

Epoxy Zinc-Rich

PRODUCT DESCRIPTION

A two component, metallic zinc rich epoxy primer formulated to provide fast drying, rapid handling properties and excellent abrasion resistance.

INTENDED USES

As a high performance anti-corrosive primer to form part of a coating system to provide corrosion protection to steel substrates in a wide range of industrial situations including offshore structures, cranes, petrochemical refineries, chemical plants, pulp and paper plants and bridges.

PRACTICAL INFORMATION FOR INTERZINC 109

Colour	Grey
Gloss Level	Matt
Volume Solids	60%
Typical Thickness	50-75 microns (2-3 mils) dry equivalent to 83-125 microns (3.3-5 mils) wet
Theoretical Coverage	12 m ² /litre at 50 microns d.f.t and stated volume solids 481 sq.ft/US gallon at 2 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	
			Minimum	Maximum
10°C (50°F)	45 minutes	5 hours	5 hours	Extended ¹
15°C (59°F)	40 minutes	3 hours	3 hours	Extended ¹
25°C (77°F)	30 minutes	2 hours	3 hours	Extended ¹
40°C (104°F)	20 minutes	1 hour	1 hour	Extended ¹

¹ See International Protective Coatings Definitions and Abbreviations

REGULATORY DATA

Flash Point (Typical)	Part A 32°C (90°F); Part B 26°C (79°F); Mixed 26°C (79°F)	
Product Weight	2.82 kg/l (23.5 lb/gal)	
VOC	143 g/kg	EU Solvent Emissions Directive (Council Directive 1999/13/EC)

See Product Characteristics section for further details

Epoxy Zinc-Rich

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 109, 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.

Shop Primed Steel

Interzinc 109 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	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.	
Mix Ratio	5 part(s) : 1 part(s) by volume		
Working Pot Life	10°C (50°F) 4 hours	15°C (59°F) 3 hours	25°C (77°F) 40°C (104°F) 2 hours 1 hour
Airless Spray	Recommended	Tip Range 0.43-0.53 mm (17-21 thou) Total output fluid pressure at spray tip not less than 141 kg/cm ² (2005 p.s.i.)	
Air Spray (Pressure Pot)	Recommended	Gun Air Cap Fluid Tip	DeVilbiss MBC or JGA 704 or 765 E
Brush	Suitable - small areas only	Typically 50 microns (2.0 mils) can be achieved	
Roller	Suitable - small areas only	Typically 50 microns (2.0 mils) can be achieved	
Thinner	International GTA220	Do not thin more than allowed by local environmental legislation	
Cleaner	International GTA822		
Work Stoppages	Do not allow material to remain in hoses, gun or spray equipment. Thoroughly flush all equipment with International GTA822. 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 GTA822. 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.		

Epoxy Zinc-Rich

PRODUCT CHARACTERISTICS

Care should be exercised to avoid over-application, which may result in cohesive film failure with subsequent high builds, and to avoid dry spray which can lead to pinholing of subsequent coats. Over-application will also result in slower curing and extended handling and overcoating times.

This product must only be thinned using recommended International GTA220 thinners. The use of alternative thinners, particularly those containing ketones, can severely inhibit the curing mechanism of the coating.

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

Interzinc 109 is not designed for continuous water immersion.

Prior to overcoating, Interzinc 109 must be clean, dry and free from zinc salts.

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

Interzinc 109 is designed for use over correctly prepared blasted steel, but can be applied over approved preconstruction primers.

Recommended topcoats are:

Intergard 400
Intergard 410
Intergard 475HS
Intergard 540

For other suitable primers/topcoats, consult International Protective Coatings.

Epoxy Zinc-Rich

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	16.67 litre	20 litre	3.33 litre	5 litre
For availability of other pack sizes, contact International Protective Coatings.					
SHIPPING WEIGHT (TYPICAL)	Unit Size	Part A		Part B	
		kg		kg	
	20 litre	55.2		3.5	
STORAGE	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.			

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 representative that this data sheet is current prior to using the product.

This Technical Data Sheet is available on our website at www.international-marine.com or www.international-pc.com, and should be the same as this document. Should there be any discrepancies between this document and the version of the Technical Data Sheet that appears on the website, then the version on the website will take precedence.

Issue date: 05/02/2015

Copyright © AkzoNobel, 05/02/2015.

All trademarks mentioned in this publication are owned by, or licensed to, the AkzoNobel group of companies.

www.international-pc.com