

PRODUCT DESCRIPTION

A single component, water based paint disbonder designed to remove coating residues from metallic substrates.

Can be described as readily biodegradable as tested by OECD 301B CO₂ Evolution test.

INTENDED USES

Interplus 634 is specifically designed to remove tightly adhering coating residues from metallic substrates prior to repainting with approved maintenance coatings. Coating residues include conventional epoxies, polyurethanes, alkyds, acrylics and water borne coatings.

Interplus 634 can be used where traditional surface preparation techniques, such as abrasive blasting, ultra high pressure hydroblasting or power tool methods are ruled out for operational, health & safety or environmental reasons.

PRACTICAL INFORMATION FOR INTERPLUS 634

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

REGULATORY DATA

Flash Point	>100°C (212°F)
Product Weight	1.01 kg/l (8.4 lb/gal)
VOC	3.60 lb/gal (432 g/lit) 392 g/kg

EPA Method 24
 EU Solvent Emissions Directive
 (Council Directive 1999/13/EC)

See Product Characteristics section for further details

**SURFACE
PREPARATION**

Prior to application of Interplus 634, any loose rust or loose coating residue should be removed to aid penetration of the product. Surfaces not to be treated should be masked and protected with polyethylene. A strong ground sheet should be used to contain coating residue, product and rinse water. For further details, contact International Protective Coatings.

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 coating residue. Activation times are very much dependent upon the in situ coating type and condition, however, a typical working time is within 6 to 16 hours. The resultant rinse washings collected during removal should be analysed by an independent laboratory to ensure disposal in accordance with local environmental legislation.

Application Conditions

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

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 0.53-0.79 mm (21 to 31 thou) tip with a spray angle of between 65 and 80°. Pressure at spray tip should not exceed 105 kg/cm ² (1500 p.s.i.). High pressures are not required to apply a uniform coat. See Product Characteristics.
Air Spray (Pressure Pot)	Not recommended	
Brush	Recommended	Typically 250 microns (10.0 mils) can be achieved
Roller	Recommended	Typically 250 microns (10.0 mils) can be achieved
Thinner	Not recommended	
Cleaner	Clean 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. Neutralising 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	A plastic (HDPE) or metal scraper should be used for residue removal prior to water rinsing. 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 105kg/cm² (1500 p.s.i.). 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.

When applying Interplus 634 by brush or roller, it may be necessary to apply multiple coats to achieve the required film build.

The removal rate of coating residues is dependent upon the thickness and uniformity of Interplus 634. Repeat applications may be required for high build, multi coat residues.

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 634.

Ensure the surface onto which Interplus 634 is to be applied is dry. Any surface moisture could hinder the penetration properties and prolong activation time.

When applying Interplus 634 in confined spaces ensure adequate ventilation.

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 634 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 colour and normal manufacturing tolerances.

**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 634 treated surfaces:

Intercure 202
Intergard 251
Interseal 670HS
Interzinc 52
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 litre	20 litre
	5 litre	5 litre
For availability of other pack sizes, contact International Protective Coatings.		
SHIPPING WEIGHT	Unit Size	
	20 litre	20.4 kg
	5 litre	5.1 kg
U.N. Shipping No. Non Hazardous		
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. Protect from freezing at all times during storage.

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 International Paint representative that this data sheet is current prior to using the product.

Issue date: 07/07/2009

Copyright © AkzoNobel, 07/07/2009.

 International and all product names mentioned in this publication are trademarks of, or licensed to, AkzoNobel.

www.international-pc.com