Interzinc® 52E

Rapid Recoat Epoxy Zinc Rich

PRODUCT DESCRIPTION

A two component, high solids, fast drying, rapid recoat, metallic zinc-rich epoxy primer which complies with the compositional requirements of ISO 12944 Part 5. Interzinc 52E also complies with the compositional and performance requirements of SSPC Paint 20.

Interzinc 52E uses zinc dust conforming to the requirements of ASTM D520 Type II as a minimum.

INTENDED USES

As a high performance primer to give maximum protection as part of any anti-corrosive coating system for aggressive environments including those found on offshore structures, petrochemical facilities, pulp and paper plants, bridges and power plants.
Interzinc 52E has been designed to provide excellent corrosion resistance in new construction situations.

PRACTICAL INFORMATION FOR INTERZINC 52E

Colour	Grey
Gloss Level	Matt
Volume Solids	65%
Typical Thickness	50-100 microns (2-4 mils) dry equivalent to 77-154 microns (3.1-6.2 mils) wet
Theoretical Coverage	13 m²/litre at 50 microns d.f.t and stated volume solids 521 sq.ft/US gallon at 2 mils d.f.t and stated volume solids
Practical Coverage	Allow appropriate loss factors
Method of Application	Airless Spray, Air spray, Brush

Drying Time

			Overcoating Interval with recommended topcoats	
Temperature	**Touch Dry**	**Hard Dry**	*Minimum*	*Maximum*
5°C (41°F)	45 minutes	4 hours	3 hours	Extended[1]
10°C (50°F)	30 minutes	3 hours	2 hours	Extended[1]
25°C (77°F)	15 minutes	90 minutes	45 minutes	Extended[1]
40°C (104°F)	15 minutes	45 minutes	30 minutes	Extended[1]

[1] See International Protective Coatings Definitions and Abbreviations
Maximum overcoating intervals are shorter when using polysiloxane or Chartek topcoats. Consult International Protective Coatings for further details.
To ensure good aged overcoating of Interzinc 52E by other materials the surface must be thoroughly clean, dry and free of any white zinc salts.

REGULATORY DATA

Flash Point (Typical)	Part A 28°C (82°F); Part B 32°C (90°F); Mixed 31°C (88°F)	
Product Weight	2.23 kg/l (18.6 lb/gal)	
VOC	2.50 lb/gal (300 g/lt)	EPA Method 24
	143 g/kg	EU Solvent Emissions Directive (Council Directive 2010/75/EU)
	298 g/lt in accordance with Korea Clean Air Conservation Act	

Coating hazard marker GB 30981.2-S-Pb≤1000-NC Qualified for GB 30981.2-2025

See Product Characteristics section for further details

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SURFACE PREPARATION

All surfaces to be coated should be clean and free from contamination. Prior to 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 Interzinc 52E, 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 sharp, angular surface profile of 40-75 microns (1.6-3.0 mils) is recommended.

Shop Primed Steelwork

Interzinc 52E may be applied to zinc shop primers which have been sweep blasted.

Weld seams and damaged areas should be cleaned to a minimum St3 (ISO 8501-1:2007) or SSPC -SP3. Optimum performance will be achieved with blasting to Sa2½ (ISO 8501-1:2007) or SSPC-SP6; where this is not practical, power tool preparation to SSPC-SP11 is recommended.

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

9 part(s) : 1 part(s) by volume

Working Pot Life

5°C (41°F)	10°C (50°F)	25°C (77°F)	40°C (104°F)
4 hours	90 minutes	75 minutes	30 minutes

Airless Spray	Recommended	Tip Range 0.43-0.53 mm (17-21 thou) Total output fluid pressure at spray tip not less than 176 kg/cm² (2503 p.s.i.)
Air Spray (Pressure Pot)	Recommended	Gun: DeVilbiss MBC or JGA Air Cap: 704 or 765 Fluid Tip: E
Brush	Suitable	Typically 2.0-3.0 mils (50-75 microns) can be achieved
Roller	Not recommended	
Thinner	International GTA220	Thinning is not normally required. Consult the local representative for advice during application in extreme conditions. Do not thin more than allowed by local environmental legislation.
Cleaner	International GTA220	Choice of cleaner maybe subject to local legislation. Please consult your local representative for specific advice.

Work Stoppages

Do not allow material to remain in hoses, gun or spray equipment. Thoroughly flush all equipment with International GTA220. 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 GTA220. 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

In order to ensure good anti-corrosive performance, it is important to achieve a minimum dry film thickness of Interzinc 52E of 50 microns (2 mils). The film thickness of Interzinc 52E applied must be compatible with the blast profile achieved during surface preparation. Low film thickness should not be applied over coarse blast profiles.

Care should be exercised to avoid the application of dry film thicknesses in excess of 150 microns (6 mils).

Care should be exercised to avoid over-application, which may result in cohesive film failure with subsequent high builds, and to avoid dry spray which can lead to pinholing of subsequent coats. Over-application will also result in slower curing and extended handling and overcoating times.

Over-application of Interzinc 52E will extend both the minimum overcoating periods and handling times, and may be detrimental to long term overcoating properties.

When Interzinc 52E is allowed to weather before topcoating ensure all zinc salts are removed prior to paint application and only topcoat with recommended materials.

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

Interzinc 52E is not normally recommended for underwater use. Please consult International Protective Coatings for details in this situation.

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

Interzinc 52E is normally applied directly to blast cleaned steel.

Recommended topcoats/intermediates are:

Interfine 979	Interseal 670HS
Intergard 251HS	Interthane 990
Intergard 269	Interthane 990E
Intergard 345	Interzone 954
Intergard 475HS	Interzone 1000

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 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 Safety Data Sheet and the container(s), and should not be used without reference to the Safety Data Sheet (SDS).

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 AkzoNobel for further advice.

PACK SIZE	Unit Size	Part A		Part B	
		Vol	Pack	Vol	Pack
	10 litre	9 litre	10 litre	1 litre	1 litre
	For availability of other pack sizes, contact AkzoNobel.				

SHIPPING WEIGHT (TYPICAL)	Unit Size	Part A	Part B
	10 litre	22.5 kg	1.1 kg

STORAGE	Shelf Life	12 months 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 representative that this data sheet is current prior to using the product.

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