Interzone® 9545

Epoxy

PRODUCT DESCRIPTION

Two component, ultra-high solids, fast curing, heavy duty epoxy barrier coating formulated for single leg airless spray application. Based on novel hybrid epoxy technology Interzone 9545 is designed to provide long term corrosion protection in aggressive offshore environments. Shows excellent corrosion resistance to abrasion and cathodic disbondment.

INTENDED USES

Interzone 9545 has been designed primarily to meet the performance requirements for protection of assets in highly corrosive offshore environments in both the Renewable Energy and Oil & Gas markets.

Interzone 9545 has been formulated to provide rapid recoat times even at low temperatures allowing improved productivity and increased throughput in the fabrication shop.

Interzone 9545 has been tested in accordance with ISO12944-9 demonstrating excellent performance in both the splashzone and immersed environments and compatible with cathodic protection systems utilised offshore.

PRACTICAL INFORMATION FOR INTERZONE 9545

Colour	Limited colour range available
Gloss Level	Semi-gloss
Volume Solids	95%
Typical Thickness	250-500 microns (10-20 mils) dry equivalent to 263-526 microns (10.5-21 mils) wet
Theoretical Coverage	3.80 m²/litre at 250 microns d.f.t and stated volume solids 152 sq.ft/US gallon at 10 mils d.f.t and stated volume solids
Practical Coverage	Allow appropriate loss factors
Method of Application	Airless spray, Brush

Drying Time

			Overcoating Interval with recommended topcoats	
Temperature	**Touch Dry**	**Hard Dry**	*Minimum*	*Maximum*
5°C (41°F)	15 hours	18 hours	18 hours	10 days[1]
10°C (50°F)	4 hours	8 hours	6 hours	10 days[1]
25°C (77°F)	3 hours	5 hours	5 hours	10 days[1]
40°C (104°F)	2.5 hours	3 hours	3 hours	10 days[1]

[1] The maximum self-self overcoating interval is 28 days.
Drying times quoted above require a minimum relative humidity of 30%. Longer cure times will result if the relative humidity falls below 30%.

REGULATORY DATA

Flash Point (Typical)	Part A 87°C (189°F);Part B 145°C (293°F)
Product Weight	1.66 kg/l (13.9 lb/gal)
VOC	0.54 lb/gal (65 g/lt) EPA Method 24

See Product Characteristics section for further details

Epoxy

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.

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

Steel
Abrasive blast clean to Sa2½ (ISO 8501-1:2007) or SSPC-SP10. If oxidation has occurred between blasting and application of Interzone 9545, 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 sharp, angular surface profile of 75 microns (3 mils) is recommended.

Damaged / Repair Areas
For small areas of touch up repair, power tool cleaning to SSPC SP11 is suitable. A minimum surface profile of 50 microns (2 mils) is required.

APPLICATION

Mixing

Interzone 9545 should be stored at a minimum of 20ºC (70ºF) for 24 hours prior to application. 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.

Mix Ratio

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

Working Pot Life

5°C (41°F)	10°C (50°F)	25°C (77°F)	40°C (104°F)
3 hours	2.5 hours	60 minutes	45 minutes

Airless Spray

Recommended

Tip Range 0.48-0.58 mm (19-23 thou)
Total output fluid pressure at spray tip not less than 176 kg/cm² (2503 p.s.i.)

Brush

Suitable

Recommended for small areas and repairs, multiple coats will be necessary to achieve the required dry film thickness. Typically 200-250 microns (8.0-10.0 mils) can be achieved

Thinner

DO NOT THIN

Cleaner

International GTA203

Work Stoppages

Do not allow material to remain in hoses or spray equipment. Thoroughly flush all equipment with International GTA203. 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 material.

Clean Up

Clean all equipment immediately after use with GTA203. 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 material and empty containers should be disposed of in accordance with appropriate regional regulations/legislation.

PRODUCT CHARACTERISTICS

Maximum film build in one coat is best attained by airless spray (single or plural component). Low or high temperatures may require specific application techniques to achieve maximum film build. When applying Interzone 9545 by brush, it may be necessary to apply multiple coats to achieve the total specified system dry film thickness.

Surface temperature must always be a minimum of 3°C (5°F) above dew point. Do not apply at steel temperatures below 4°C (39°F). When applying Interzone 9545 in confined spaces ensure adequate ventilation. In special cases where overcoating is required and curing has been at low temperature and high relative humidity, ensure no amine bloom is present prior to application of subsequent topcoats.

Condensation occurring during or immediately after application may result in an inferior film. Premature exposure to ponding water will cause a colour change, especially in dark colours. When applied between tides on jetties, piling etc., Interzone 9545 can be immersed after 60 minutes. This will lead to whitening of dark colours but will not affect ultimate anti-corrosive performance.

In common with all epoxies, Interzone 9545 will chalk and discolour on exterior exposure. Where a durable cosmetic finish with good gloss and colour retention is required overcoat with recommended topcoats.

This product has the following specification approvals:

Norsok M-501 Rev 6 System 7A and 7B for both splashzone and immersed areas

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

Interzone 9545 is normally overcoated with itself, however, where a cosmetically acceptable topcoat is required the following products are recommended:

Interthane 870
Interthane 990

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 Safety Data Sheet and the container(s), and should not be used without reference to the Safety Data Sheet (SDS).

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 AkzoNobel for further advice.

PACK SIZE	Unit Size	Part A		Part B	
		Vol	Pack	Vol	Pack
	20 litre	16.19 litre	20 litre	3.81 litre	5 litre
	For availability of other pack sizes, contact AkzoNobel.				

SHIPPING WEIGHT (TYPICAL)	Unit Size	Part A	Part B
	20 litre	30.82 kg	4.3 kg

STORAGE	Shelf Life	12 months 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