

# Interzinc 42

E p o x y - Z i n c

**Product Description**

A two component, metallic zinc epoxy primer which complies with the composition and performance requirements of SSPC Paint 29.

**Intended Uses**

As a zinc primer for application as part of a coating system for structures in aggressive environments in a wide range of industries, including offshore facilities, petrochemical plants, pulp and paper mills, bridges and power plants.

Interzinc 42 has been designed for use in maintenance situations and as a primer at new construction.

**Practical Information for Interzinc 42**

<b>Colour</b>	Red, Grey and Green			
<b>Gloss Level</b>	Matt			
<b>Volume Solids</b>	55%			
<b>Typical Thickness</b>	50-75 microns (2-3 mils) dry equivalent to 91-136 microns (3.6-5.4 mils) wet			
<b>Theoretical Coverage</b>	7.33 m <sup>2</sup> /litre at 75 microns d.f.t and stated volume solids 294 sq.ft/US gallon at 3 mils 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			
<b>Drying Time</b>				
			Overcoating Interval with recommended topcoats	
Temperature	Touch Dry	Hard Dry	<i>Minimum</i>	<i>Maximum</i>
10°C (50°F)	90 minutes	5 hours	4 hours	Extended*
15°C (59°F)	60 minutes	4 hours	3 hours	Extended*
25°C (77°F)	45 minutes	2½ hours	2 hours	Extended*
40°C (104°F)	30 minutes	90 minutes	90 minutes	Extended*

\* See International Protective Coatings Definitions & Abbreviations

**Regulatory Data**

<b>Flash Point</b>	Base (Part A) 31°C (88°F)	C/A (Part B) 32°C (90°F)	Mixed 32°C (90°F)
<b>Product Weight</b>	1.95 kg/l (16.27 lb/gal)		
<b>VOC</b>	415 g/l	UK - PG6/23(92), Appendix 3	
	3.43 lb/gal (412 g/l)	USA - EPA Method 24	

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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 8504:1992.

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

### Abrasive Blast Cleaning

Abrasive blast clean to Sa2½ (ISO 8501-1:1988) or SSPC-SP6. If oxidation has occurred between blasting and application of Interzinc 42, 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 40-75 microns (1.5-3.0 mils) is recommended.

### Shop Primed Steelwork

Interzinc 42 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 8501-1:1988) or SSPC-SP6.

## 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 parts : 1 part by volume

### Working Pot Life

10°C (50°F)	15°C (59°F)	25°C (77°F)	40°C (104°F)
24 hours	16 hours	10 hours	5 hours

### Airless Spray

Recommended - Tip range 0.43-0.53 mm (17-21 thou)  
- Total output fluid pressure at spray tip not less than 162 kg/cm<sup>2</sup> (2,300 p.s.i.)

### Air Spray (Pressure Pot)

Recommended Gun DeVilbiss MBC or JGA  
Air Cap 704 or 765  
Fluid Tip E

### Brush

Small areas only Typically 50 microns (2 mils) can be achieved

### Roller

Not recommended

### Thinner

International GTA220 Do not thin more than allowed by local (or GTA415) environmental legislation.

### Cleaner

International GTA822 (or GTA415)

### Work Stoppages

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.

### Clean Up

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 42 of 50 microns (2 mils). The film thickness of Interzinc 42 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 thickness in excess of 150 microns (6 mils).

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 42 will extend both the minimum overcoating periods and handling times, and may be detrimental to long term overcoating properties.

When Interzinc 42 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 3°C (5°F) above dew point.

This product will not cure adequately below 5°C (41°F). For maximum performance ambient curing temperatures should be above 10°C (50°F).

Interzinc 42 is not normally recommended for underwater use. Please consult International Protective Coatings for further details in this situation.

This product has the following specification approvals:

Steel Structures Painting Council - SSPC Paint 29.

## Systems Compatibility

Interzinc 42 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	Intergard 740
Intercure 200	Interseal 670HS
Intercure 420	Interthane 990
Interfine 629HS	Interzone 505
Intergard 251	Interzone 954
Intergard 269	Interzone 1000
Intergard 475HS	

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 sections of the International Protective Coatings data manual:

- 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.

<b>Pack Size</b>	10 litre unit	Interzinc 42 Base	8 litres in a 10 litre container
		Interzinc 42 Curing Agent	2 litres in a 2.5 litre container
	5 gallon unit	Interzinc 42 Base	4 gallons in a 5 gallon container
		Interzinc 42 Curing Agent	1 gallon in a 1 gallon container
	For availability of other pack sizes contact International Protective Coatings		
<b>Shipping Weight</b>	U.N. Shipping No. 1263		
	10 litre unit	19.6 kg (43.2 lb) Base (Part A)	2.1 kg (4.6 lb) Curing Agent (Part B)
	5 gallon unit	35.7 kg (79.0 lb) Base (Part A)	3.8 kg (8.3 lb) Curing Agent (Part B)
<b>Storage</b>	<b>Shelf Life</b>	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.	

## Disclaimer

*The information given in this sheet is not intended to be exhaustive and any person using the product for any purpose other than that specifically recommended in this sheet without first obtaining written confirmation from us as to the suitability of the product for the intended purpose does so at his own risk. Any warranty, if given, or specific Terms & Conditions of Sale are contained in International's Terms & Conditions of Sale, a copy of which can be obtained on request. Whilst we endeavour to ensure that all advice we give about the product (whether in this sheet or otherwise) is correct we have no control over either the quality or 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 whatsoever or howsoever arising for the performance of the product or for any loss or damage (other than death or personal injury resulting from our negligence) arising out of the use of the product. The information contained in this sheet is liable to modification from time to time in the light of experience and our policy of continuous product development.*

*It is the user's responsibility to check that this sheet is current prior to using the product. Issue date: 14/11/2002*

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## International Protective Coatings

<u>World Centre</u>	<u>Asia Region</u>	<u>Australasia Region</u>	<u>Europe Region</u>	<u>Middle East Region</u>	<u>North America Region</u>	<u>South America Region</u>
P.O Box 20980 Oriol House 16 Connaught Place London, W2 2ZB England	3 Neythal Road Jurong Town Singapore 628570	115 Hyde Road Yeronga Brisbane Queensland Australia	P.O Box 20980 Oriol House 16 Connaught Place London, W2 2ZB England	PO Box 37 Dammam 31411 Saudi Arabia	6001 Antoine Drive Houston Texas 77091	Av Paiva 999, Neves, Sao Gonçalo, Rio de Janeiro Brazil
Tel: (44) 20 7479 6000 Fax: (44) 20 7479 6500	Tel: (65) 663 3066 Fax: (65) 266 5287	Tel: (61) 7 3892 8888 Fax: (61) 7 3892 4287 H&S (61) 1800 807 001	Tel: (44) 20 7479 6000 Fax: (44) 20 7479 6500	Tel: (966) 3 812 1044 Fax: (966) 3 812 1169	Tel: (1) 713 682 1711 Fax: (1) 713 684 1514	Tel: (55) 21 624 7100 Fax: (55) 21 624 7123

### Local Office:

Tel: 0191 469 6111 Fax: 0191 495 0676