

# Interplus 880

Surface Tolerant Polyurethane

**Product Description** A low VOC, two component high solids flexible aliphatic surface tolerant polyurethane primer, intermediate or finish capable of producing high build films.

**Intended Uses** Primarily as a high performance single coat industrial maintenance coating to upgrade any tightly adhering existing coating to a longer life durable system.

For use in a wide variety of aggressive environments, including those found in chemical plants, refineries, pulp and paper mills and on bridges.

Capable of providing superior gloss and colour retention particularly when compared to epoxy based finishes and will cure at temperatures down to -5°C (23°F).

May be applied to steel surfaces where it is not possible to abrasive blast.

**Practical Information for Interplus 880**

**Colour** Wide range via the Chromascan system

**Gloss Level** Semi Gloss

**Volume Solids** 80% ± 3% (depends on colour)

**Typical Thickness** 75-125 microns (3-5 mils) dry equivalent to 94-156 microns (3.75-6.25 mils) wet

**Theoretical Coverage** 8.00 m<sup>2</sup>/litre at 100 microns d.f.t and stated volume solids  
321 sq.ft/US gallon at 4 mils 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	
			<i>Minimum</i>	<i>Maximum</i>
5°C (41°F)	3 hours	8 hours	8 hours	Extended*
15°C (59°F)	90 minutes	3 hours	3 hours	Extended*
25°C (77°F)	60 minutes	2 hours	2 hours	Extended*
40°C (104°F)	30 minutes	45 minutes	45 minutes	Extended*

\* See International Protective Coatings Definitions and Abbreviations

**Regulatory Data**

**Flash Point** Base (Part A) 32°C (90°F) C/A (Part B) 51°C (124°F) Mixed 36°C (97°F)

**Product Weight** 1.56-1.77 kg/l (13.02-14.77 lb/gal)

**VOC** 180 g/l UK - PG6/23(92), Appendix 3  
1.58 lb/gal (190 g/l) USA - EPA Method 24

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## 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 8504:1992.

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.

### Abrasive Blast Cleaning

Abrasive blast clean to Sa2½ (ISO 8501-1:1988) or SSPC-SP6. If oxidation has occurred between blasting and application of Interplus 880, the surface should be reblasted to the specified visual standard.

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

### Power Tool Preparation

Power tool clean to a minimum St3 (ISO 8501-1:1988) or SSPC-SP3.

Note, all scale must be removed and areas which cannot be prepared adequately by chipping or needle gun should be spot blasted to a minimum standard of Sa2 (ISO 8501-1:1988) or SSPC-SP6. Typically this would apply to C or D grade rusting in this standard.

### Aged Coatings

Interplus 880 is suitable for overcoating aged coatings which show good adhesion. Loose or flaking coatings should be removed back to a firm edge.

Existing epoxy or polyurethane systems which are glossy may require abrasion to ensure good intercoat adhesion.

See Product Characteristics section for further information.

## 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>	4 parts : 1 part by volume			
<b>Working Pot Life</b>	5°C (41°F) 3 hours	15°C (59°F) 2 hours	25°C (77°F) 1 hour	40°C (104°F) 30 minutes
<b>Airless Spray</b>	Recommended	- Tip range 0.45-0.58 mm (18-23 thou) - Total output fluid pressure at spray tip not less than 141 kg/cm <sup>2</sup> (2,000 p.s.i.)		
<b>Air Spray (Pressure Pot)</b>	Recommended	Gun	DeVilbiss MBC or JGA	
		Air Cap	704 or 765	
		Fluid Tip	E	
<b>Brush</b>	Recommended	Typically 50-75 microns (2-3 mils) can be achieved		
<b>Roller</b>	Recommended	Typically 50-75 microns (2-3 mils) can be achieved		
<b>Thinner</b>	International GTA007	Do not thin more than allowed by local environmental legislation.		
<b>Cleaner</b>	International GTA007			
<b>Work Stoppages</b>	Do not allow material to remain in hoses, gun or spray equipment. Thoroughly flush all equipment with International GTA007. 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 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.			

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## Product Characteristics

In order to ensure good anti-corrosive performance, it is important to achieve a minimum system dry film thickness of 200 microns (8 mils) by application of multi-coats over hand prepared steel. On hand prepared rusty steel and in severe environments patch prime with Interplus 256 or Interplus 356.

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. Application by air spray may require a multiple cross spray pattern to attain maximum film build. Low or high temperatures may require specific application techniques to achieve maximum film build.

When applying Interplus 880 by brush or roller, it may be necessary to apply multiple coats to achieve the total specified system dry film thickness.

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

For brush and roller application, and in some colours, two coats of Interplus 880 may be required to give uniform coverage.

Do not apply under low temperature conditions where condensation is probable, this will cause gloss loss and may detract from long term performance. Maximum RH recommended for application is 85%.

