

Interzone 505

Glass Flake Epoxy



Product Description

A high solids, low VOC, high build epoxy primer/intermediate or finish coat, reinforced with chemically resistant high aspect ratio glass flake for enhanced durability and corrosion resistance.

Intended Uses

For the protection of steelwork in all corrosive environments including splashzone areas on offshore structures, underdeck, decks and above water areas, pilings, pulp and paper mills, bridges and chemical plants.

To provide excellent long term, anti-corrosive and anti-abrasion protection in both new construction and maintenance situations.

As part of a non-slip deck system in conjunction with appropriate aggregate.

Practical Information for Interzone 505

Colour	Limited range			
Gloss Level	Semi-gloss			
Volume Solids	90%			
Typical Thickness	300-500 microns (12-20 mils) dry equivalent to 333-555 microns (13.3-22.2 mils) wet			
Theoretical Coverage	2.25 m ² /litre at 400 microns d.f.t and stated volume solids 90 sq.ft/US gallon at 16 mils d.f.t and stated volume solids			
Practical Coverage	Allow appropriate loss factors			
Method of Application	Airless spray, Air spray, Brush, Roller			
Drying Time				
			Overcoating Interval with recommended topcoats	
Temperature	Touch Dry	Hard Dry	<i>Minimum</i>	<i>Maximum</i>
5°C (41°F)	20 hours	28 hours	28 hours	7 days
15°C (59°F)	6 hours	14 hours	14 hours	5 days
25°C (77°F)	3 hours	6 hours	6 hours	4 days
40°C (104°F)▲	N/A	N/A	N/A	N/A

▲ For curing at elevated temperatures an alternative curing agent is available. See Product Characteristics for details.

Regulatory Data

Flash Point	Base (Part A) 54°C (129°F)	C/A (Part B) 33°C (91°F)	Mixed 35°C (95°F)
Product Weight	1.3 kg/l (10.7 lb/g)		
VOC	157 g/l	UK - PG6/23(92), Appendix 3	
	1.71 lb/gal (205 g/l)	USA - EPA Method 24	



Ecotech is an initiative by International Protective Coatings a world leader in coating technology to promote the use of environmentally sensitive products across the globe.

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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 8504:1992.

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 Sa2 (ISO 8501-1:1988) or SSPC-SP6. If oxidation has occurred between blasting and application of Interzone 505, 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.

Ultra High Pressure Hydroblasting/Abrasive Wet Blasting

May be applied to surfaces prepared to Sa2½ (ISO 8501-1:1988) or SSPC-SP6 which have flash rusted to no worse than Grade HB2½M (refer to International Hydroblasting Standards) or grade SB2½M (refer to International Slurry Blasting Standards). It is also possible to apply to damp surfaces in some circumstances. Further information is available from International Protective Coatings.

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

1.5 parts : 1.0 part by volume

Working Pot Life

5°C (41°F)	15°C (59°F)	25°C (77°F)	40°C (104°F)▲
2½ hours	90 minutes	60 minutes	30 minutes

▲ Application at 40°C (104°F) requires the use of an alternative curing agent - see Product Characteristics.

Airless Spray

Recommended

- Tip range 0.53-0.79 mm (21-31 thou)
- Total output fluid pressure at spray tip not less than 211 kg/cm² (3,000 p.s.i.)

See Product Characteristics section for further details.

Air Spray (Pressure Pot)

Recommended	Gun	DeVilbiss MBC or JGA
	Air Cap	62
	Fluid Tip	AC

Brush

Suitable - Small areas only

Typically 75-100 microns (3-4 mils) can be achieved

Roller

Suitable - Small areas only

Typically 75-100 microns (3-4 mils) can be achieved

Thinner

International GTA220 (or GTA415)

Do not thin more than allowed by local 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

Interzone 505 is suitable for both water immersion and exterior exposure. For water immersion a minimum system thickness of 450 microns (18 mils) is required to achieve long term anti-corrosive performance. For general exterior exposure in aggressive conditions a minimum system thickness of 350 microns (14 mils) is required.

