

**PRODUCT DESCRIPTION**

A two component, high performance industrial finish coat used over properly prepared and primed steel or masonry surfaces. Exhibits superior application and hiding properties, environmental durability and chemical resistance. Excellent gloss and color retention for exterior exposures.

**INTENDED USES**

A durable high gloss topcoat for transportation equipment, handrails, pipe racks, tank exteriors, structural steel and process vessel exteriors in chemical and petroleum facilities, coastal environments, water treatment plants, offshore structures, pulp and paper manufacturing facilities, power generation and highway infrastructure.

**PRACTICAL INFORMATION FOR INTERTHANE 870HS**

<b>Color</b>	Limited range via the Chromascan system
<b>Gloss Level</b>	Gloss
<b>Volume Solids</b>	65%
<b>Typical Thickness</b>	3-5 mils (75-125 microns) dry equivalent to 4.6-7.7 mils (115-192 microns) wet
<b>Theoretical Coverage</b>	261 sq.ft/US gallon at 4 mils d.f.t and stated volume solids 6.50 m <sup>2</sup> /liter at 100 microns d.f.t and stated volume solids
<b>Practical Coverage</b>	Allow appropriate loss factors
<b>Method of Application</b>	Airless Spray, Air Spray, Brush, Roller
<b>Drying Time</b>	

<b>Temperature</b>	<b>Touch Dry</b>	<b>Hard Dry</b>	<b>Overcoating Interval with recommended topcoats</b>	
			<i>Minimum</i>	<i>Maximum</i>
50°F (10°C)	3 hours	10 hours	10 hours	Extended <sup>1</sup>
59°F (15°C)	2 hours	8 hours	8 hours	Extended <sup>1</sup>
77°F (25°C)	1.5 hours	6 hours	6 hours	Extended <sup>1</sup>
104°F (40°C)	1.5 hours	4 hours	4 hours	Extended <sup>1</sup>

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

**REGULATORY DATA**

<b>Flash Point</b>	Part A 79°F (26°C); Part B 135°F (57°C); Mixed 79°F (26°C)
<b>Product Weight</b>	11.3 lb/gal (1.35 kg/l)
<b>VOC</b>	2.60 lb/gal (312 g/lit) 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.

**Primed Surfaces**

Interthane 870HS should always be applied over a recommended anti-corrosive coating scheme. The primer surface should be dry and free from all contamination, and Interthane 870HS must be applied within the overcoating intervals specified (consult the relevant product data sheet).

Areas of breakdown, damage etc., should be prepared to the specified standard (e.g. SSPC-SP6 or Sa2½ (ISO 8501 -1:2007), Abrasive Blasting, or SSPC-SP11, Power Tool Cleaning) and patch primed prior to the application of Interthane 870HS.

**APPLICATION**

<b>Mixing</b>	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.			
<b>Mix Ratio</b>	9 part(s) : 1 part(s) by volume			
<b>Working Pot Life</b>	50°F (10°C)	59°F (15°C)	77°F (25°C)	104°F (40°C)
	4 hours	3 hours	2 hours	45 minutes
<b>Airless Spray</b>	Recommended	Tip Range 15-21 thou (0.38-0.53 mm) Total output fluid pressure at spray tip not less than 2503 psi (176 kg/cm <sup>2</sup> )		
<b>Air Spray (Pressure Pot)</b>	Recommended	Gun	DeVilbiss MBC or JGA	
		Air Cap	704	
		Fluid Tip	E	
<b>Brush</b>	Suitable	Typically 2.0-3.0 mils (50-75 microns) can be achieved		
<b>Roller</b>	Suitable	Typically 2.0-3.0 mils (50-75 microns) can be achieved		
<b>Thinner</b>	International GTA013	Do not thin more than allowed by local environmental legislation		
<b>Cleaner</b>	International GTA013			
<b>Work Stoppages</b>	Do not allow material to remain in hoses, gun or spray equipment. Thoroughly flush all equipment with International GTA013. 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 International GTA013. 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**

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

For brush and roller application, and in some colors, two coats of Interthane 870HS may be required to give uniform coverage.

When surface temperatures are greater than 104°F (40°C) for periods of greater than 72 hours then pretreatment may be required before application of a further coat of Interthane 870HS. When recoating beyond 90 days at any surface temperature, additional surface preparation may be required. Contact International Protective Coatings for recommendations.

Application at excessively high relative humidity, or under conditions where condensation is likely to occur, may result in immediate or premature loss of gloss. Best results will always be obtained by applying with relative humidity less than 85% and with surface temperatures at least 5°F (3°C) above dew point.

Condensation occurring during or immediately after application may result in a matte finish and an inferior film.

If applying Interthane 870HS in enclosed maintenance conditions ensure adequate ventilation.

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 affect VOC values determined using EPA Method 24.

**SYSTEMS COMPATIBILITY**

---

The following primers/intermediates are recommended for Interthane 870HS:

Intercure 200	Interseal 670HS
Intercure 420	Interzinc 315
Intergard 251	Interzinc 42
Intergard 269	Interzinc 52
Intergard 475HS	Interzone 1000
Interplus 256	Interzone 505
Interplus 356	Interzone 954

Interthane 870HS is designed to be topcoated with itself.

For other suitable primers/intermediates/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](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.

**Warning: Contains isocyanate. Wear air-fed hood for spray application.**

PACK SIZE	Unit Size	Part A		Part B	
		Vol	Pack	Vol	Pack
	5 US gal	4.5 US gal	5 US gal	0.5 US gal	0.5 US gal
For availability of other pack sizes contact International Protective Coatings					
SHIPPING WEIGHT	Unit Size	Part A		Part B	
		56 lb		4.6 lb	
	5 US gal	56 lb		4.6 lb	
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.			

**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.*

Copyright © AkzoNobel, 8/21/2009.

 **International** Copyright © AkzoNobel, 8/21/2009.

[www.international-pc.com](http://www.international-pc.com)