

## Epoxy Zinc-Rich

**PRODUCT DESCRIPTION** A two component, high solids, low VOC, rapid curing metallic zinc rich epoxy primer which complies with the composition and performance requirements of SSPC Paint 20.

**INTENDED USES** As a high performance primer to give maximum protection as part of a suitable anti-corrosive coating system for aggressive environments including those found on offshore structures, petrochemical facilities, bridges and power plants.

The rapid curing and overcoating properties of Interzinc 52HS provide production flexibility, making this product suitable for use both in new construction and on site as a maintenance coating.

### PRACTICAL INFORMATION FOR INTERZINC 52HS

|                              |   |
|------------------------------|---|
| <b>Color</b>                 | Green   |
| <b>Gloss Level</b>           | Matte   |
| <b>Volume Solids</b>         | 73%   |
| <b>Typical Thickness</b>     | 3 mils (75 microns) dry equivalent to 4.1 mils (103 microns) wet  |
| <b>Theoretical Coverage</b>  | 390 sq.ft/US gallon at 3 mils d.f.t and stated volume solids<br>9.70 m <sup>2</sup> /liter at 75 microns d.f.t and stated volume solids |
| <b>Practical Coverage</b>    | Allow appropriate loss factors  |
| <b>Method of Application</b> | Airless Spray, Air Spray, Brush, Roller   |

#### Drying Time

| Temperature  | Touch Dry  | Hard Dry | Overcoating Interval with recommended topcoats |                       |
|--------------|------------|----------|--|-----------------------|
|              |            |          | Minimum  | Maximum               |
| 41°F (5°C)   | 60 minutes | 6 hours  | 6 hours  | Extended <sup>1</sup> |
| 59°F (15°C)  | 40 minutes | 4 hours  | 4 hours  | Extended <sup>1</sup> |
| 77°F (25°C)  | 30 minutes | 3 hours  | 3 hours  | Extended <sup>1</sup> |
| 104°F (40°C) | 20 minutes | 2 hours  | 2 hours  | Extended <sup>1</sup> |

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

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

**REGULATORY DATA** **Flash Point (Typical)** Part A 86°F (30°C); Part B 81°F (27°C); Mixed 84°F (29°C)

**Product Weight** 25.5 lb/gal (3.06 kg/l)

**VOC** 2.07 lb/gal (249 g/lit)  
84 g/kg

EPA Method 24  
EU Solvent Emissions Directive  
(Council Directive 1999/13/EC)

See Product Characteristics section for further details

## Protective Coatings

## 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 8504:2000.

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

#### Abrasive Blast Cleaning

Abrasive blast clean to SSPC-SP6 or Sa2½ (ISO 8501-1:2007). If oxidation has occurred between blasting and application of Interzinc 52HS, 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 Steel

Interzinc 52HS 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 8501-1:2007) or SSPC-SP6.

### APPLICATION

|                                 |   |  |                      |              |
|---------------------------------|---|--|----------------------|--------------|
| <b>Mixing</b>                   | 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.   |  |                      |              |
| <b>Mix Ratio</b>                | 4 part(s) : 1 part(s) by volume   |  |                      |              |
| <b>Working Pot Life</b>         | 41°F (5°C)  | 59°F (15°C)  | 77°F (25°C)          | 104°F (40°C) |
|                                 | 4 hours   | 2 hours  | 90 minutes           | 30 minutes   |
| <b>Airless Spray</b>            | Recommended   | Tip Range 17-19 thou (0.43-0.48 mm)<br>Total output fluid pressure at spray tip not less than 2503 psi (176 kg/cm <sup>2</sup> ) |                      |              |
| <b>Air Spray (Pressure Pot)</b> | Recommended   | Gun  | DeVilbiss MBC or JGA |              |
|                                 |   | Air Cap  | 704 or 765           |              |
|                                 |   | Fluid Tip  | E                    |              |
| <b>Brush</b>                    | Suitable - Small areas only   | Typically 2.0-3.0 mils (50-75 microns) can be achieved   |                      |              |
| <b>Roller</b>                   | Suitable - Small areas only   | Typically 2.0-3.0 mils (50-75 microns) can be achieved   |                      |              |
| <b>Thinner</b>                  | International GTA220 (or International GTA415)  | Do not thin more than allowed by local environmental legislation   |                      |              |
| <b>Cleaner</b>                  | International GTA822 (or International GTA415)  |  |                      |              |
| <b>Work Stoppages</b>           | 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.     |  |                      |              |
| <b>Clean Up</b>                 | 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 dry film thickness of Interzinc 52HS of 2 mils (50 microns). To achieve a uniform, coalesced, closed film at this dry film thickness, it will be necessary to thin Interzinc 52HS with 5% recommended International thinners. The film thickness of Interzinc 52HS applied must be compatible with the blast profile achieved during surface preparation. Low film thickness should not be applied over coarse blast profiles

