

PRODUCT DESCRIPTION

A two component, glass flake reinforced ambient cure polyester coating.

INTENDED USES

As a high performance anti-corrosive coating for application at new construction where high build and fast cure combine to optimise the throughput of steelwork and minimise production overheads.

For the protection of steelwork exposed in aggressive environments such as offshore structures, chemical and petrochemical plants, pulp and paper mills and power plants.

Can also be applied as a maintenance coating on site where its fast cure and high build characteristics help to minimise downtime and keep maintenance costs to a minimum.

PRACTICAL INFORMATION FOR INTERZONE 2000

Colour	Limited range
Gloss Level	Semi Gloss
Volume Solids	100% reactive, although determined volume solids depends upon the application conditions. A recommended working figure is 85%.
Typical Thickness	500-1000 microns (20-40 mils) dry equivalent to 588-1176 microns (23.5-47 mils) wet
Theoretical Coverage	1.70 m ² /litre at 500 microns d.f.t and stated volume solids 68 sq.ft/US gallon at 20 mils d.f.t and stated volume solids
Practical Coverage	Allow appropriate loss factors
Method of Application	Airless Spray, Brush

Drying Time

Temperature	Touch Dry	Hard Dry	Overcoating Interval with recommended topcoats	
			<i>Minimum</i>	<i>Maximum</i>
10°C (50°F)	4 hours	7 hours	7 hours	3 days
15°C (59°F)	4 hours	7 hours	7 hours	3 days
25°C (77°F)	4 hours	7 hours	7 hours	3 days
35°C (95°F)	2 hours	2 hours	5 hours	3 days

These dry times have been obtained using the recommended amount of retarder for each temperature (see Product Characteristics).

REGULATORY DATA

Flash Point	Part A 28°C (82°F); Part B 100°C (212°F); Mixed 28°C (82°F)	
Product Weight	1.20 kg/l (10.0 lb/gal)	
VOC	0.29 lb/gal (35 g/l) 29 g/kg	EPA Method 24 EU Solvent Emissions Directive (Council Directive 1999/13/EC)

See Product Characteristics section for further details

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 8504:2000.

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 2000, 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 75-100 microns (3-4 mils) is recommended.

If a holding primer is required for Interzone 2000 then only the use of Interline 949 is advised. Alternatively, the blast standard can be maintained by the use of dehumidification.

Shop Primed Steel

Prior to application of Interzone 2000, all shop primed steelwork must be re-blasted to a visual standard as outlined above.

APPLICATION

Mixing	<p>Interzone 2000 MUST be applied in accordance with the detailed Application Procedures for vinyl and polyesters which are available upon request.</p> <p>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.</p> <p>(1) Agitate Base (Part A) with a power agitator. (2) Combine entire contents of Initiator (Part B) with Base (Part A) and mix thoroughly with power agitator.</p> <p>An optional retarder solution is available for this material. See Product Characteristics for details.</p>			
Mix Ratio	65.6 part(s) : 1.00 part(s) by volume			
Working Pot Life	10°C (50°F) 1 hour	15°C (59°F) 1 hour	25°C (77°F) 1 hour	35°C (95°F) 1 hour
	See Product Characteristics for details of quantity of retarder to be used			
Airless Spray	Recommended	Tip Range 0.63-0.89 mm (25-35 thou) Total output fluid pressure at spray tip not less than 211 kg/cm ² (3000 p.s.i.)		
Air Spray (Pressure Pot)	Not recommended			
Brush	Suitable - small areas only	Typically 75 microns (3.0 mils) can be achieved		
Roller	Not recommended			
Thinner	Not suitable	DO NOT THIN		
Cleaner	International GTA853	N.B Clean all equipment immediately after use.		
Work Stoppages	Do not allow material to remain in hoses, gun or spray equipment. Thoroughly flush all equipment with International GTA853. 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 GTA853. 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

The detailed guidelines for the application of vinyl esters and polyesters should be consulted prior to the use of Interzone 2000.

