

Zinc Silicate Shop Primer

PRODUCT DESCRIPTION A two pack, zinc silicate shop (pre-construction) primer providing good corrosion protection even after heating upto 800°C and resistance to damage caused by welding, gas cutting and fairing. Suitable for fast welding processes and offers control of secondary surface preparation requirements.

INTENDED USES As a shop (pre-construction) primer for the protection of steel during fabrication and assembly. Suitable for use with controlled cathodic protection. For use at Newbuilding.

PRODUCT INFORMATION	Colour	NQA856-Grey , other colours may be available in specific countries - see Worldwide Availability section
	Finish/Sheen	Matt
	Part B (Curing Agent)	NQA857
	Volume Solids	25% ±2% (ISO 3233:1998)
	Mix Ratio	0.67 volume(s) Part A to 1 volume(s) Part B
	Typical Film Thickness	15 microns dry (60 microns wet)
	Theoretical Coverage	16.7 m ² /litre at 15 microns dft, allow appropriate loss factors
	Method of Application	Airless Spray, Brush, Conventional Spray, Roller
	Flash Point (Typical)	Part A 5°C; Part B 10°C; Mixed 13°C
	Induction Period	Not required

Drying Information	5°C		10°C		25°C		35°C	
	Hard Dry [ISO 9117-1:2009]					5 mins		4 mins
Pot Life	24 hrs		24 hrs		24 hrs		8 hrs	

Overcoating Data - see limitations	Substrate Temperature							
	5°C		10°C		25°C		35°C	
Overcoated By	Min	Max	Min	Max	Min	Max	Min	Max

Note Consult International Paint, minimum of 7 days for appropriate primers.

REGULATORY DATA	VOC	628 g/lit as supplied (EPA Method 24) 472 g/kg of liquid paint as supplied. EU Solvent Emissions Directive (Council Directive 1999/13/EC)
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Note: VOC values are typical and are provided for guidance purposes only. These may be subject to variation depending on factors such as differences in colour and normal manufacturing tolerances.

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CERTIFICATION

When used as part of an approved scheme, this material has the following certification:

- Weld Quality - Shop Primers for Corrosion Protection of Steel Plates and Structures (DNV)
- Weld Quality - Approval of Prefabrication Primers (LR)

Consult your International Paint representative for details.

SYSTEMS AND COMPATIBILITY

Consult your International Paint representative for the system best suited for the surfaces to be protected.

SURFACE PREPARATIONS

Use in accordance with the standard Worldwide Marine Specifications.
All surfaces to be coated should be clean, dry and free from contamination.

NEWBUILDING

Shop primers should be applied using automatic blasting/spraying equipment.

Blast to a minimum of Sa2½ (ISO 8501-1:2007). Steel grit or a mixture of steel grit of particle size 0.6-1.0mm and steel shot of particles size 0.6-1.4mm are normally used to give a predominantly angular profile.

Apply Interplate 855 before oxidation occurs. If oxidation does occur the entire oxidised area should be reblasted to the standard specified above.

Ensure that the area is clean and dry prior to application of Interplate 855.

Consult your International Paint representative for specific recommendations.

NOTE

**For use in Marine situations in North America, the following surface preparation standards can be used:
SSPC-SP10 in place of Sa2½ (ISO 8501-1:2007)**

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APPLICATION

Mixing	Material is supplied in 2 containers as a unit. Always mix a complete unit in the proportions supplied. Agitate Paste (Part A) with a power agitator, slowly add binder (Part B) while agitating. Allow to mix for at least 5 minutes, sieve through a 30-60 mesh screen before use. Continue stirring during use.
Thinner	GTA820 (Winter Grade), GTA840 (Summer Grade) Not recommended. Use International GTA820, GTA840 only in exceptional circumstances (max 15% by volume). DO NOT thin more than allowed by local environmental legislation.
Airless Spray	Recommended Tip Range 0.38-0.58 mm (15-23 thou) Total output fluid pressure at spray tip not less than 60 - 100 kg/cm ² (850 - 1420 p.s.i.)
Conventional Spray	Use suitable proprietary equipment. Thinning may be required.
Brush	Application by brush is recommended for small areas only. Multiple coats may be required to achieve specified film thickness.
Roller	Application by roller is recommended for small areas only. Multiple coats may be required to achieve specified film thickness.

Cleaner International GTA820/GTA840

Work Stoppages and Cleanup Do not allow material to remain in hoses, gun or spray equipment. Thoroughly flush all equipment with International GTA820/GTA840. 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 all equipment immediately after use with International GTA820/GTA840. 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, relative humidity and elapsed time, including any delays. Do not exceed pot life limitations.
All surplus materials and empty containers should be disposed of in accordance with appropriate regional regulations/legislation.

Welding 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. In North America do so in accordance with instruction in ANSI/ASC Z49.1 "Safety in Welding and Cutting."

SAFETY **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.**

Prior to use, obtain, consult and follow the Material Safety Data Sheet for this product concerning health and safety information. Read and follow all precautionary notices on the Material Safety Data Sheet and container labels. If you do not fully understand these warnings and instructions or if you can not strictly comply with them, do not use this product. Proper ventilation and protective measures must be provided during application and drying to keep solvent vapour concentrations within safe limits and to protect against toxic or oxygen deficient hazards. Take precautions to avoid skin and eye contact (ie. gloves, goggles, face masks, barrier creams etc.) Actual safety measures are dependant on application methods and work environment.

EMERGENCY CONTACT NUMBERS:

USA/Canada - Medical Advisory Number 1-800-854-6813

Europe - Contact (44) 191 4696111. For advice to Doctors & Hospitals only contact (44) 207 6359191

R.O.W. - Contact Regional Office

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LIMITATIONS

Drying times will depend on the substrate temperature and ventilation conditions.
 If the relative humidity is below 50%, cure will be retarded.
 Interplate 855 is not recommended for manual spray application.
 At higher dry film thickness, fabrication properties (welding and cutting) may be affected.
 Shop primers are not recommended for use as touch-up primers after fabrication.

Overcoating information is given for guidance only and is subject to regional variation depending upon local climate and environmental conditions. Consult your local International Paint representative for specific recommendations. The temperature of the surface to be coated must be at least 3°C above the dew point. For optimum application properties bring the material to 21-27°C, unless specifically instructed otherwise, prior to mixing and application. Unmixed material (in closed containers) should be maintained in protected storage in accordance with the information given in the STORAGE section of this data sheet.

Technical and application data herein is for the purpose of establishing a general guideline of the coating and proper coating application guidelines. Test performance results were obtained in a controlled laboratory environment and International Paint makes no claim that the exhibited published test results, or any other tests, accurately represent results actually found in all field environments. As application, environmental and design factors can vary significantly, due care should be exercised in the selection, verification of performance and use of the coating.

UNIT SIZE	Unit Size	Part A		Part B	
		Vol	Pack	Vol	Pack
	20 lt	8 lt	20 lt	12 lt	15 lt

For availability of other unit sizes consult International Paint

UNIT SHIPPING WEIGHT (TYPICAL)	Unit Size	Unit Weight
	20 lt	26.2 Kg

STORAGE	Shelf Life	Low flash storage required. Part A - 12 months minimum from date of manufacture when maintained in protected storage at temperatures up to 25°C. Part B - 6 months minimum from date of manufacture at temperatures up to 25°C. Subject to reinspection thereafter. Store in dry, shaded conditions away from sources of heat and ignition.

WORLDWIDE AVAILABILITY NQA855 - Red (Europe only), NQA858 - Dark Green (Mercosul - Argentina, Brazil, Chile & Uruguay only), consult International Paint.

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.

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