

## Zinc Silicate Shop Primer

**PRODUCT DESCRIPTION** A two pack zinc silicate shop (pre-construction) primer designed to give good welding and cutting performance and good weathering properties.

**INTENDED USES** As a shop (pre-construction) primer for the protection of steel during fabrication and assembly. Suitable for use with controlled cathodic protection. For use at Newbuilding.

**PRODUCT INFORMATION**

<b>Colour</b>	NQA805-Dark Grey
<b>Finish/Sheen</b>	Not applicable
<b>Part B (Curing Agent)</b>	NQA806
<b>Volume Solids</b>	30% ±2% (ISO 3233:1998)
<b>Mix Ratio</b>	1 volume(s) Part A to 1 volume(s) Part B
<b>Typical Film Thickness</b>	15 microns dry (50 microns wet)
<b>Theoretical Coverage</b>	20.00 m <sup>2</sup> /litre at 15 microns dft, allow appropriate loss factors
<b>Method of Application</b>	Airless Spray, Brush, Conventional Spray, Roller
<b>Flash Point (Typical)</b>	Part A 5°C; Part B 10°C; Mixed 10°C
<b>Induction Period</b>	Not required

<b>Drying Information</b>	25°C	30°C	35°C	40°C
Hard Dry [ISO 9117-1:2009]	7 mins	6 mins	5 mins	4 mins
Pot Life	24 hrs	18 hrs	12 hrs	8 hrs

<b>Overcoating Data - see limitations</b>	<b>Substrate Temperature</b>							
	25°C		30°C		35°C		40°C	
<b>Overcoated By</b>	Min	Max	Min	Max	Min	Max	Min	Max

**Note** Consult International Paint, minimum of 24 hours for appropriate primers.

**REGULATORY DATA**

<b>VOC</b>	620 g/lit as supplied (EPA Method 24) 370 g/kg of liquid paint as supplied. EU Solvent Emissions Directive (Council Directive 1999/13/EC)
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**Note:** VOC values are typical and are provided for guidance purposes only. These may be subject to variation depending on factors such as differences in colour and normal manufacturing tolerances.

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### CERTIFICATION

When used as part of an approved scheme, this material has the following certification:

- Weld Quality - Approval of Prefabrication Primers (LR)

Consult your International Paint representative for details.

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### SYSTEMS AND COMPATIBILITY

Consult your International Paint representative for the system best suited for the surfaces to be protected.

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### SURFACE PREPARATIONS

Use in accordance with the standard Worldwide Marine Specifications.

All surfaces to be coated should be clean, dry and free from contamination.

High pressure fresh water wash or fresh water wash, as appropriate, and remove all oil or grease, soluble contaminants and other foreign matter in accordance with SSPC-SP1 solvent cleaning.

#### NEWBUILDING

Shop primers should be applied using automatic blasting/spraying equipment.

Abrasive blast clean to Sa2½ (ISO 8501-1:2007). If oxidation has occurred between blasting and application of Interplate 805, the surface should be reblasted to the specified visual standard.

Steel grit or a mixture of steel grit of particle size 0.6 - 1.0 mm and steel shot of particle size 0.6 - 1.4 mm are normally used to give a predominantly angular profile

Ensure that the area is clean and dry prior to application of Interplate 805.

Consult your International Paint representative for specific recommendations.

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### APPLICATION

<b>Mixing</b>	Interplate 805 is supplied in 2 parts, a liquid Binder component (Part B) and a Paste component (Part A). The Binder (Part B) should be slowly added to the Paste (Part A) whilst stirring with a mechanical agitator. <b>DO NOT ADD PASTE TO LIQUID.</b> Material should be sieved 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. This is a low viscosity material and agitation is required during application to ensure homogeneity is maintained.
<b>Thinner</b>	International GTA803. Do not thin more than allowed by local environmental legislation.
<b>Airless Spray</b>	Recommended Tip Range 0.46-0.53 mm (18-21 thou) Total output fluid pressure at spray tip not less than 70 - 141 kg/cm <sup>2</sup> (1000 - 2010 p.s.i.)
<b>Conventional Spray</b>	Suitable. Suitable. Use suitable proprietary equipment. Thinning may be required.
<b>Brush</b>	Application by brush is recommended for small areas only.
<b>Roller</b>	Application by roller is recommended for small areas only.
<b>Cleaner</b>	International GTA822
<b>Work Stoppages and Cleanup</b>	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 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. Do not exceed pot life limitations. All surplus materials and empty containers should be disposed of in accordance with appropriate regional regulations/legislation.
<b>Welding</b>	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. In North America do so in accordance with instruction in ANSI/ASC Z49.1 "Safety in Welding and Cutting."

### SAFETY

**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.**

**Prior to use, obtain, consult and follow the Material Safety Data Sheet for this product concerning health and safety information. Read and follow all precautionary notices on the Material Safety Data Sheet and container labels. If you do not fully understand these warnings and instructions or if you can not strictly comply with them, do not use this product. Proper ventilation and protective measures must be provided during application and drying to keep solvent vapour concentrations within safe limits and to protect against toxic or oxygen deficient hazards. Take precautions to avoid skin and eye contact (ie. gloves, goggles, face masks, barrier creams etc.) Actual safety measures are dependant on application methods and work environment.**

#### **EMERGENCY CONTACT NUMBERS:**

**USA/Canada - Medical Advisory Number 1-800-854-6813**

**Europe - Contact (44) 191 4696111. For advice to Doctors & Hospitals only contact (44) 207 6359191**

**R.O.W. - Contact Regional Office**

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### LIMITATIONS

Drying times will depend on the substrate temperature and ventilation conditions. If the relative humidity is below 50%, cure will be retarded. Interplate 805 is not recommended for manual spray application. Shop primers are not recommended for use as touch-up primers after fabrication. Overcoating information is given for guidance only and is subject to regional variation depending upon local climate and environmental conditions. Consult your local International Paint representative for specific recommendations. The temperature of the surface to be coated must be at least 3°C above the dew point. For optimum application properties bring the material to 21-27°C, unless specifically instructed otherwise, prior to mixing and application. Unmixed material (in closed containers) should be maintained in protected storage in accordance with the information given in the STORAGE section of this data sheet. Technical and application data herein is for the purpose of establishing a general guideline of the coating and proper coating application guidelines. Test performance results were obtained in a controlled laboratory environment and International Paint makes no claim that the exhibited published test results, or any other tests, accurately represent results actually found in all field environments. As application, environmental and design factors can vary significantly, due care should be exercised in the selection, verification of performance and use of the coating.

UNIT SIZE	Unit Size	Part A		Part B	
		Vol	Pack	Vol	Pack
	20 lt	10 lt	20 lt	10 lt	10 lt

*For availability of other unit sizes consult International Paint*

UNIT SHIPPING WEIGHT (TYPICAL)	Unit Size	Unit Weight
	20 lt	36.35 Kg

STORAGE	Shelf Life	12 months minimum at 25°C. Subject to re-inspection thereafter. Store in dry, shaded conditions away from sources of heat and ignition.

**WORLDWIDE AVAILABILITY** Consult International Paint.

### 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 representative that this data sheet is current prior to using the product.*

*This Technical Data Sheet is available on our website at [www.international-marine.com](http://www.international-marine.com) or [www.international-pc.com](http://www.international-pc.com), and should be the same as this document. Should there be any discrepancies between this document and the version of the Technical Data Sheet that appears on the website, then the version on the website will take precedence.*

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