

PRODUCT DESCRIPTION

A fast drying, two component, weldable zinc silicate pre-fabrication primer for application by manual or automatic spray.

INTENDED USES

As a temporary protective primer for the coating of steelwork prior to the fabrication process.

Suitable for overcoating with a wide range of high performance coating systems for use in a variety of environments, including offshore structures, marine environments, chemical and petrochemical plants, power stations and bridges.

PRACTICAL INFORMATION FOR INTERPLATE 855

Colour	Red Brown, Grey
Gloss Level	Matt
Volume Solids	25% ± 2%
Typical Thickness	10-20 microns (0.4-0.8 mils) dry equivalent to 40-80 microns (1.6-3.2 mils) wet
Theoretical Coverage	16.70 m ² /litre at 15 microns d.f.t and stated volume solids 668 sq.ft/US gallon at 0.6 mils d.f.t and stated volume solids
Practical Coverage	Allow appropriate loss factors
Method of Application	Airless Spray, Air Spray
Drying Time	

Temperature	Touch Dry	Hard Dry	Overcoating Interval with recommended topcoats	
			Minimum	Maximum
10°C (50°F)	3 minutes	8 minutes	7 days	Extended ¹
15°C (59°F)	3 minutes	8 minutes	7 days	Extended ¹
25°C (77°F)	3 minutes	5 minutes	7 days	Extended ¹
40°C (104°F)	3 minutes	3 minutes	7 days	Extended ¹

¹ See International Protective Coatings Definitions and Abbreviations

REGULATORY DATA

Flash Point	Part A 5°C (41°F); Part B 10°C (50°F); Mixed 13°C (55°F)	
Product Weight	1.32 kg/l (11.0 lb/gal)	
VOC	5.24 lb/gal (628 g/lt) 472 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.

Where necessary, remove weld spatter and smooth weld seams and sharp edges.

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 Interplate 855, 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.

The blast profile achieved should have an angular configuration. Blasting media should be steel grit of a nominal size of 0.6-1.0 mm (24-40 thou) or a mixture with steel shot of a nominal size of 0.6-1.4 mm (24-56 thou).

This product is NOT recommended over hand prepared steel.

APPLICATION

Mixing	Interplate 855 is supplied in 2 parts, a Paste component (Part A) and a liquid Binder component (Part B). The liquid Binder (Part B) should be slowly added to the Paste (Part A) whilst stirring with a mechanical agitator. DO NOT ADD PASTE TO LIQUID. Material should be filtered prior to application and should be constantly agitated in the pot during spraying. Once the unit has been mixed, it should be used within the working pot life specified.			
	This is a low viscosity material and agitation is required during application to ensure homogeneity is maintained.			
Mix Ratio	0.67 part(s) : 1.00 part(s) by volume			
Working Pot Life	10°C (50°F) 24 hours	15°C (59°F) 24 hours	25°C (77°F) 24 hours	40°C (104°F) 7 hours
Airless Spray	Recommended	Automatic plant preferred: Tip range 0.53-0.64 mm (21-25 thou) Manual application: Tip range 0.38-0.58 mm (15-23 thou) Total output fluid pressure at spray tip not less than 60 kg/cm ² (850 p.s.i.)		
Air Spray (Pressure Pot)	Recommended	Gun Air Cap Fluid Tip	DeVilbiss MBC or JGA 704 or 765 E	
Air Spray (Conventional)	Recommended	Use suitable proprietary equipment		
Brush	Suitable - Touch up and small areas only			
Roller	Suitable - Touch up and small areas only			
Thinner	International GTA820	Do not thin more than allowed by local environmental legislation		
Cleaner	International GTA820			
Work Stoppages	Do not allow material to remain in hoses, guns or spray equipment. Thoroughly flush all equipment with International GTA820. 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 GTA820. 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, relative humidity 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

Satisfactory welding properties will only be obtained by strict control of application to the recommended film thickness. Over application of Interplate 855 will result in increased levels of weld fume on cutting and welding, and will also increase the porosity of the welds.

Interplate 855 is designed for application by automatic plant; if small areas are to be hand sprayed, take care to avoid dry spray and over-application.

Note, this product dries too quickly to enable accurate wet film thickness measurements.

Failure to obtain an even film and coverage of blast profile will result in rapid rash rusting on exposure to weathering.

The drying times quoted are for the recommended dry film thickness at the stated temperatures when using automated processes. Failure to adhere to these parameters can result in damage to equipment, rollers and disruption of the coated surface due to handling damage on stacking.

Thicker films of Interplate 855 will provide longer periods of corrosion resistance, but will compromise welding, cutting and handling properties. In most environments to obtain 6-9 months protection 25 microns (1 mil) is the recommended dry film thickness.

Satisfactory curing for overcoating within 24 hours will not be achieved at relative humidities less than 50%. At relative humidities below 50%, curing will be severely retarded and humidity may need to be increased by steam or water spraying.

Interplate 855 is compatible with sacrificial and impressed current cathodic protection systems.

Prior to overcoating, Interplate 855 must be clean, dry and free from both soluble salts and excessive zinc corrosion products.

For further information on application, handling and weathering properties, consult International Protective Coatings.

This product has the following specification approvals:

- Lloyd's Register of shipping - Welding Approval of Prefabrication Primer
- Det Norske Veritas - Welding Approval on Blast Cleaned Steel

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

Interplate 855 can be overcoated with a wide range of high performance topcoats including:

Intercure 200	Interseal 670HS
Intercure 420	Interzone 505
Intergard 251	Interzone 954
Intergard 269	Interzone 1000
InterH2O 401	

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	
	20 litre	8 litre	20 litre	12 litre	15 litre
SHIPPING WEIGHT	Unit Size	Part A		Part B	
	20 litre	17.7 kg		11.4 kg	
STORAGE	Shelf Life	Part A - 12 months minimum at 25°C (77°F). Part B - 6 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

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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SKE Beschichtungssysteme GmbH | Buchenring 11 | D-21272 Egestorf
 Fon +49 (0) 4175 / 808 99 -31 | Fax +49 (0) 4175 / 808 99 -32
 E-Mail: info@ske-beschichtungen.de | www.ske-beschichtungen.de