

PRODUCT DESCRIPTION

A two component solvent based inorganic zinc rich ethyl silicate primer, containing 85% zinc by weight, in the dry film. Complies with the composition and performance requirements of SSPC Paint 20.

Available in ASTM D520, Type II zinc dust version.

INTENDED USES

A metallic zinc primer suitable for use with a wide range of high performance systems and topcoats in both maintenance and new construction of bridges, tanks, pipework, offshore structures and structural steelwork. Provides excellent corrosion protection for correctly prepared steel substrates, up to temperatures of 1004°F (540°C) when suitably topcoated. Fast drying primer capable of application in a wide range of climatic conditions.

PRACTICAL INFORMATION FOR INTERZINC 22

Color	Greenish gray
Gloss Level	Matte
Volume Solids	63%
Typical Thickness	2-3.2 mils (50-80 microns) dry equivalent to 3.2-5.1 mils (79-127 microns) wet
Theoretical Coverage	337 sq.ft/US gallon at 3 mils d.f.t and stated volume solids 8.40 m ² /liter at 75 microns d.f.t and stated volume solids
Practical Coverage	Allow appropriate loss factors
Method of Application	Airless Spray, Air Spray

Drying Time

Temperature	Touch Dry	Hard Dry	Overcoating Interval with recommended topcoats	
			Minimum	Maximum
41°F (5°C) ¹	30 minutes	3 hours	36 hours	Extended ²
59°F (15°C) ¹	20 minutes	90 minutes	24 hours	Extended ²
77°F (25°C) ¹	10 minutes	1 hour	16 hours	Extended ²
104°F (40°C) ¹	5 minutes	30 minutes	8 hours	Extended ²

¹ Drying and overcoating times are dependent upon ambient conditions. The figures quoted above have been determined at the quoted temperature and 65% relative humidity. See Product Characteristics for further advice.

² Maximum overcoating intervals are shorter when using polysiloxane topcoats. Consult International Protective Coatings for further details.

REGULATORY DATA

Flash Point Part A 57°F (14°C); Part B Not applicable; Mixed 59°F (15°C)

Product Weight 20.9 lb/gal (2.50 kg/l)

VOC 4.08 lb/gal (490 g/l) EPA Method 24
222 g/kg EU Solvent Emissions Directive (Council Directive 1999/13/EC)

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 a minimum of SSPC-SP6 or Sa2½ (ISO 8501-1:2007), (or SSPC-SP10 for optimum performance). If oxidation has occurred between blasting and application of Interzinc 22, 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 1.6-3.0 mils (40-75 microns) is recommended.

Shop Primed Steelwork

Interzinc 22 is suitable for application to unweathered 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 SSPC-SP6 or Sa2½ (ISO 8501-1:2007).

Damaged/Repair Areas

All damaged areas should ideally be blast cleaned to SSPC SP6 or Sa2½ (ISO 8501:1988). However, it is acceptable that small areas can be power tool cleaned to SSPC SP11 or Pt3 (JSRA SPSS:1984), provided the area is not polished. Repair of the damaged area can then be carried out using a recommended zinc epoxy primer - consult International Protective Coatings for specific advice.

APPLICATION

Mixing	Interzinc 22 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) while 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	3.17 part(s) : 1.00 part(s) by volume			
Working Pot Life	41°F (5°C) 12 hours	59°F (15°C) 8 hours	77°F (25°C) 4 hours	104°F (40°C) 2 hours
Airless Spray	Recommended	Tip Range 15-21 thou (0.38-0.53 mm) Total output fluid pressure at spray tip not less than 1593 psi (112 kg/cm²)		
Air Spray (Pressure Pot)	Recommended	Gun	DeVilbiss MBC or JGA	
		Air Cap	704 or 765	
		Fluid Tip	E	
Brush	Suitable - Small areas only	Typically 1.0-2.0 mils (25-50 microns) can be achieved		
Roller	Not recommended			
Thinner	International GTA803 (International GTA415)	Do not thin more than allowed by local environmental legislation		
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 GTA415. 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 GTA415. 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 22 is available in various low lead zinc dust versions dependent upon local legislation/project specification. When utilizing the ASTM D520 Type II specification, the appropriate zinc dust grade must be used. Contact International Protective Coatings for further details.

Prior to overcoating, Interzinc 22 must be clean, dry and free from both soluble salts and excessive zinc corrosion products.

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

When applying Interzinc 22 in confined spaces, ensure adequate ventilation.

The minimum overcoating interval is dependent upon the relative humidity during cure. Below 65% relative humidity the minimum recoat period will normally be at least 24 hours, but will be dependent upon the ambient temperature and relative humidity during the application and curing period.

If thinning is required to assist spray application in warmer climates, (typically >82°F (28°C)), it is recommended that International GTA803 thinners are used.

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. Alternatively, the use of Interzinc accelerator solution may be necessary. Please consult International Protective Coatings for further details in this situation.

Excessive film thickness and/or over-application of Interzinc 22 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.

Care should be exercised to avoid the application of dry film thicknesses in excess of 5.0 mils (125 microns).

For high temperature systems the thickness of Interzinc 22 should be restricted to 2 mils (50 microns) d.f.t. Continuous dry temperature resistance of Interzinc 22 is 752°F (400°C) if left untopcoated, however, if this product is used as a primer for Intertherm 50, the dry temperature resistance will be 1004°F (540°C).

Untopcoated Interzinc 22 is not suitable for exposure in acid or alkaline conditions or continuous water immersion.

This product has the following specification approvals:

- SSPC Paint Specification No. 20 Type 1C
- BS5493 (1977) : EP2A
- Shell Specification 40.48.00.30 V1(g)
- ASTM A490 Class B Slip Coefficient
- BS4604 Friction Grip

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 color and normal manufacturing tolerances.

Low molecular weight reactive additives, which will form part of the film during normal ambient cure conditions, will also affect VOC values determined using EPA Method 24.

SYSTEMS COMPATIBILITY

When it is necessary for Interzinc 22 is to be overcoated by itself due to low dry film thickness the coating surface must be fresh and unweathered. A minimum of 2 mils (50 microns) d.f.t. of any subsequent coat of Interzinc 22 is needed to ensure good film formation.

Before overcoating with recommended topcoats ensure the Interzinc 22 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.

Typical topcoats and intermediates are:

Intercryl 530	Intergard 475HS
Intercure 200	Interseal 670HS
Intercure 420	Interfine 979
Intergard 251	Intertherm 50
Intergard 269	Intertherm 715

In some cases it may be necessary to apply a mist coat of suitable viscosity to minimize bubbling. This will depend upon the age of the Interzinc 22, surface roughness and ambient conditions during curing and application. Alternatively, an epoxy sealer coat, such as Intergard 269, 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
	14 liter	10.64 liter	15 liter	3.36 liter	20 liter
	5 US gal	3.8 US gal	5 US gal	1.2 US gal	5 US gal
For availability of other pack sizes contact International Protective Coatings					
SHIPPING WEIGHT	Unit Size	Part A		Part B	
	14 liter	11.7 kg		25.8 kg	
	5 US gal	37.5 lb		66.1 lb	
STORAGE	Shelf Life	Part A: 6 months minimum at 77°F (25°C).			
		Part B: 12 months minimum at 77°F (25°C). 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 law) any loss or damage arising out of the use of the product. 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.

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