

## Alkyd

### PRODUCT DESCRIPTION

Interprime 1068 is an air drying Zinc Phosphate Primer designed for application to all types of steel surfaces.

This primer is characterised by good anti-corrosive properties, easy application and the ability to protect hand cleaned steel.

Interprime 1068 is primarily intended as a single coat system for use in mildly corrosive environments, classified in ISO12944-2 as up to and including C2.

### INTENDED USES

Shop priming of structural steel, girders, plates and pre-fabricated structures.

Field priming of all steel structures such as building frames, bridges, towers and tanks.

### PRACTICAL INFORMATION FOR INTERPRIME 1068

<b>Colour</b>	Red Oxide, Blue, Dark Grey, Stone Grey
<b>Gloss Level</b>	Matt
<b>Volume Solids</b>	41%
<b>Typical Thickness</b>	50-75 microns (2-3 mils) dry equivalent to 122-183 microns (4.9-7.3 mils) wet
<b>Theoretical Coverage</b>	6.83 m <sup>2</sup> /litre at 60 microns d.f.t and stated volume solids 274 sq.ft/US gallon at 2.4 mils d.f.t and stated volume solids
<b>Practical Coverage</b>	Allow appropriate loss factors
<b>Method of Application</b>	Airless Spray, Roller, Air Spray, Brush
<b>Drying Time</b>	

Temperature	Touch Dry	Hard Dry	Overcoating Interval with recommended topcoats	
			Minimum	Maximum
5°C (41°F)	3 hours	8 hours	6 hours	Extended <sup>1</sup>
15°C (59°F)	90 minutes	3 hours	3 hours	Extended <sup>1</sup>
25°C (77°F)	1 hour	2 hours	2 hours	Extended <sup>1</sup>
40°C (104°F)	30 minutes	1 hour	1 hour	Extended <sup>1</sup>

<sup>1</sup> See International Protective Coatings Definitions and Abbreviations

### REGULATORY DATA

<b>Flash Point (Typical)</b>	23°C (73°F)
<b>Product Weight</b>	1.31 kg/l (10.9 lb/gal)
<b>VOC</b>	416 g/kg EU Solvent Emissions Directive (Council Directive 1999/13/EC)

See Product Characteristics section for further details

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### SURFACE PREPARATION

The performance of this product will depend upon the degree of surface preparation. The surface 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.

Accumulated dirt and soluble salts must be removed. Dry bristle brushing will normally be adequate for accumulated dirt. Soluble salts should be removed by fresh water washing.

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 Interprime 1068, 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.

Interprime 1068 is suitable for application to blast cleaned surfaces which were initially to the above standard but have been allowed to deteriorate under good shop conditions for up to 7-10 days. The surface may deteriorate to Sa2 standard but must be free from loose powdery deposits.

### Maintenance and Site Touch-up

The product is designed for application to surfaces prepared to St2 (ISO 8501-1:2007) or SSPC SP2. When using power tools care should be taken to avoid surface polishing. The product may also be applied to surfaces which have been brush blasted to Sa1 (ISO 8501-1:2007) or SSPC-SP7.

On surfaces prepared to St2 (ISO 8501-1:2007) or SSPC-SP2, brush application will assist surface wetting and improve subsequent coating performance.

### APPLICATION

<b>Mixing</b>	This material is a one component coating and should always be mixed thoroughly with a power agitator before application.		
<b>Airless Spray</b>	Recommended	Tip Range 0.43-0.53 mm (17-21 thou) Total output fluid pressure at spray tip not less than 176 kg/cm <sup>2</sup> (2503 p.s.i.)	
<b>Air Spray (Pressure Pot)</b>	Recommended	Gun Air Cap Fluid Tip	DeVilbiss MBC or JGA 704 or 765 E
<b>Brush</b>	Recommended	Typically 40 microns (1.6 mils) can be achieved. Care should be taken to avoid under-application.	
<b>Roller</b>	Recommended	Typically 40 microns (1.6 mils) can be achieved. Care should be taken to avoid under-application.	
<b>Thinner</b>	International GTA007		
<b>Cleaner</b>	International GTA007		
<b>Work Stoppages</b>	Thoroughly flush all equipment with International GTA007. All unused material should be stored in tightly closed containers. Partially filled containers may show surface skinning and/or a viscosity increase of the material after storage.		
<b>Clean Up</b>	Clean all equipment immediately after use with International GTA007. 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

This product is not intended for use in aggressive, corrosive environments, or on heavily pitted or contaminated steel.

For brush and roller application, two coats of Interprime 1068 may be required to give uniform coverage.

Over-application of Interprime 1068 will extend both the minimum overcoating periods and handling times, and may be detrimental to long term overcoating properties.

Minimum overcoating time for polyurethane topcoats is 16 hours at 25°C (77°F). Further information is available from International Protective Coatings. When overcoating with polyurethane it will be necessary to adhere to the specified dry film thickness to ensure that adequate drying times are allowed, and that the Interprime 1068 is not over-applied.

Interprime 1068 is not suitable for use as a barrier coat for upgrading old chlorinated rubber and vinyl systems.

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.

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### SYSTEMS COMPATIBILITY

The following topcoats are recommended for Interprime 1068:

Interlac 649  
Interlac 665  
Interthane 990

For other suitable 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 documents available at [www.international-pc.com](http://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		
		Vol	Pack
	20 litre	20 litre	20 litre
	5 litre	5 litre	5 litre
For availability of other pack sizes, contact International Protective Coatings.			
SHIPPING WEIGHT (TYPICAL)	Unit Size		
	20 litre		28.2 kg
	5 litre		7.1 kg
STORAGE	Shelf Life	24 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](http://www.international-marine.com) or [www.international-pc.com](http://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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