Interzinc® 52E

Rapid Recoat Epoxy Zinc Rich

PRODUCT DESCRIPTION

A two component, high solids, fast drying, rapid recoat, metallic zinc-rich epoxy primer which complies with the compositional requirements of ISO 12944 Part 5. Interzinc 52E also complies with the compositional and performance requirements of SSPC Paint 20.

Interzinc 52E uses zinc dust conforming to the requirements of ASTM D520 Type II as a minimum.

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 offshore structures, petrochemical facilities, pulp and paper plants, bridges and power plants.
Interzinc 52E has been designed to provide excellent corrosion resistance in new construction situations.

PRACTICAL INFORMATION FOR INTERZINC 52E

Color	Gray
Gloss Level	Matte
Volume Solids	65%
Typical Thickness	2-4 mils (50-100 microns) dry equivalent to 3.1-6.2 mils (77-154 microns) wet
Theoretical Coverage	521 sq.ft/US gallon at 2 mils d.f.t and stated volume solids 13 m²/liter at 50 microns 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*
41°F (5°C)	45 minutes	4 hours	3 hours	Extended[1]
50°F (10°C)	30 minutes	3 hours	2 hours	Extended[1]
77°F (25°C)	15 minutes	90 minutes	45 minutes	Extended[1]
104°F (40°C)	15 minutes	45 minutes	30 minutes	Extended[1]

[1] See International Protective Coatings Definitions & Abbreviations
Maximum overcoating intervals are shorter when using polysiloxane or Chartek topcoats. Consult International Protective Coatings for further details.
To ensure good aged overcoating of Interzinc 52E by other materials the surface must be thoroughly clean, dry and free of any white zinc salts.

REGULATORY DATA

Flash Point (Typical)	Part A 82°F (28°C); Part B 90°F (32°C); Mixed 88°F (31°C)	
Product Weight	18.6 lb/gal (2.23 kg/l)	
VOC	2.50 lb/gal (300 g/lt)	EPA Method 24
	143 g/kg	EU Solvent Emissions Directive (Council Directive 1999/13/EC)
	298 g/lt (2.48 lb/US Gal) as supplied under Korea Clean Air Conservation Act	

See Product Characteristics section for further details

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SURFACE PREPARATION

All surfaces to be coated should be clean and free from contamination. Prior to 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 52E, 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 Steelwork

Interzinc 52E may be applied to zinc shop primers which have been sweep blasted.

Weld seams and damaged areas should be blast cleaned to Sa2½ (ISO 8501-1:2007) or SSPC-SP10.

APPLICATION

Mixing

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

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

Working Pot Life

41°F (5°C)	50°F (10°C)	77°F (25°C)	104°F (40°C)
4 hours	90 minutes	75 minutes	30 minutes

Airless Spray	Recommended	Tip Range 17-21 thou (0.43-0.53 mm) Total output fluid pressure at spray tip not less than 2503 psi (176 kg/cm²)
Air Spray (Pressure Pot)	Recommended	Gun: DeVilbiss MBC or JGA Air Cap: 704 or 765 Fluid Tip: E
Brush	Suitable	Typically 2.0-3.0 mils (50-75 microns) can be achieved
Roller	Not recommended	
Thinner	International GTA220	Thinning is not normally required. Consult the local representative for advice during application in extreme conditions. Do not thin more than allowed by local environmental legislation.
Cleaner	International GTA220	Choice of cleaner may be subject to local legislation. Please consult your local representative for specific advice.

Work Stoppages

Do not allow material to remain in hoses, gun or spray equipment. Thoroughly flush all equipment with International GTA220. 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 GTA220. 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 52E of 2 mils (50 microns). The film thickness of Interzinc 52E applied must be compatible with the blast profile achieved during surface preparation. Low film thickness should not be applied over coarse blast profiles.

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

Care should be exercised 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 will also result in slower curing and extended handling and overcoating times.

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

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

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

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

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 affect VOC values determined using EPA Method 24.

SYSTEMS COMPATIBILITY

Interzinc 52E is normally applied directly to blast cleaned steel.

Recommended topcoats/intermediates are:

Interfine 979	Interseal 670HS
Intergard 251HS	Interthane 990
Intergard 269	Interzone 954
Intergard 345	Interzone 1000
Intergard 475HS	

For other suitable topcoats, consult International Protective Coatings.