Interzinc® 2265

Inorganic Zinc Rich Silicate

PRODUCT DESCRIPTION

Part of the Interzinc 22 series of products.

A two component, rapid recoat, fast curing solvent based inorganic zinc rich ethyl silicate primer. Conforms to SSPC Paint 20 Level 3.

Available in ASTM D520, Type II zinc dust version as standard

INTENDED USES

A 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 and structural steelwork.

Fast curing primer capable of application in a wide range of climatic conditions.

PRACTICAL INFORMATION FOR INTERZINC 2265

Colour	Green Grey
Gloss Level	Matt
Volume Solids	63%
Typical Thickness	50-75 microns (2-3 mils) dry equivalent to 79-119 microns (3.2-4.8 mils) wet
Theoretical Coverage	8.40 m²/litre at 75 microns d.f.t and stated volume solids 337 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

Drying Time

			Overcoating Interval with recommended topcoats	
Temperature	**Touch Dry**	**Hard Dry**	*Minimum*	*Maximum*
5°C (41°F)	30 minutes	3 hours	18 hours	Extended[1]
15°C (59°F)	20 minutes	90 minutes	9 hours	Extended[1]
25°C (77°F)	10 minutes	60 minutes	4.5 hours	Extended[1]
40°C (104°F)	5 minutes	30 minutes	90 minutes	Extended[1]

[1] See International Protective Coatings Definitions and Abbreviations

The drying times quoted have been determined at the quoted temperature and 55% relative humidity. The 5°C (41°F) time was determined at 60% relative humidity. Prior to overcoating, verify a value of 4 via ASTM D4752 MEK rub test. See Product Characteristics section for more details on overcoating.

REGULATORY DATA

Flash Point (Typical)	Part A 13°C (55°F); Part B N/A, Mixed 13°C (55°F)	
Product Weight	2.15 kg/l (17.9 lb/gal)	
VOC	4.08 lb/gal (490 g/lt) 249 g/kg	EPA Method 24 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 Sa2½ (ISO 8501-1:2007) or SSPC-SP6 (or SSPC-SP10 for optimum performance). If oxidation has occurred between blasting and application of Interzinc 2265 , 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 40-75 microns (1.5-3.0 mils) is recommended.

Shop Primed Steelwork
Interzinc 2265 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 Sa2½ (ISO 8501-1:2007) or SSPC-SP6.

Damaged / Repair Areas
All damaged areas should ideally be blast cleaned to Sa2½ (ISO 8501-1:2007) or SSPC-SP6. However, it is acceptable that small areas can be power tool cleaned to Pt3 (JSRA SPSS:1984) or SSPC-SP11, 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 2265 is supplied in two 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) whilst 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

5.70 part(s) : 1 part(s) by volume

Working Pot Life

5°C (41°F)	15°C (59°F)	25°C (77°F)	40°C (104°F)
12 hours	8 hours	4 hours	2 hours

Airless Spray

Recommended

Tip Range 0.38-0.53 mm (15-21 thou)
Total output fluid pressure at spray tip not less than 112 kg/cm² (1593 p.s.i.)

Air Spray (Pressure Pot)

Recommended

Gun	DeVilbiss or Binks
Air Cap	As per fluid tip
Fluid Tip	DeVilbiss E,D/Binks 66,67

Brush

Suitable - Small touch-up areas only

Typically 25-50 microns (1.0-2.0 mils) can be achieved

Roller

Not recommended

Thinner

International GTA803 (or 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 GTA803. 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 GTA803. 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

Prior to overcoating, Interzinc 2265 must be clean, dry and free from both soluble salts and excessive zinc corrosion products.

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

When applying Interzinc 2265 in confined spaces ensure adequate ventilation.

The minimum overcoating interval is dependent upon the relative humidity during cure. 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 55%, curing will be retarded. Humidity may be increased by the use of steam or water spraying. However, cure at relative humidities below 55% is more effectively achieved by incorporating the Low Humidity Cure Accelerator*; some example overcoating times at 15ºC (59ºF) are detailed below;

Relative Humidity (%)	20	30	40
Minimum Overcoating Interval	24 hours	10 hours	10 hours

The Interzinc 2265 Application Guidelines contain further information on expected cure times at lower relative humidities.

Excessive film thickness and/or over-application of Interzinc 2265 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 application of dry film thickness in excess of 125 microns (5 mils).

Untopcoated Interzinc 2265 is not suitable for exposure in acid or alkaline conditions or continuous water immersion.

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.

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.

*Only available in Europe, China, Middle East, Africa and Russia.

SYSTEMS COMPATIBILITY

When it is necessary for Interzinc 2265 to be overcoated by itself due to low dry film thickness, the coating surface must be fresh and unweathered. A minimum of 50 microns (2 mils) d.f.t. of any subsequent coat of Interzinc 2265 is needed to ensure good film formation.

Before overcoating with recommmeded topcoats ensure the Interzinc 2265 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 are:

Intercure 200	
Intercure 420	Intergard 251
Intergard 269	Intergard 345
Intergard 475HS	Interseal 670HS

In some cases it may be necessary to apply a mist coat of suitable viscosity to minimise bubbling. This will depend upon the age of the Interzinc 2265 , 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, 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
- Interzinc 2265 Application Guidelines

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
10 litre	8.51 litre	10 litre	1.49 litre	12 litre

For availability of other pack sizes, contact International Protective Coatings.

SHIPPING WEIGHT (TYPICAL)

Shipping weights can vary depending on supply point; please contact International Paint for further details.

STORAGE

Shelf Life

Part A 6 months minimum at 25°C (77°F).
Part B 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.

Important Note

www.international-pc.com