

Interzinc 315

Rapid Recoat Epoxy Zinc-Rich

WORLD WIDE PRODUCT RANGE

Product Description

A two component high solids, low VOC metallic zinc-rich epoxy primer formulated on proprietary polymer technology which provides rapid cure and overcoating even under low temperature conditions.

Intended Uses

As a zinc-rich primer to form part of a coating system to provide corrosion protection for steel substrates, for use in a wide range of industrial situations including offshore, petrochemical and chemical plants, refineries, pulp and paper plants, and bridges.

The rapid curing and overcoating properties of Interzinc 315 provide production flexibility, making this product suitable for use both in new construction and on site as a maintenance coating.

Practical Information for Interzinc 315

Colour	Blue, Grey
Gloss Level	Matt
Volume Solids	69%
Typical Thickness	50-75 microns (2-3 mils) dry equivalent to 72-109 microns (2.9-4.3 mils) wet
Theoretical Coverage	13.80 m ² /litre at 50 microns d.f.t and stated volume solids 553 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
Drying Time	

Temperature	Touch Dry	Hard Dry	Overcoating Interval with recommended topcoats	
			<i>Minimum</i>	<i>Maximum</i>
5°C (41°F)	30 minutes	5 hours	4 hours	Extended*
15°C (59°F)	20 minutes	3 hours	3 hours	Extended*
25°C (77°F)	15 minutes	2 hours	2 hours	Extended*
40°C (104°F)	10 minutes	1 hour	1 hour	Extended*

*See International Protective Coatings Definitions and Abbreviations

Regulatory Data

Flash Point	Base (Part A) 27°C (81°F)	C/A (Part B) 26°C (79°F)	Mixed 27°C (81°F)
Product Weight	3.14 kg/l (26.20 lb/gal)		
VOC	290 g/l	UK - PG6/23(92), Appendix 3	
	2.46 lb/gal (295 g/l)	USA - EPA Method 24	



Ecotech is an initiative by International Protective Coatings a world leader in coating technology to promote the use of environmentally sensitive products across the globe.

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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 8504:1992.

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

Abrasive Grit Blast Cleaning

Abrasive grit blast clean to Sa2½ (ISO 8501-1:1988) or SSPC-SP6. If oxidation has occurred between blasting and application of Interzinc 315, 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 sharp, angular surface profile of 50-75 microns (2-3 mils) is recommended.

Shop Primed Steelwork

Interzinc 315 is suitable for application to steelwork freshly coated with zinc silicate shop primers.

If the shop primer was applied over shot blasted surfaces, overall grit sweep blasting will be necessary prior to the application of Interzinc 315.

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

Weld seams and damaged areas should be grit blast cleaned to Sa2½ (ISO 8501-1:1988) 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.

For three pack material see product characteristics

Mix Ratio

4 parts : 1 part by volume

Working Pot Life

5°C (41°F)	15°C (59°F)	25°C (77°F)	40°C (104°F)
6 hours	3 hours	2 hours	1 hour

Airless Spray

- Tip range 0.43-0.53 mm (17-21 thou)
- Total output fluid pressure at spray tip not less than 141 kg/cm² (2,000 p.s.i.)

Air Spray (Pressure Pot)

Small areas only

Brush

Small areas only Typically 40-50 microns (1.6-2.0 mils) can be achieved

Roller

Not recommended

Thinner

International GTA220 (or GTA415) Do not thin more than allowed by local environmental legislation.

Cleaner

International GTA822 (or GTA415)

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.

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Product Characteristics

Due to the high solids level and high zinc content of this coating, in some countries it has become necessary to supply as a 3 pack material to meet local transport and shipping requirements. The mixed paint and dry film achieved from both 2 and 3 pack materials are identical in both application properties and performance.

The following is mixing information for the three pack material:-

Material is supplied in three 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 specified pot life.

- (1) Agitate Base (Part A), then combine the entire contents of Base (Part A) and Curing Agent (Part B) and mix thoroughly with power agitator.
- (2) The Powder Component (Part C) should be slowly added to the thoroughly mixed Part A and Part B whilst stirring with a power agitator.
- (3) Material should be sieved prior to application and should be constantly agitated in the pot during spraying.

Interzinc 315 can be applied at dry film thicknesses between 50 microns (2 mils) and 150 microns (6 mils). Care should be exercised to avoid over application in excess of 150 microns (6 mils).

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 International thinners. The use of alternative thinners, particularly those containing Ketones, can severely inhibit the curing mechanism of the coating.

Interzinc 315 is not normally recommended for underwater use. Please consult International Protective Coatings for details in this situation.

Low Temperature Curing

Interzinc 315 is capable of curing at temperatures below 0°C (32°F). However, this product should not be applied at temperatures below 0°C (32°F) where there is a possibility of ice formation on the substrate.

Temperature	Touch Dry	Hard Dry	Overcoating interval with recommended topcoats	
			<i>Minimum</i>	<i>Maximum</i>
-5°C (23°F)	60 minutes	8 hours	8 hours	Extended*
0°C (32°F)	45 minutes	6 hours	6 hours	Extended*

*See International Protective Coatings Definitions and Abbreviations

Touch dry times shown above are actual drying times due to chemical cure, rather than physical set due to solidification of the coating film at temperatures below 0°C (32°F).

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

This product has the following specification approvals:

SSPC Paint Specification No. 20, Type II
BS5493(1977) : DF & KP1B
BS4652:1995
ASTM A490 Class B Slip Coefficient

Systems Compatibility

Interzinc 315 is designed for use over correctly prepared grit blasted steel but can be applied over approved prefabrication primers.

Recommended topcoats are:

Intercure 200	Intergard 740
Intercure 420	Interseal 670 HS
Interfine 629 HS	Interthane 990
Intergard 401	Interzone 505
Intergard 475 HS	Interzone 954

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.

Pack Size	10 litre unit	Interzinc 315 Base Interzinc 315 Curing Agent	8 litres in a 10 litre container 2 litres in a 2.5 litre container
	4 gallon unit	Interzinc 315 Base Interzinc 315 Curing Agent Interzinc 315 Powder	1.77 gallons in a 5 gallon container 0.80 gallons in a 1 gallon container 1.43 gallons in a 3 gallon container
	For availability of other pack sizes contact International Protective Coatings		
Shipping Weight	U.N. Shipping No.	1263	
	10 litre unit	31.4 kg (69.2 lb) Base (Part A) 2.2 kg (4.9 lb) Curing Agent (Part B)	
	4 gallon unit	11.0 kg (24.2 lb) Base (Part A) 2.5 kg (5.5 lb) Curing Agent (Part B) 40.1 kg (88.4 lb) Powder (Part C)	
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.	

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: 30/04/2001

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International Protective Coatings

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