Interzinc® 315B

Epoxy Zinc-Rich

PRODUCT DESCRIPTION

A three component, metallic, zinc rich epoxy primer which passes Slip B coefficient. Interzinc 315B complies with SSPC Paint 20 and contains minimum 80% zinc in the dry film.

The zinc dust used in Interzinc 315B conforms to ASTM D520, Type II.

INTENDED USES

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

Interzinc 315B has been designed to provide excellent corrosion resistance in both maintenance and new construction situations.

PRACTICAL INFORMATION FOR INTERZINC 315B

Colour	Green, Red
Gloss Level	Matt
Volume Solids	68%
Typical Thickness	50-150 microns (2-6 mils) dry equivalent to 74-221 microns (3-8.8 mils) wet
Theoretical Coverage	9.10 m²/litre at 75 microns d.f.t and stated volume solids 364 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, Brush

Drying Time

			Overcoating Interval with recommended topcoats	
Temperature	**Touch Dry**	**Hard Dry**	*Minimum*	*Maximum*
0°C (32°F)	15 hours	30 hours	30 hours	Extended[1]
5°C (41°F)	1 hour	7 hours	7 hours	Extended[1]
15°C (59°F)	40 minutes	4 hours	4 hours	Extended[1]
25°C (77°F)	30 minutes	3 hours	30 minutes	Extended[1]
40°C (104°F)	15 minutes	1.5 hours	30 minutes	Extended[1]

[1] See International Protective Coatings Definitions and Abbreviations

REGULATORY DATA

Flash Point (Typical)	Part A 29°C (84°F); Part B 25°C (76°F); Mixed 29°C (84°F)	
Product Weight	3.26 kg/l (27.2 lb/gal)	
VOC	2.42 lb/gal (290 g/lt)	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

Abrasive blast clean to Sa2½ (ISO 8501-1:2007) or SSPC-SP6. If oxidation has occurred between blasting and application of Interzinc 315B, 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 50-75 microns (2-3 mils) is recommended.

Shop Primed Steel

Interzinc 315B 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

Mixing

Material is supplied in three 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 Part A, then combine the entire contents of Part A and Part B and mix thoroughly with a power agitator.

(2) Part C, the powder component, should be slowly added to the thoroughly mixed Part A and Part B whilst stirring with a power agitator.

(3) Material should be sieved prior to application and should be constantly agitated in the pot during spraying.

Mix Ratio

1.9 part(s) : 0.71 part(s) : 1.43 part(s) by volume

Working Pot Life

5°C (41°F)	15°C (59°F)	25°C (77°F)	40°C (104°F)
8.5 hours	5 hours	3 hours	1 hour

Airless Spray	Recommended	Tip Range 0.43-0.53 mm (17-21 thou) Total output fluid pressure at spray tip not less than 176 kg/cm² (2503 p.s.i.)	
Air Spray (Pressure Pot)	Recommended	Gun Air Cap Fluid Tip	DeVilbiss MBC or JGA 704 or 765 E
Brush	Suitable - small areas only	Typically 50-75 microns (2.0-3.0 mils) can be achieved	
Roller	Not recommended		
Thinner	International GTA415	Do not thin more than allowed by local environmental legislation	
Cleaner	International GTA415		

Work Stoppages

Do not allow material to remain in hoses, gun or spray equipment. Thoroughly flush all equipment with International GTA415. 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 GTA415.

It is good working practice to periodically flush out spray equipment during the course of the working day. Frequency should 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

The film thickness of Interzinc 315B applied must be compatible with the blast profile achieved during surface preparation.

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 315B 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 3°C (5°F) above dew point.

Interzinc 315B is not recommended for underwater use.

Interzinc 315B is suitable for the localised repair of damaged inorganic zinc primer - consult International Protective Coatings for specific advice.

Interzinc 315B is approved by NEPCOAT as the primer for the following system:

Interzinc 315B
Intergard 475HS
Interthane 870UHS.

Note: VOC values quoted are based on maximum possible for the product taking into account variations due to colour differences 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

Interzinc 315B is designed for application to correctly prepared steel. However, it is also possible to apply over approved prefabrication primers. Further details of these can be obtained from International Protective Coatings.

Recommended topcoats are:

Intergard 345	Intergard 475HS
Interseal 670HS	Interthane 870
Interthane 870UHS	Interthane 990
Interthane 990FD	Interthane 990HS
Interzone 954	

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 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		Part C		
		Vol	Pack	Vol	Pack	Vol	Pack	
	4 US gal	1.9 US gal	5 US gal	0.7 US gal	1 US gal	1.4 US gal	5 US gal	
	For availability of other pack sizes, contact International Protective Coatings.							
SHIPPING WEIGHT (TYPICAL)	Unit Size	Part A		Part B		Part C		
	4 US gal	23.8 lb		6.2 lb		84.6 lb		
STORAGE	Shelf Life	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