



460IF ISOFREE TECHNICAL DATA SHEET

Non-yellowing, fast curing, isocyanate-free two-component acrylic coating. UV stabilised with exterior durability and chemical resistance comparable to industrial two-component polyurethane coatings.

PROPERTIES

Item	Detail
Product Type	Isocyanate free Acrylic based 2 Pack coating
Mixing Ratio	Four parts IsoFree base colour to one part Hardener (400IF-0001 by volume)
Colours	Can be tinted to most colours
Gloss Level	Full Gloss, Semi-Gloss
Thinning / Clean Up	Universal Thinner 101UT-0001
Coverage	Theoretical 15–20 m ² /L Practical 6–8 m ² /L (spray)
Specific Gravity	1.10 – 1.25 Kg/L
Weight Solids	55 – 65 %
Volume Solids	40 – 50 %
Container Size	4 L, 16 L
Exterior Exposure	Excellent
Recoat Time	12 hours
Drying Time	Tack free upto 1 hr. Force cure at 50°C for 30–60 minutes if required.

TYPICAL USES

Used as a substitute for isocyanate cured polyurethane coatings. Suitable for cars, trucks, buses, boats, farming machinery and earthmoving equipment.

RECOATING/COMPATIBILITIES

Recoat overnight and sand between coats. May be applied over 2k Epoxies, 2k Polyurethane and Polyester primers. It is advised to pre-test on other brands for suitability prior using. May also be applied over single pack etch primer 120PE Etch Primer.

LIMITATIONS

Do not apply to wet or contaminated substrates. Not suited for direct to metal use, must be applied over compatible primers. Always complete a test patch.

APPLICATION

EQUIPMENT

- Conventional spray gun
- HVLP Spray Gun
- Airless
- Air Assisted Airless

RECOMMENDED SPRAY EQUIPMENT PARAMETERS – 400IF

Spray method	Recommended nozzle / tip size	Typical spray pressure	Viscosity* (DIN 4 @ 25°C)
Conventional (gravity or suction feed)	1.4 – 1.8 mm	3.0 – 4.0 bar (300–400 kPa / 45–60 psi)	20 – 25 sec
HVLP / RP	1.4 – 1.6 mm	2.0 – 3.0 bar (200–300 kPa / 30–45 psi)	20 – 25 sec
Airless	0.007" – 0.011" (≈ 15–17 thou)	100 – 140 bar (10–14 MPa)	25 – 30 sec
Air-assisted airless (AAA)	0.007" – 0.011" Pump Ratio 32:1	70 – 100 bar fluid pressure (with air assist)	25 – 30 sec

*Viscosity measured after mixing and induction, adjusted only if required using the recommended reducer.

SUBSTRATE

- LOW CHROMIUM FERROUS METAL (MILD STEEL, CARBON STEEL, CAST IRON)

SURFACE PREPARATION

Prepare surfaces in accordance with AS1627.1 and AS1627.4 Class 2.5 with a blast profile of 40–70 microns.

- Ensure surface is free from dirt and grease or metal scale.
- Round off all welds and sharp edges. Grind off any weld spatter and remove grease, oil, and other contaminants in accordance with AS1627.1. Prepare metal surface by mechanical sanding or abrasive blast clean to a minimum of AS1627.4 Class 2.5 with a blast profile of 40 – 70 micron. Remove all dust or contaminants by brushing or vacuum cleaning.
- Solvent wipe using approved Wax and Grease Remover (101WG).

PAINTING

1. Prime surface with 120PE Etch Primer or 460EP Epoxy (Follow data sheet guidelines).
 2. Mix 4 parts 400IF IsoFree Topcoat with 1-part 400HD Hardener by volume and stir well.
 3. Spray apply 400IF IsoFree to achieve a Dry Film Build (dft.) of 40 – 60-micron and allow 12 hours cure.
 4. Sand with fine wet/dry grit paper and repeat steps 2. and 3. to achieve a final primed film build of 100 – 150-micron dft.
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- NON-FERROUS METAL (GALVANISED STEEL, ALUMINIUM, STAINLESS STEEL, ZINCALUME, ZINC RICH PRIMED SURFACES)

SURFACE PREPARATION

Fresh galvanised steel should be allowed to weather for a minimum of 40 days before coating. Never abrade off the oxidized zinc layer.

1. Ensure surface is free from dirt and grease. Clean by brushing off dirt and grime then solvent wiping using **101WG Wax and Grease Remover** do not abrade the surface.
 2. Prime with **120EP Etch Primer**. (Follow data sheet recommendations).
 3. Mix 4 parts 400IF IsoFree Topcoat with 1-part 400HD Hardener by volume and stir well.
 4. Spray apply 400IF IsoFree to achieve a Dry Film Build (dft.) of 40 – 60-micron and allow 12 hours cure. Sand with fine wet/dry grit paper and repeat steps 2. and 3. Achieving a final primed film build of 100 – 150-micron dft.
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SAFETY INFORMATION

Prior to use, users must review the current Safety Data Sheet (SDS) for this product and all associated components. The SDS provides essential information regarding safe handling, storage, mixing, application, personal protective equipment (PPE), ventilation requirements, and emergency procedures. Appropriate PPE must be always worn, including respiratory protection where spraying is undertaken. Ensure adequate ventilation during application and curing. This product is intended for professional use only, and all handling and application must comply with relevant workplace health and safety regulations. Failure to follow SDS recommendations may result in personal injury or health risks.

DISCLAIMER AND LIABILITY

All information provided is based on current knowledge and is given in good faith. Product performance depends on correct surface preparation, application methods, substrate condition, and site conditions, which are beyond the control of Intec Coatings Pty Ltd. No warranty or guarantee, express or implied, is given regarding performance in any specific application. The user is responsible for determining product suitability and for ensuring application is carried out in accordance with this Technical Data Sheet and relevant standards. To the maximum extent permitted by law, Intec Coatings Pty Ltd accepts no liability for loss or damage arising from the use or misuse of this product. Nothing in this disclaimer excludes rights available under the Australian Consumer Law.

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