

PRODUCT DESCRIPTION

Two component solvent based inorganic zinc rich ethyl silicate based primer.

Conforms to AS/NZS 3750.15 Type 4.

INTENDED USES

As a zinc primer to provide excellent protection to steel substrates, for use with a wide range of high performance systems in offshore and onshore environments including oil production platforms, refineries, bridges, tanks, pipework and structural steel.

Ideal for giving long term protection to structural steel prior to field topcoating.

Can be used for new construction and as a fast drying primer, capable of application in a wide range of climatic conditions including low temperatures.

PRACTICAL INFORMATION FOR INTERZINC 215

Colour	Grey
Gloss Level	Matt
Volume Solids	60%
Typical Thickness	65-90 microns (2.6-3.6 mils) dry equivalent to 108-150 microns (4.3-6 mils) wet
Theoretical Coverage	8 m ² /litre at 75 microns d.f.t and stated volume solids 321 sq.ft/US gallon at 3 mils d.f.t and stated volume solids
Practical Coverage	Due to the porous nature of inorganic silicate coatings practical coverage is based upon generally accepted industry figures for this type of coating of up to 5.5 m ² /litre depending upon configuration of the work.
Method of Application	Airless Spray, Air Spray

Drying Time

Temperature	Touch Dry	Hard Dry	Overcoating Interval with recommended topcoats	
			Minimum	Maximum
10°C (50°F)	20 minutes	1 hour	72 hours	Extended ¹
15°C (59°F)	15 minutes	1 hour	60 hours	Extended ¹
25°C (77°F)	10 minutes	1 hour	36 hours	Extended ¹
40°C (104°F)	5 minutes	30 minutes	18 hours	Extended ¹

¹ See International Protective Coatings Definitions and Abbreviations

Overcoating is dependent upon ambient conditions. The figures quoted above have been determined at the quoted dry film thickness, temperature and 65% relative humidity. See Product Characteristics for further advice.

REGULATORY DATA

Flash Point	Part A >10°C (50°F); Part B N/A; Mixed >10°C (50°F)	
Product Weight	2.16 kg/l (18.0 lb/gal)	
VOC	484 g/l	PG6/23(92), Appendix 3

See Product Characteristics section for further details

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.

Oil or grease should be removed in accordance with SSPC-SP1 solvent cleaning.

Abrasive Blast Cleaning

Abrasive blast clean to Sa2½ (ISO 8501-1:2007) or SSPC-SP6. If oxidation has occurred between blasting and application of Interzinc 215, 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.

A surface profile of 40-75 microns (1.6-3.0 mils) is recommended.

Shop Primed Steel

Interzinc 215 is suitable for application to steelwork freshly coated with zinc silicate shop primers.

If the zinc shop primer shows extensive or widely scattered breakdown, or excessive zinc corrosion products, overall sweep blasting will be necessary. Other types of shop primer are not suitable for overcoating and will require complete removal by abrasive blast cleaning.

Weld seams and damaged areas should be blast cleaned to Sa2½ (ISO 8501-1:2007) or SSPC-SP6.

APPLICATION

Mixing	Interzinc 215 is supplied in 2 parts, a liquid Binder base component (Part A) and a Powder component (Part B). The Powder (Part B) should be slowly added to the liquid Binder (Part A) whilst stirring with a mechanical agitator. DO NOT ADD LIQUID TO POWDER. Material should be filtered prior to application and should be constantly agitated in the pot during spraying. Once the unit has been mixed it should be used within the working pot life specified.			
Mix Ratio	4.26 part(s) : 1 part(s) by volume			
Working Pot Life	10°C (50°F) 12 hours	15°C (59°F) 8 hours	25°C (77°F) 4 hours	40°C (104°F) 2 hours
Airless Spray	Recommended	Tip Range 0.38-0.53 mm (15-21 thou) Total output fluid pressure at spray tip not less than 112 kg/cm ² (1593 p.s.i.) A 9 mm (0.375") fluid hose of maximum 15 metres (49 ft) is recommended.		
Air Spray (Pressure Pot)	Recommended	Gun Air Cap Fluid Tip	DeVilbiss MBC or JGA 704 or 765 E	
Brush	Not recommended			
Roller	Not recommended			
Thinner	International GTA803 (or International GTA415)			
Cleaner	International GTA803 (or International GTA415)			
Work Stoppages	Do not allow material to remain in hoses, gun or spray equipment. Thoroughly flush all equipment with International GTA803. 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.			
Clean Up	Clean all equipment immediately after use with International GTA803. 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

