

**PRODUCT DESCRIPTION**

A one component, high build alkyd primer containing anticorrosive pigment.

**INTENDED USES**

For use as a general purpose maintenance primer primarily for the bridge market, for application to correctly prepared steel.

**PRACTICAL INFORMATION FOR INTERPRIME 234**

<b>Color</b>	Red, Off White, Gray
<b>Gloss Level</b>	Matte
<b>Volume Solids</b>	58% ± 2%
<b>Typical Thickness</b>	1.5-3.6 mils (38-89 microns) dry equivalent to 2.6-6.1 mils (66-153 microns) wet
<b>Theoretical Coverage</b>	465 sq.ft/US gallon at 2 mils d.f.t and stated volume solids 11.60 m <sup>2</sup> /liter at 50 microns d.f.t and stated volume solids
<b>Practical Coverage</b>	Allow appropriate loss factors
<b>Method of Application</b>	Airless Spray, Roller, Brush, Conventional Spray

**Drying Time**

<b>Temperature</b>	<b>Touch Dry</b>	<b>Hard Dry</b>	<b>Overcoating Interval with recommended topcoats</b>	
			<i>Minimum</i>	<i>Maximum</i>
41°F (5°C)	2 hours	16 hours	20 hours	Extended <sup>1</sup>
50°F (10°C)	2 hours	12 hours	12 hours	Extended <sup>1</sup>
77°F (25°C)	90 minutes	6 hours	6 hours	Extended <sup>1</sup>
95°F (35°C)	30 minutes	5 hours	5 hours	Extended <sup>1</sup>

<sup>1</sup> See International Protective Coatings Definitions & Abbreviations

**REGULATORY DATA**

<b>Flash Point</b>	99°F (37°C)
<b>Product Weight</b>	12.6 lb/gal (1.51 kg/l)
<b>VOC</b>	2.83 lb/gal (340 g/l)      EPA Method 24

See Product Characteristics section.

**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.

**Steel Substrates**

All bare steel surfaces should be cleaned by hand or power tool methods to SSPC SP2 or SSPC SP3. Care should be taken to avoid polishing the steel when using power tool methods.

**Previously Painted Surfaces**

Thoroughly clean and degrease. Remove all loose or flaking coatings, loose rust or other surface contamination using hand or power tool methods, to achieve SSPC SP2 or SSPC SP3 on bare areas.

**APPLICATION**

<b>Mixing</b>	This material is a one component coating and should always be mixed thoroughly with a power agitator before application.		
<b>Airless Spray</b>	Recommended	Tip Range 19-21 thou (0.475-0.533 mm) Total output fluid pressure at spray tip not less than 2005 psi (141 kg/cm <sup>2</sup> )	
<b>Air Spray (Conventional)</b>	Recommended	Gun	DeVilbiss MBC-510
		Air Cap	704
		Fluid Tip	E
<b>Brush</b>	Suitable		
<b>Roller</b>	Suitable	Use a short nap roller.	
<b>Thinner</b>	International GTA004	Not normally required. Do not thin more than allowed by local environmental legislation	
<b>Cleaner</b>	International GTA004		
<b>Work Stoppages</b>	Do not allow material to remain in hoses, gun or spray equipment. Thoroughly flush all equipment with International GTA004. 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.		
<b>Clean Up</b>	Clean all equipment immediately after use with GTA004. 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**

Apply in good climatic conditions. The temperature of the surface to be coated must be at least 5°F (3° C) above the dew point. Curing will be retarded if air and surface temperatures are below 41°F (5°C).

**CHARACTERISTICS**

Unmixed material (in closed containers) should be maintained in protected storage in accordance with information given in the Storage section of this datasheet

When used as part of an approved scheme, this material has the following certification:

- Fire Resistance - Surface Spread of Flame (WFR) - (IMO Resolution A653 (16))
- Fire Resistance - MSC61 (67) Smoke & Toxicity (WFR)

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**

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Interprime 234 may be overcoated with itself or the following topcoats;

Interlac 665  
Interlac 800  
Interprime 234

**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](http://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
	1 US gal	1 US gal	1 US gal
5 US gal	5 US gal	5 US gal	5 US gal
For availability of other pack sizes contact International Protective Coatings			
SHIPPING WEIGHT	Unit Size		
	1 US gal		14 lb
5 US gal		64.6 lb	
STORAGE	Shelf Life	24 months minimum at 40-100°F (4-38°C). Subject to re-inspection thereafter. Store in dry, shaded conditions away from sources of heat and ignition.	

**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.*

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