

Inorganic Zinc Rich Silicate

PRODUCT DESCRIPTION

A zinc silicate anticorrosive primer providing assured corrosion protection with fast drying.

INTENDED USES

For use as a primer to ensure good anticorrosive protection in both new construction and maintenance & repair situations.

Suitable for use on a wide variety of structures in the onshore oil and gas, chemical and petrochemical, mining and power industries as well as bridges.

PRACTICAL INFORMATION FOR EIGHTY8HUNDRED 8805

Colour	Green Grey
Gloss Level	Matt
Volume Solids	63%
Typical Thickness	50-75 microns dft equivalent to 79-119 microns wft
Theoretical Coverage	8.4 m ² /litre at 75 microns dft 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	
			Min	Max
15°C	20 minutes	1½ hrs	9 hrs	Extended ¹
25°C	10 minutes	1 hr	4½ hrs	Extended ¹
40°C	5 minutes	½ hr	1½ hrs	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.

See Product Characteristics section for more details on overcoating.

REGULATORY DATA

Flash Point (Typical)	Part A 13°C Part B N/A Mixed 13°C
Product Weight	2.2 kg/litre
VOC	490 g/lit EPA Method 24

See Product Characteristics section for further details.

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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 8504:2000.

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 Eighty8Hundred 8805, 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

Eighty8Hundred 8805 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 Eighty8Hundred 8808 epoxy primer - consult International Protective Coatings for specific advice.

APPLICATION

Mixing	Eighty8Hundred 8805 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	15°C	25°C	40°C
	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/cm ² (1593 p.s.i.)	
Air Spray (Pressure Pot)	Recommended	Gun Air Cap Fluid Tip	DeVilbiss or Binks As per 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.		

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PRODUCT CHARACTERISTICS

Prior to overcoating, Eighty8Hundred 8805 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 above dew point.

When applying Eighty8Hundred 8805 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.

Excessive film thickness and/or over-application of Eighty8Hundred 8805 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 Eighty8Hundred 8805 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.

SYSTEMS COMPATIBILITY

When it is necessary for Eighty8Hundred 8805 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 Eighty8Hundred 8805 is needed to ensure good film formation.

Before overcoating with recommended topcoats ensure the Eighty8Hundred 8805 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.

The following topcoat is recommended:

- Eighty8Hundred 8840

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 Eighty8Hundred 8805, surface roughness and ambient conditions during curing and application.

Eighty8Hundred 8805 should only be used in schemes with other Eighty8Hundred products.

See relevant product data sheet for details.

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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:

- Definitions & Abbreviations
- Surface Preparation
- Paint Application
- Theoretical & Practical Coverage
- Eighty8Hundred 8805 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.
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STORAGE	Shelf Life	Part A 6 months minimum at 25°C. Part B 12 months minimum at 25°C. Subject to re-inspection thereafter. Store in dry, shaded conditions away from sources of heat and ignition.
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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 or 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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