

Interzinc 72

E p o x y Z i n c R i c h

Product Description

A two component, metallic zinc rich epoxy primer, designed to provide excellent corrosion resistance both as a single coat and as a primer for a high performance coating system. Contains 90% zinc by weight in the dry film.

Intended Uses

As a factory or site applied primer, for use in high performance coating systems for the protection of steel in aggressive environments such as offshore structures, refineries, petrochemical and chemical plants, power stations, bridges and pulp and paper plants.

Practical Information for Interzinc 72

Colour	Grey																														
Gloss Level	Matt																														
Volume Solids	60%																														
Typical Thickness	50-75 microns (2-3 mils) dry equivalent to 83-125 microns (3.3-5.0 mils) wet																														
Theoretical Coverage	8.0 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	Allow appropriate loss factors																														
Method of Application	Airless spray, Air spray, Brush, Roller																														
Drying Time	<table> <tr> <th rowspan="2">Temperature</th><th rowspan="2">Touch Dry</th><th rowspan="2">Hard Dry</th><th colspan="2">Overcoating Interval with recommended topcoats</th></tr> <tr> <th><i>Minimum</i></th><th><i>Maximum</i></th></tr> <tr> <td>10°C (50°F)</td><td>45 minutes</td><td>6 hours</td><td>8 hours</td><td>Extended*</td></tr> <tr> <td>15°C (59°F)</td><td>35 minutes</td><td>4 hours</td><td>6 hours</td><td>Extended*</td></tr> <tr> <td>25°C (77°F)</td><td>25 minutes</td><td>90 minutes</td><td>4 hours</td><td>Extended*</td></tr> <tr> <td>40°C (104°F)</td><td>20 minutes</td><td>45 minutes</td><td>2 hours</td><td>Extended*</td></tr> </table>				Temperature	Touch Dry	Hard Dry	Overcoating Interval with recommended topcoats		<i>Minimum</i>	<i>Maximum</i>	10°C (50°F)	45 minutes	6 hours	8 hours	Extended*	15°C (59°F)	35 minutes	4 hours	6 hours	Extended*	25°C (77°F)	25 minutes	90 minutes	4 hours	Extended*	40°C (104°F)	20 minutes	45 minutes	2 hours	Extended*
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* See International Protective Coatings Definitions & Abbreviations.

Regulatory Data

Flash Point	Base (Part A) 32°C (90°F)	C/A (Part B) 33°C (91°F)	Mixed 32°C (90°F)
Product Weight	2.8 kg/l (23.4 lb/gal)		
VOC	410 g/l (3.42 lb/gal)	UK - PG6/23(92), Appendix 3	

Interzinc 72

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 8504:1992.

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

Abrasive Blast Cleaning

Abrasive blast clean to Sa2½ (ISO 8501-1:1988) or SSPC-SP6. If oxidation has occurred between blasting and application of Interzinc 72, 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 Steelwork

Interzinc 72 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 8501-1:1988) 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.

Mix Ratio

4 parts : 1 part by volume

Working Pot Life

10°C (50°F)	15°C (59°F)	25°C (77°F)	40°C (104°F)
12 hours	10 hours	8 hours	5 hours

Airless Spray

Recommended

- Tip range 0.43-0.53 mm (17-21 thou)
- Total output fluid pressure at spray tip not less than 176 kg/cm² (2,500 p.s.i.)

Air Spray (Pressure Pot)

Thinning may be required

Gun	DeVilbiss MBC or JGA
Air Cap	704 or 765
Fluid Tip	E

Brush

Suitable - Small areas only

Typically 40-50 microns (1.5-2.0 mils) can be achieved

Roller

Suitable - Small areas only

Typically 40-50 microns (1.5-2.0 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.

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Product Characteristics

In order to ensure good anti-corrosive performance, it is important to achieve a minimum system dry film thickness of 40 microns (1.5 mils). To achieve a uniform film at this thickness thinning at around 10% with International thinners will be required.

When applying Interzinc 72 by brush or roller, it may be necessary to apply multiple coats to achieve the total specified system dry film thickness.

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

This product will not cure adequately below 5°C (41°F). For maximum performance ambient curing temperatures should be above 10°C (50°F).

Where Interzinc 72 is to be used as a primer for a coating system to be subjected to water immersion, it is important to ensure that a minimum dry film thickness of 65 microns (2.5 mils) is applied in order to provide adequate corrosion protection.

Over-application of Interzinc 72 will extend both the minimum overcoating periods and handling times, and may be detrimental to long term overcoating properties.

Excessive film thickness may lead to splitting of the film when overcoated with high build systems.

In the event of Interzinc 72 being allowed to weather before being topcoated, it is important to ensure that all zinc salts are removed prior to paint application, and recommended topcoats are applied.

Interzinc 72 is not suitable for exposure to acid or alkaline environments.

This product has the following specification approvals:

BS5493:1977 DF and KP1B.

BS4652:1995

British Gas Specification PA9 and PA10.

Systems Compatibility

Interzinc 72 can be overcoated with a wide range of high performance topcoats including:

Intercure 200	Intergard 411
Intercure 420	Intergard 475 HS
Intercure 422	Interseal 670 HS
Intergard 251	Intersheen 73
Intergard 269	Intertuf 708
Intergard 400	Interzone 505
Intergard 405	Interzone 954
Intergard 410	

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 72 Base	8 litres in a 10 litre container
		Interzinc 72 Curing Agent	2 litres in a 2.5 litre container
For availability of other pack sizes contact International Protective Coatings			
Shipping Weight	U.N. Shipping No. 1263		
	10 litre unit	27.3 kg (60.2 lb) Base (Part A)	2.1 kg (4.6 lb) Curing Agent (Part B)
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.		

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 from 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: 1st September 1997

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