Interzinc 215 should be applied by spray. Application by other methods, e.g. brush may require more than one coat and should only be used for small areas, stripe coats or touch up.

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

When applying Interzinc 215 in confined spaces ensure adequate ventilation.

Prior to overcoating, Interzinc 215 must be clean, dry and free from both soluble salts and excessive zinc corrosion products.

The minimum overcoating interval is dependent upon the ambient temperature and relative humidity during application and curing period.

It is recommended that prior to overcoating a solvent rub test to ASTM D4752 should be undertaken. A value of 4 indicates a satisfactory degree of cure for overcoating purposes.

At relative humidities below 50%, curing will be severely retarded and humidity may need to be increased by steam or water spraying. If this can not be accommodated then consideration should be given to the use of waterborne zinc silicates e.g. Interzinc 685.

Excessive film thickness and/or over-application of Interzinc 215 can lead to mudcracking, which will require complete removal of the affected areas by abrasive blasting and re-application in accordance with the original specification.

Dry times are given for typical thickness. Film builds above this will yield slower overcoat times.

For high temperature systems the thickness of Interzinc 215 should be restricted to 50 microns (2 mils) d.f.t. Continuous dry temperature resistance of Interzinc 215 is 400°C (752°F) if left untopcoated, however, if this product is used as a primer for Intertherm 50, the dry temperature resistance will be 540°C (1004°F).

Untopcoated Interzinc 215 is not suitable for exposure in acid or alkaline conditions or continuous water immersion.

Friction grip bolting friction grip factor is 0.50

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

When it is necessary for Interzinc 215 to be overcoated by itself due to low dry film thickness, the coating surface must be fresh and unweathered. A minimum of 50 microns (2 mils) d.f.t. of any subsequent coat of Interzinc 215 is needed to ensure good film formation. Alternatively, repairs to Interzinc 215 may be made using Interzinc 52.

Before overcoating with recommended topcoats ensure the Interzinc 215 is fully cured (see above) and if weathering has occurred all zinc salts should be removed from the surface by fresh water washing, and if necessary, scrubbing with bristle brushes.

Recommended topcoats/intermediates are:

Intercryl 530	Intergard 475
Intercure 200	Intergard 475HS
Intercure 420	Intertherm 50
Intergard 251	

In some cases it may be necessary to apply a mist coat of the topcoat to minimise bubbling. This will depend upon the age of the Interzinc 215, surface roughness and ambient conditions during curing and application. Alternatively an epoxy sealer, such as Intergard 251 can be used to reduce bubbling problems.

For other suitable topcoats/intermediates, 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:

- 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	Part A		Part B	
		Vol	Pack	Vol	Pack
	20 litre	16.2 litre	20 litre	27.06 kg	15 litre
	5 US gal	4.05 litre	5 US gal	56.4 lb	1 US gal
For availability of other pack sizes, contact International Protective Coatings.					
SHIPPING WEIGHT	Unit Size	Part A		Part B	
		Vol	Pack	Vol	Pack
	20 litre	18.2 kg		29 kg	
	5 US gal	37.9 lb		60.6 lb	
U.N. Shipping No. Non Hazardous					
STORAGE	Shelf Life	6 months minimum at 25°C (77°F). 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 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.

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