Over-application may result in foaming and microblistering.

Interplus 880 is formulated for maximum compatibility with old coatings and as such it does not have the properties normally associated with aliphatic polyurethane finishes. It is more flexible and does not exhibit the hardness of conventional coatings, making the product eminently suitable for maintenance painting. It is not recommended for factory application.

Interplus 880 must be fully cured before exposure to ponding water otherwise adhesion loss can occur.

Ensure good ventilation is present during application of Interplus 880 and topcoating systems, this may necessitate the use of forced ventilation when objects are encapsulated such as storage tanks and bridges.

Curing will occur at low temperatures.

Temperature	Touch Dry	Hard Dry	Overcoating interval with recommended topcoats	
			<i>Minimum</i>	<i>Maximum</i>
-5°C (23°F)	16 hours	24 hours	24 hours	Extended*
0°C (32°F)	9 hours	16 hours	16 hours	Extended*

\* See International Protective Coatings Definitions and Abbreviations

Interplus 880 is not designed for continuous water immersion.

## Systems Compatibility

Interplus 880 is suitable for overcoating all sound aged coatings but is not generally recommended for direct application to zinc silicate (e.g. Interzinc 22) or zinc epoxy (e.g. Interzinc 52).

The following primers are recommended for Interplus 880:

Intercure 200	Interplus 256
Intercure 420	Interplus 356
Intergard 251	Interplus 770
Intergard 269	Interplus 880
Intergard 475 HS	Interseal 670 HS

The following topcoats are recommended for Interplus 880:

Interplus 880  
Interthane 990

It should be noted, Interplus 880 is not suitable for overcoating with alkyd, chlorinated rubber, vinyl or acrylic finishes.

For other suitable primers/topcoats consult International Protective Coatings.

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## Additional Information

Further information regarding industry standards, terms and abbreviations used in this data sheet can be found in the following sections of the International Protective Coatings data manual:

- 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.**

<b>Pack Size</b>	20 litre unit	Interplus 880 Base	16 litres in a 20 litre container
		Interplus 880 Curing Agent	4 litres in a 5 litre container
	5 gallon unit	Interplus 880 Base	4 gallons in a 5 gallon container
		Interplus 880 Curing Agent	1 gallons in a 5 gallon container
For availability of other pack sizes contact International Protective Coatings			
<b>Shipping Weight</b>	U.N. Shipping No. 1263		
	20 litre unit	31.1 kg (68.6 lb) Base (Part A)	5.0 kg (11.0 lb) Curing Agent (Part B)
	5 gallon unit	29.9 kg (66.1 lb) Base (Part A)	4.7 kg (10.3 lb) Curing Agent (Part B)
<b>Storage</b>	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.		

## Disclaimer

*The information given in this sheet is not intended to be exhaustive and any person using the product for any purpose other than that specifically recommended in this sheet without first obtaining written confirmation from us as to the suitability of the product for the intended purpose does so at his own risk. Any warranty, if given, or specific Terms & Conditions of Sale are contained in International's Terms & Conditions of Sale, a copy of which can be obtained on request. Whilst we endeavour to ensure that all advice we give about the product (whether in this sheet or otherwise) is correct we have no control over either the quality or 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 whatsoever or howsoever arising for the performance of the product or for any loss or damage (other than death or personal injury resulting from our negligence) arising out of the use of the product. The information contained in this sheet is liable to modification from time to time in the light of experience and our policy of continuous product development.*

*It is the user's responsibility to check that this sheet is current prior to using the product. Issue date: 1st June 1997*

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## International Protective Coatings

### World Centre

50 George Street  
London W1A 2BB  
England

### Asia Region

3 Neythal Road  
Jurong Town  
Singapore 628570

### Australasia Region

115 Hyde Road  
Yeronga  
Brisbane  
Queensland  
Australia

### Europe Region

50 George Street  
London W1A 2BB  
England

### Middle East Region

PO Box 37  
Dammam 31411  
Saudi Arabia

### North America Region

6001 Antoine Drive  
Houston  
Texas 77091

### South America Region

Rua Gomes de Carvalho, 1356,  
15° Andar, Vila Olimpia,  
São Paulo, S.P.  
CEP: 04547-005  
Brazil

Tel: (44) 171 612 1400 Tel: (65) 663 3066  
Fax: (44) 171 612 1561 Fax: (65) 266 5287

Tel: (61) 7 3892 8866  
Fax: (61) 7 3892 4287  
H&S (61) 1800 807 001

Tel: (44) 171 612 1410 Tel: (966) 3 842 8436  
Fax: (44) 171 612 1555 Fax: (966) 3 842 4361

Tel: (1) 713 682 1711  
Fax: (1) 713 684 1327

Tel: (011) 3044 0344  
Fax: (011) 3044 0322

### Local Office:

Tel: 0191 469 6111 Fax: 0191 495 0676