Interzone® 954BG

Modified Epoxy

PRODUCT DESCRIPTION

A two component, low VOC, high solids, modified epoxy barrier coating specifically designed to provide long term steel protection via brush or roller application techniques. Will continue to cure when immersed in water and has excellent cathodic disbondment resistance.

INTENDED USES

Primarily designed for use in offshore splashzone maintenance, where its continued cure under immersed conditions makes it ideal for coping with tidal movements and surges. May be applied to reoxidised and slightly damp surfaces.

Interzone 954BG is intended for use in those instances where the performance of Interzone 954 is required but spray application is not possible.

PRACTICAL INFORMATION FOR INTERZONE 954BG

Colour	Limited range
Gloss Level	Gloss
Volume Solids	87%
Typical Thickness	200-300 microns (8-12 mils) dry equivalent to 230-345 microns (9.2-13.8 mils) wet
Theoretical Coverage	4.40 m²/litre at 200 microns d.f.t and stated volume solids 174 sq.ft/US gallon at 8 mils d.f.t and stated volume solids
Practical Coverage	Allow appropriate loss factors
Method of Application	Brush, Roller

Drying Time

			Overcoating Interval with recommended topcoats	
Temperature	**Touch Dry**	**Hard Dry**	*Minimum*	*Maximum*
10°C (50°F)	14 hours	24 hours	24 hours	14 days
15°C (59°F)	10 hours	18 hours	18 hours	10 days
25°C (77°F)	4 hours	8 hours	8 hours	7 days
40°C (104°F)	90 minutes	3 hours	3 hours	5 days

REGULATORY DATA

Flash Point (Typical)	Part A 32°C (90°F); Part B >101°C (214°F); Mixed 32°C (90°F)	
Product Weight	1.70 kg/l (14.2 lb/gal)	(depending on colour)
VOC	122 g/kg	EU Solvent Emissions Directive (Council Directive 1999/13/EC)

See Product Characteristics section for further details

SURFACE PREPARATION

The performance of this product will depend upon the degree of surface preparation. The surface to be coated must be clean and free from contamination. Prior to paint application all surfaces should be assessed and treated in accordance with ISO 8504:2000.

Accumulated dirt and soluble salts must be removed. Dry bristle brushing will normally be adequate for accumulated dirt. Soluble salts should be removed by fresh water washing.

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. If oxidation has occurred between blasting and application of Interzone 954BG, 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.

Hand or Power Tool Preparation

Hand or power tool clean to a minimum St3 (ISO 8501-1:2007) or SSPC-SP3 for atmospheric use only.

Note, all scale must be removed and areas which cannot be prepared adequately by chipping or needle gun should be spot blasted to a minimum standard of Sa2 (ISO 8501-1:2007) or SSPC-SP6. Typically this would apply to C or D grade rusting in this standard.

Ultra High Pressure Hydroblasting / Abrasive Wet Blasting

May be applied to surfaces prepared to Sa2 (ISO 8501-1:2007) or SSPC-SP6 which have flash rusted to no worse than Grade HB2M (refer to International Hydroblasting Standards). It is also possible to apply to damp surfaces in some circumstances. Further information is available from International Protective Coatings.

Aged Coatings

Interzone 954BG is suitable for overcoating some sound intact aged coatings. To ensure compatibility, application and evaluation of a test patch is required.

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

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

Working Pot Life

10°C (50°F)	15°C (59°F)	25°C (77°F)	40°C (104°F)
3 hours	2 hours	90 minutes	45 minutes

Airless Spray	Not suitable	
Air Spray (Pressure Pot)	Not suitable	
Air Spray (Conventional)	Not suitable	
Brush	Recommended	Typically 200-300 microns (8.0-12.0 mils) can be achieved.
Roller	Recommended	Typically 150-200 microns (6.0-8.0 mils) can be achieved.
Thinner	International GTA220 (or International GTA415)	Do not thin more than allowed by local environmental legislation.
Cleaner	International GTA822 (or International GTA415)	
Work Stoppages	Not applicable	
Clean Up	Clean all equipment immediately after use with International GTA822.	
	All surplus materials and empty containers should be disposed of in accordance with appropriate regional regulations/legislation.	

PRODUCT CHARACTERISTICS

When applying Interzone 954BG by brush or roller, 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 954BG in confined spaces ensure adequate ventilation.

In special cases where overcoating is required and curing has been at low temperatures and high relative humidities, ensure no amine bloom is present prior to application of subsequent topcoats.

Condensation occurring during or immediately after application may result in a matt finish and/or colour change.

Premature exposure to ponding water will cause a colour change, especially in dark colours.

In common with all epoxies Interzone 954BG will chalk and discolour on exterior exposure. However, these phenomena are not detrimental to anti-corrosive performance.

Where a durable cosmetic finish with good gloss and colour retention is required overcoat with recommended topcoats.

When applied between tides on jetties, piling etc., Interzone 954BG can typically be immersed after 30 minutes. This will lead to whitening of dark colours but will not affect ultimate anti-corrosive performance.

For use in atmospheric service a minimum dry film thickness of 350 microns (14 mils) is required in multiple coats when applied direct to steel, for water immersion a minimum of 450 microns (18 mils) dry film thickness is recommended.

Interzone 954BG is compatible with sacrificial and impressed current cathodic protection systems.

Interzone 954BG has an identical dry film composition to Interzone 954 and will provide equivalent performance at equivalent dry film thicknesses.

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.

SYSTEMS COMPATIBILITY

Interzone 954BG will generally be applied to bare steel prepared by dry abrasive blasting, wet abrasive blasting or ultra high pressure hydroblasting.

The following primers are recommended for Interzone 954BG:

Intercure 200	Interzinc 12 (mist or tie coat recommended)*
Intercure 200HS	Interzinc 22 (mist or tie coat recommended)*
Intergard 251	Interzinc 42
Intergard 269 (for underwater use)	Interzinc 52
Interline 982 (for underwater use)	Interzone 1000

The following topcoats are recommended for Interzone 954BG:

Interfine 629HS	Intergard 740
Interfine 691	Intersleek 167
Interfine 878	Interthane 870
Interfine 979	Interthane 990

For other suitable primers/topcoats, consult International Protective Coatings.

See relevant product data sheet for details.

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	
		Vol	Pack	Vol	Pack
	5 litre	4 litre	5 litre	1 litre	1 litre

SHIPPING WEIGHT (TYPICAL)	Unit Size	Part A	Part B
	5 litre	7.7 kg	2.1 kg

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

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