

PRODUCT DESCRIPTION

A rust inhibitive primer for use over properly prepared steel. A general purpose shop primer, Interlac 393 offers low cost, easy application and low VOC.

INTENDED USES

An economical general purpose shop primer for structural steel in mild industrial and commercial environments. Suitable for use on metal parts, fabricated structures, machinery and other ferrous metal surfaces.

PRACTICAL INFORMATION FOR INTERLAC 393

Color	Red, Gray
Gloss Level	Not applicable
Volume Solids	55%
Typical Thickness	1-2 mils (25-50 microns) dry equivalent to 1.8-3.6 mils (45-91 microns) wet
Theoretical Coverage	441 sq.ft/US gallon at 2 mils d.f.t and stated volume solids 11 m ² /liter at 50 microns d.f.t and stated volume solids
Practical Coverage	Allow appropriate loss factors
Method of Application	Airless Spray, Air Spray, Brush, Roller

Drying Time

Temperature	Touch Dry	Hard Dry	Overcoating Interval with recommended topcoats	
			Minimum	Maximum
50°F (10°C)	30 minutes	2.5 hours	1 hour	Extended ¹
59°F (15°C)	20 minutes	2 hours	1 hour	Extended ¹
77°F (25°C)	15 minutes	1 hour	45 minutes	Extended ¹
104°F (40°C)	5 minutes	45 minutes	30 minutes	Extended ¹

¹ See International Protective Coatings Definitions & Abbreviations

REGULATORY DATA

Flash Point	165°F (74°C)		
Product Weight	12.3 lb/gal (1.47 kg/l)		
VOC	3.29 lb/gal (395 g/l)	EPA Method 24	

See Product Characteristics section.

SURFACE PREPARATION

The performance of this product will depend upon the degree of surface preparation. The surface 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.

Accumulated dirt and soluble salts must be removed. Dry bristle brushing will normally be adequate for accumulated dirt. Soluble salts should be removed by fresh water washing.

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

Abrasive Blast Cleaning

Abrasive blast clean to Sa2½ (ISO 8501-1:2007) or SSPC-SP6.

Surface defects revealed by the blast cleaning process should be ground, filled, or treated in the appropriate manner.

Interlac 393 is suitable for application to blast cleaned surfaces which were initially to the above standard but have been allowed to deteriorate under good shop conditions for up to 7-10 days. The surface may deteriorate to Sa2 standard but must be free from loose powdery deposits.

Maintenance and Site Touch-up

The product is designed for application to surfaces prepared to St2 (ISO 8501-1:2007) or SSPC-SP2. When using power tools care should be taken to avoid surface polishing. The product may also be applied to surfaces which have been brush blasted to Sa1 (ISO 8501-1:2007) or SSPC-SP7. On poor surfaces brush application will assist performance.

Interlac 393 is suitable for overlap onto most aged coating systems. Loose or flaking coatings should be removed back to a firm edge. Glossy epoxies and polyurethanes may require abrasion.

APPLICATION

Mixing	This material is a one component coating and should always be mixed thoroughly with a power agitator before application.		
Airless Spray	Recommended	Tip Range 15-17 thou (0.38-0.43 mm) Total output fluid pressure at spray tip not less than 2503 psi (176 kg/cm ²)	
Air Spray (Pressure Pot)	Recommended	Gun Air Cap Fluid Tip	DeVilbiss MBC or JGA 704 E
Brush	Suitable	Typically 1.6-2.0 mils (40-50 microns) can be achieved. Care should be taken to avoid under-application.	
Roller	Suitable	Typically 1.6-2.0 mils (40-50 microns) can be achieved. Care should be taken to avoid under-application.	
Thinner	International GTA007	Do not thin more than allowed by local environmental legislation	
Cleaner	International GTA007		
Work Stoppages	Thoroughly flush all equipment with International GTA007. All unused material should be stored in tightly closed containers. Partially filled containers may show surface skinning and/or a viscosity increase of the material after storage. Material should be filtered prior to use.		
Clean Up	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.		
	All surplus materials and empty containers should be disposed of in accordance with appropriate regional regulations/legislation.		

PRODUCT CHARACTERISTICS

Anti-corrosive performance on hand prepared steel is related directly to both the degree of surface preparation and the dry film thickness of the system applied.

This product is not intended for use in aggressive, corrosive environments, or on heavily pitted or contaminated steel.

When applying Interlac 393 by brush or roller, it may be necessary to apply multiple coats to achieve the total specified system dry film thickness.

Where a durable cosmetic finish with good gloss and color retention is required, overcoat with recommended topcoats.

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

If applying Interlac 393 in enclosed maintenance conditions ensure adequate ventilation.

Over-application of Interlac 393 will extend both the minimum overcoating intervals and handling times, may be detrimental to long term overcoating, performance properties and may give rise to wrinkling.

Low Temperature Curing

<u>Temperature</u>	<u>Touch Dry</u>	<u>Hard Dry</u>	<u>Overcoating Interval with recommended topcoats</u>	
			<u>Minimum</u>	<u>Maximum</u>
41°F (5°C)	1 hour	4 hours	2 hours	Extended*

* See International Protective Coatings Definitions and Abbreviations

Interlac 393 meets CISC 2-75 and 1-73a Performance Specification with exception of Drying Time (para. 5.2).

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

Interlac 393 is normally applied to blasted or hand or power tool cleaned steel.

The following topcoats are recommended for Interlac 393:

Interlac 665
Interlac 665FD
Interlac 789
Interlac 800

For other suitable topcoats, consult International Protective Coatings.

**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	Vol	Pack
	5 US gal	5 US gal	5 US gal
For availability of other pack sizes contact International Protective Coatings			
SHIPPING WEIGHT	Unit Size		
	5 US gal		65 lb
STORAGE	Shelf Life	24 months minimum at 77°F (25°C). 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 law) any loss or damage arising out of the use of the product. 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 International Paint representative that this data sheet is current prior to using the product.

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