Interzone 2000 can be applied in a wide range of climatic conditions, including elevated material temperatures up to 35°C (95°F). However, at material temperatures greater than 15°C (59°F) the use of a retarder solution is required in order to maintain the working pot life, allowing normal airless spray methods to be employed. The recommended level of retarder is as follows:

<15°C (59°F)	No retarder required
15-25°C (59-77°F)	1 unit retarder required
26-35°C (79-95°F)	2 units retarder required

These volumes of retarder will maintain the pot life at approximately 1 hour. The retarder must always be added to the base prior to the addition of the initiator and mixed thoroughly using a power agitator.

Maximum steel temperature at the time of application is 60°C (140°F) and maximum relative humidity during the application and cure period is 80%.

Although Interzone 2000 is theoretically a 100% reactive mix, actual theoretical coverage rates can vary between 1.7m²/litre (68.2 sq.feet/US gallon) and 1.96 m²/litre (78.6 sq.feet/US gallon) at 500 microns (20 mils) dry film thickness. This is dependent on application and cure conditions.

Apply by airless spray only. Application by other methods, e.g. brush or roller, may require more than one coat and is suggested for small areas only or initial stripe coating.

This product must **not** be thinned as the use of thinners may severely inhibit the curing mechanism of the coating.

This product will not cure adequately below 5°C (41°F). For maximum performance ambient curing temperatures should be above 15°C (59°F).

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

Maximum continuous dry temperature resistance for Interzone 2000 is 60°C (140°F).

Interzone 2000 is not intended to be used as a cosmetic finish and colour stability will not be achievable. Where a durable cosmetic finish with good gloss and colour retention is required overcoat with recommended topcoats.

In order to attain the maximum degree of colour stability, the use of an optional wax solution is essential. This should be added with the retarder during mixing, prior to the addition of the initiator. See detailed Application Procedures for further advice.

The wax solution must only be used in the final coat as it will impair intercoat adhesion.

Interzone 2000 is also available as a non-skid option for deck areas. Consult International Protective Coatings for details.

Elevated storage temperatures reduce shelf life. Avoid storage above 35°C (95°F). Uncatalysed Interzone 2000 is stable for 6 months from date of manufacture when stored below 25°C (77°F) in its original sealed containers. Interzone 2000 should never be stored in direct sunlight. If necessary, refrigerated storage can be used to prolong shelf life at elevated temperatures and ensure that the working pot life can be achieved.

Under direct sunlight exposures or when surface temperatures exceed 35°C (95°F), Interzone 2000 should be recoated as soon as the coating will support foot traffic, in order to prevent the possibility of intercoat disbondment.

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.

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

Interzone 2000 is normally applied to suitably prepared steel, e.g. blast cleaned. If necessary, application over a holding primer is possible, however, this is limited to:

Interline 949

Recommended cosmetic topcoats for exposed high profile areas are:

Interfine 629HS
Intergard 740
Interthane 990

For other suitable topcoats, consult International Protective Coatings.

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 the following information are available upon request:

- Detailed Application Guidelines: Vinyl & Polyesters

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
	20 litre	19.7 litre	20 litre	0.3 litre	0.5 litre
The optional retarder and wax solution for this product are available as follows: Retarder 40ml in a 100ml container; Wax Solution 300ml in a 500ml container.					
For availability of other pack sizes, contact International Protective Coatings.					
SHIPPING WEIGHT	Unit Size	Part A		Part B	
		25.9 kg		0.4 kg	
	20 litre				
STORAGE	Shelf Life	6 months minimum at 25°C. Subject to re-inspection thereafter. Store in dry, shaded conditions away from sources of heat and ignition.			

Important Note

The information in this data sheet is not intended to be exhaustive; any person using the product for any purpose other than that specifically recommended in this data sheet without first obtaining written confirmation from us as to the suitability of the product for the intended purpose does so at their own risk. All advice given or statements made about the product (whether in this data sheet or otherwise) is correct to the best of our knowledge but we have no control over the quality or the 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 at all for the performance of the product or for (subject to the maximum extent permitted by law) any loss or damage arising out of the use of the product. We hereby disclaim any warranties or representations, express or implied, by operation of law or otherwise, including, without limitation, any implied warranty of merchantability or fitness for a particular purpose. All products supplied and technical advice given are subject to our Conditions of Sale. You should request a copy of this document and review it carefully. The information contained in this data sheet is liable to modification from time to time in the light of experience and our policy of continuous development. It is the user's responsibility to check with their local International Paint representative that this data sheet is current prior to using the product.

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