	
	20 litre	28 kg		5.1 kg	
STORAGE	Shelf Life	12 months minimum at 25°C (77°F). Subject to re-inspection thereafter. Store in dry, shaded conditions away from sources of heat and ignition.			

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.

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