If salt water is used in the wet blast process the resulting surface must be thoroughly washed with fresh water before application of Interzone 505. With freshly blasted surfaces a slight degree of flash rusting is allowable, and is preferable to the surface being too wet. Puddles, ponding and accumulations of water must be removed.

Maximum film build in one coat is best attained by airless spray. When applying by methods other than airless spray, the required film build is unlikely to be achieved. Application by air spray may require a multiple cross spray pattern to attain maximum film build. Low or high temperatures may require specific application techniques to achieve maximum film build.

For airless spray application best results will be achieved by using 9 mm (3/8") lines with no whip ends. The pump should be a minimum of 45:1 ratio. Filters should be removed from the spray machine and gun, and fluid lines kept as short as possible.

Higher ratio pumps are recommended when long fluid lines are used.

When applying Interzone 505 by brush or roller, it may be necessary to apply multiple coats to achieve the total specified system dry film thickness.

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

This product will not cure adequately below 5°C (41°F). For maximum performance ambient curing temperatures should be above 10°C (50°F). Surface temperature must always be a minimum of 3°C (5°F) above dew point.

When applying Interzone 505 in confined spaces ensure adequate ventilation.

Condensation occurring during or immediately after application may result in a matt finish and an inferior film. Premature exposure to ponding water will cause a colour change, especially in dark colours.

Films of Interzone 505 cured at an ambient temperature of 25°C (77°F) or greater, will be suitable for immersion in water after 24 hours.

Curing is retarded underwater. Some colour change may be observed.

Elevated Temperature Curing▲

An alternative curing agent is available for applications at temperatures greater than 25°C (77°F).

Temperature	Touch Dry	Hard Dry	Overcoating Interval with recommended topcoats	
			<i>Minimum</i>	<i>Maximum</i>
40°C (104°F)	2 hours	5 hours	5 hours	2 Days

Interchanging standard and elevated temperature curing agents during application to a specific structure will give rise to an observable colour variations due to a difference in the yellowing/discolouration process common to all epoxies on exposure to UV light.

In common with all epoxies Interzone 505 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.

Interzone 505 can be used as a non-skid deck system by modification with addition of GMA132 (crushed flint) aggregate. Application should then be to a suitably primed surface. Typical thicknesses will be between 500-1,000 microns (20-40 mils). Preferred application is by a suitable large tip hopper gun (e.g. Sagola 429 or air texture gun fitted with a 5-10 mm nozzle). Trowel or roller can be used for small areas. Alternatively, a broadcast method of application can be used, consult International Protective Coatings for details.

Interzone 505 is compatible with sacrificial and impressed current cathodic protection systems.

Systems Compatibility

Interzone 505 can be applied directly to blasted steel but can also be used over the following primers for underwater systems:

Intergard 269

Interline 982

When used in aggressive exterior exposure environments the following primers are recommended for Interzone 505:

Intercure 200

Interzinc 12 (mist or tie coat recommended)*

Intergard 251

Interzinc 22 (mist or tie coat recommended)*

Intergard 269

Interzinc 42

Interline 982

Interzinc 52

Interzinc 315

The following topcoats are recommended for Interzone 505:

Interfine 629 HS

Interthane 990

Intergard 740

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

* See relevant product data sheets for details.

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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.

Pack Size	17.5 litre unit	Interzone 505 Base	10.5 litres in a 20 litre container
		Interzone 505 Curing Agent	7.0 litres in a 10 litre container
	5 gallon unit	Interzone 505 Base	3 gallons in a 5 gallon container
		Interzone 505 Curing Agent	2 gallons in a 2 gallon container
	For availability of other pack sizes contact International Protective Coatings		
Shipping Weight	U.N. Shipping No. 1263		
	20 litre unit	18.5 kg (40.8 lb) Base (Part A)	9.9 kg (21.8 lb) Curing Agent (Part B)
	5 gallon unit	15.4 kg (33.8 lb) Base (Part A)	8.3 kg (18.2 lb) Curing Agent (Part B)
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.	

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: 20/06/2002

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International Protective Coatings

Worldwide Availability

World Centre	Asia Region	Australasia Region	Europe Region	Middle East Region	North America Region	South America Region
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