

**PRODUCT DESCRIPTION**

Inorganic self curing ethyl silicate zinc primer

- Imparts outstanding corrosion protection by itself or in system.
- Resistant to rain after 20 minutes.
- **Conforms to IS: 14946 Specifications.**
- **Conforms to SSPC- Paint 20 –Type 1-Level II specification.**
- **Zinc content conforms to ASTM- D520 Type II**

**INTENDED USES**

As a metallic zinc pigmented primer to provide excellent protection to steel substrates for use with a wide range of high performance system in offshore and onshore environments

Including oil production platforms, refineries, bridges, tanks, pipe work and structural Steelwork.

Can be used for new construction and as fast drying primer, capable of application in a wide range of climatic conditions including low temperatures.

**Meets to IS: 14946 Specifications.**

**Meets SSPC- Paint 20 –Type 1-Level II specification.**

**PRACTICAL INFORMATION FOR INTERZINC 78**

<b>Colour</b>	Metallic Grey
<b>Gloss Level</b>	Matt
<b>Volume Solids</b>	60 ± 2 % (depends on Colour)
<b>Typical Thickness</b>	50 – 75 microns (2.0 - 3.0 mils) dry equivalent to 83 - 125microns ( 3.3 – 5.0) wet
<b>Theoretical Coverage</b>	8.0 m <sup>2</sup> / liter at 75 microns dft and stated volume solids.
<b>Practical Coverage</b>	Allow appropriate loss factors.
<b>Method of Application</b>	Airless spray, Brush, Roller, Air spray

**Drying Time**

Temperature	Touch Dry	Hard Dry	Over coating Interval with recommended Topcoats $\sigma$	
			<i>Minimum</i>	<i>Maximum</i>
5° C (50° F)	20 minutes	1 hour	48 hours	Extended*
15° C (59° F)	15 minutes	45 minutes	34 hours	Extended*
25° C (77° F)	10 minutes	30 minutes	24 hours	Extended*
40° C (104° F)	5 minutes	15 minutes	12 hours	Extended*

$\sigma$  Over coating is dependent upon ambient conditions. The figures quoted above have been determined at the quoted dry film thickness, temperature and 65% relative humidity. See Product characteristics for further advice.

\* See International Protective Coatings Definitions and Abbreviations

**REGULATORY DATA**

Flash Point	Binder (Part-A)	Powder (Part-B)	Mixing
	>20°C(68°F)	N/A	>20°C(68°F)
Specific Gravity	2.30 Kg /Liter		

**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 **Inorganic Zinc-rich silicate: IS 14946**

Oil and grease should be removed in accordance with SSPC-SP-1 solvent cleaning

New Steel

Abrasive blast clean to Sa2½ (ISO 8501-1:1988) or SSPC SP 6. If oxidation has occurred between blasting and application of Interzinc 78i, 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.

**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 Part (XHA177) : 3.98 Parts (XHA178) by volume  
60 Part (XHA 177): 40 Parts (XHA 178) by Weight.

**Working Pot  
life**

10°C (50°F)	15°C (59°F)	25°C (77°F)	40°C (104°F)
12 hours	8 hours	4 hours	2 hours

**Airless Spray**

Recommended - Tip range 0.38-0.53mm (15-21 thou)  
Total output fluid pressure at spray tip not  
Less than 112Kg/cm<sup>2</sup> (1600 psi)

**Air Spray  
(Pressure Pot)**

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

**Brush**

Small areas only - Typically 20–25 microns (0.8-1.0 mil)  
Can be achieved

**Roller**

Not recommended

**Thinner**

International GTA803 depending upon site conditions

**Cleaner**

International GTA803

**Work  
Stoppages**

Do not allow material to remain in hoses, gun or spray equipment; Thoroughly flush all equipment with International GTA803. 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 GTA 803. 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.

**PRODUCT  
CHARACTERISTICS**

Interzinc 78i should be applied by spray. Application by other methods, e.g. Brush should only be used for small areas, stripe coats or touch up.

Surface temperature must always be a minimum of 3 °C (5 °F) above dew point. If applying Interzinc 78i in confined spaces ensure adequate ventilation.

Prior to overcoating, Interzinc 78i must be clean, dry and free from both soluble salts and excessive zinc corrosion products.

The minimum overcoating interval is dependent upon the ambient temperature and relative humidity during application and curing period. At relative humidities below 50% curing will be severely retarded and humidity may be needed to be increased by steam or water spraying.

Excessive film thickness and or/over application of Interzinc 78i will lead to mud cracking, which will require complete removal of the affected areas by abrasive blasting and re-application in accordance with the original specification.

Dry times are given for typical thickness. Film builds above this will yield slower overcoat times.

Untopcoated Interzinc 78i is not suitable for exposure in acid or alkaline conditions or continuous water immersion.

For high temperature service, the thickness of Interzinc 78 should be restricted to 50

Microns (2mils) dry film thickness. Continuous dry temperature resistance of Interzinc 78i is 400°C (752°F) if left untopcoated, however, if this product is used as a primer for Interzinc 78i the dry temperature resistance will be 540°C (1004°F).

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**SYSTEM  
COMPATABILITY**

Before overcoating with recommended topcoats ensure the Interzinc 78 is fully cured, and if weathering has occurred ,Intergard 269 primer can be used as a sealer coat to eliminate Bubbling problems.

Typical top coats are :

Intergard 251	Intergard 906
Intergard 475 HS	
Interseal 670 HS	Intergard 966
Interseal 547	Intergard HB Epoxy
Intergard 400	Intergard 410
Intertherm 50	Intercure 420

For other suitable primers/topcoats consult International Protective Coatings.

**ADDITIONAL  
INFORMATION**

For 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
  - Practical & Theoretical Coverage
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**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 of 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.

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<b>PACK SIZE</b>	60 liters units	Interzinc 78i(Part A) Interzinc 78i(Part B)	315.98 liters in 20 liter plastic carboy 3 x 4.02 liters in a 20litre Pail
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For availability of other pack sizes contact International Protective Coatings

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**STORAGE** Shelf life : 6 months minimum at 25°C (77°F).subject to re-inspection thereafter. store in dry, shaded

conditions away from sources of heat & ignition.

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### 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 of 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 given 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 end 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 sheet is liable to modification from time to time in the light of experience and our policy of continuous product development.*

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