This product must only be thinned using International thinners. The use of alternative thinners, particularly those containing ketones, can severely inhibit the curing mechanism of the coating.

Care should be exercised to avoid the application of dry film thicknesses in excess of 6 mils (150 microns).

Care should be exercised during application to avoid over-application which may result in cohesive film failure with subsequent high builds, and to avoid dry spray which can lead to pinholing of subsequent coats.

Over-application of Interzinc 52HS will extend both the minimum overcoating periods and handling times, and may be detrimental to long term overcoating properties.

Surface temperature must always be a minimum of 5°F (3°C) above dew point. Interzinc 52HS is capable of curing at temperatures below 32°F (0°C). However, this product should not be applied at temperatures below 32°F (0°C) where there is a possibility of ice formation on the substrate.

Interzinc 52HS is not normally recommended for underwater use. Please consult International Protective Coatings for further details in this situation.

When Interzinc 52HS is allowed to weather before topcoating ensure all zinc salts are removed prior to paint application and only topcoat with recommended materials.

Interzinc 52HS is suitable for the localized repair of damaged inorganic zinc primer - consult International Protective Coatings for specific advice.

This product has the following specification approvals:

- Steel Structures Painting Council - SSPC Paint 20, Type II

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 effect VOC values determined using EPA Method 24.

### SYSTEMS COMPATIBILITY

Interzinc 52HS is designed for application to correctly prepared steel. It is possible to apply over approved prefabrication primers. Details of these can be obtained from International Protective Coatings.

Recommended topcoats are:

|                 |                 |
|-----------------|-----------------|
| Intercryl 530   | Intercure 200HS |
| Intercure 420   | Intercure 420HS |
| Interfine 629HS | Interfine 979   |
| Intergard 269   | Intergard 345   |
| Intergard 400   | Intergard 475HS |
| Intergard 740   | Interseal 670HS |
| Interthane 870  | Interthane 990  |
| Interzone 505   | Interzone 954   |

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  | Part A   |          | Part B     |             |
|--|------------|--|----------|------------|-------------|
|  |            | Vol  | Pack     | Vol        | Pack        |
|  | 10 liter   | 8 liter  | 10 liter | 2 liter    | 3.7 liter   |
|  | 1 US gal   | 0.8 US ga  | 1 US gal | 0.2 US gal | 0.25 US gal |
| For availability of other pack sizes contact International Protective Coatings |            |  |          |            |             |
| SHIPPING WEIGHT (TYPICAL)  | Unit Size  | Part A   |          | Part B     |             |
|  | 10 liter   | 30.3 kg  |          | 2.4 kg     |             |
|  | 1 US gal   | 24.7 lb  |          | 1.9 lb     |             |
| STORAGE  | Shelf Life | 6 months minimum at 77°F (25°C). Subject to re-inspection thereafter.<br>Store in dry, shaded conditions away from sources of heat and ignition. |          |            |             |

### Disclaimer

*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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