

PRODUCT DESCRIPTION

A single component, water based rust remover gel, which can be described as readily biodegradable as tested by OECD 301B CO₂ Evolution test.

INTENDED USES

Interplus 614 is specifically designed to remove tightly adhering light to medium rust deposits from metallic substrates prior to repainting with approved maintenance coatings.

Suitable as an alternative surface preparation technique where abrasive blasting, ultra high pressure hydroblasting or power tool methods have been ruled out for operational, health & safety or environmental reasons.

To be used in conjunction with maintenance products requiring a substrate preparation similar to ISO 8501:1988 St.2.

Can be used to remove ferrous corrosion staining from stainless steel structures and zinc corrosion products from aged epoxy zinc primed surfaces.

PRACTICAL INFORMATION FOR INTERPLUS 614

Color	Blue
Gloss Level	Not applicable
Volume Solids	Not applicable
Typical Thickness	400-600 microns (16-24 mils) wet film thickness
Theoretical Coverage	80 sq.ft/US gallon (2 m ² /litre) is typically achieved when applied at a thickness of 20 mils (500µm)
Practical Coverage	Allow appropriate loss factors
Method of Application	Airless Spray, Brush, Roller
Drying Time	Not applicable

REGULATORY DATA

Flash Point	>100°C (212°F)
Product Weight	8.3 lb/gal (1.0 kg/l)
VOC	0.25 lb/gal (30 g/l) USA - EPA Method 24

28 g/kg EU Solvent Emissions Directive
(Council Directive 1999/13/EC)

See Product Characteristics section for further details

SURFACE PREPARATION

Prior to application of Interplus 614, any loose rust deposits should be removed to aid penetration of the product. Surfaces not to be treated should be masked and protected with polythylene. A strong ground sheet should be used to contain coating residue, product and rinse water. For further details, contact International Protective Coatings.

Oil or grease should be removed in accordance with SSPC-SP1 solvent cleaning using Interplus 546 degreaser.

Test Patch

It is strongly recommended that a small test patch should always be carried out on a representative area in order to ascertain the optimum application thickness and activation time required to successfully remove the rust deposits. Activation times are very much dependent upon the in situ rust level and condition, however, a typical working time is within 6 to 16 hours. The resultant rinse washings collected during removal should be analyzed by an independent laboratory to ensure disposal in accordance with local environmental legislation.

Application Conditions

Optimal working temperature range is 41 - 95°F (5 - 35°C), however, it can be used at temperatures as low as 32°F (0°C) and a maximum of 140°F (60°C).

For best results, it is advised to suitably cover the application area to reduce the effect of wind, rain and intense sunlight.

APPLICATION

Mixing	Mixing should not normally be required but if separation has occurred the product should be hand mixed until homogeneous.
Mix Ratio	Not applicable
Airless Spray	Suitable Apply through a 21 to 31 thou (0.53-0.79 mm) tip with a spray angle of between 65° and 80°. Pressure at spray tip should not exceed 1500 p.s.i. (105 kg/cm ²). High pressures are not required to apply a uniform coat. See Product Characteristics.
Air Spray (Pressure Pot)	Not suitable
Air Spray (Conventional)	Not suitable
Brush	Suitable Use a soft brush and apply evenly and generously. Typically 12.0 mils (300 microns) can be achieved.
Roller	Suitable Typically 10.0 mils (250 microns) can be achieved.
Thinner	Not recommended
Cleaner	Clean potable water
Work Stoppages	Product containers should be resealed to prevent drying out of the product.
Clean Up	Clean equipment immediately after use with water. Dispose of washing in accordance with local environmental legislation. Neutralizing and dilution with water may be required to meet local waste or sewage disposal requirements. Spills should be contained and disposed of under the same requirements.
Removal	High pressure water wash and/or steam cleaners improve removal rates and reduce water usage. Above 2000 p.s.i. pressure is advised for large areas and to aid removal of alkaline salts from steel substrates. Cleaned surfaces should be repainted as quickly as possible to prevent reoxidation.

**PRODUCT
CHARACTERISTICS**

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.

Typical working pressures for airless spray application are approximately 1500 p.s.i. (105kg/cm²). This allows both an even atomisation and film formation to be achieved. Excessive pressures should be avoided as this can lead to poor atomisation and film formation, thus reducing product efficiency.

The removal rate of rust deposits is dependent upon the thickness and uniformity of Interplus 614. Repeat applications may be required for areas where the rust level is high.

Test patching is recommended to determine activation time and removal efficiency prior to full application.

Any surrounding plastic and/or rubber materials should be masked off to prevent damage caused by long term exposure to Interplus 614.

When applying Interplus 614 in confined spaces, ensure adequate ventilation.

Interplus 614 should be applied and allowed to activate on the surface whereby a color change from blue to green takes place.

Treated areas should be wrapped in polyethylene where high temperature airflow or direct sunlight may cause drying out.

Treated surfaces should be overcoated as quickly as possible to prevent the onset of re-oxidation.

Interplus 614 does not remove millscale.

Interplus 614 must be protected from freezing at all times during storage.

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.

Low molecular weight reactive additives, which will form part of the film during normal ambient cure conditions, will also effect VOC values determined using EPA Method 24.

**SYSTEMS
COMPATIBILITY**

To ensure good overcoating of approved maintenance primers, it is important that the treated surface is free from all residue contamination and a thorough rinsing and wash down has been undertaken.

The surface should be clean and dry prior to overcoating with approved primers.

The following primers are approved for application direct to Interplus 614 treated surfaces:

Interplus 256
Interplus 356
Interseal 670HS
Interzone 954

**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.

For Health and Safety reasons this product must not be transferred out of its original packaging.

If in doubt regarding the suitability of use of this product, consult International Protective Coatings for further advice.

PACK SIZE

Unit Size

Vol Pack

20 liter 20 liter 20 liter

5 liter 5 liter 5 liter

For availability of other pack sizes contact International Protective Coatings

SHIPPING WEIGHT

Unit Size

20 liter 20 kg

5 liter 5 kg

U.N. Shipping No. Non Hazardous

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. Protect from freezing at all times during storage.

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 International Paint 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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