Interzone® 278

Epoxy

PRODUCT DESCRIPTION

A low VOC, two component high build, high solids, epoxy immersion coating.

Designed to give long term protection in a single coat for immersion service situations. A winter curing agent is available to assist faster turn around times in cold conditions.

INTENDED USES

A single product, immersion coating system suitable for the storage of fresh or salt water.

An extremely tough and damage resistant coating that can be applied up to 500 microns (20 mils) DFT in a single coat. Also suitable for certain atmospheric applications where chemical splash and spill resistance to petroleum products, aliphatic solvents, alkalis and other chemical products is required.

Not suitable for use as a chemically resistant tank lining, or in situations where continuous chemical contact will occur.

PRACTICAL INFORMATION FOR INTERZONE 278

Colour	Limited Colours
Gloss Level	Semi Gloss
Volume Solids	83%
Typical Thickness	200-500 microns (8-20 mils) dry equivalent to 241-602 microns (9.6-24.1 mils) wet
Theoretical Coverage	2.77 m²/litre at 300 microns d.f.t and stated volume solids 111 sq.ft/US gallon at 12 mils d.f.t and stated volume solids
Practical Coverage	Allow appropriate loss factors
Method of Application	Airless spray, Brush, Roller

Drying Time

			Overcoating interval with self	
Temperature	**Touch Dry**	**Hard Dry**	*Minimum*	*Maximum*
10°C (50°F)	12 hours	48 hours	48 hours	14 days
15°C (59°F)	8 hours	30 hours	30 hours	10 days
25°C (77°F)	4 hours	16 hours	16 hours	5 days
40°C (104°F)	2 hours	8 hours	8 hours	48 hours

REGULATORY DATA

Flash Point (Typical)	Part A 10°C (50°F); Part B 65°C (149°F); Mixed 10°C (50°F)	
Product Weight	1.7 kg/l (14.2 lb/gal)	
VOC	170 g/lt	Calculated
	160 g/lt	Chinese National Standard GB23985

Coating hazard marker GB 30981.2-W-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, dry and free from contamination. Prior to application all surfaces should be assessed and treated in accordance with ISO 8504:2000

Abrasive Blast Cleaning
For immersion service, Interzone 278 must be applied directly to surfaces blast cleaned to a minimum of Sa2½ (ISO 8501-1:2007) SSPC SP10, however Interzone 278 is also suitable for a limited number of atmpospheric applications where chemical resistance to splashes and spills is required. When used in atmospheric applications Interzone 278 should be applied over an approved anti-corrosive primer.

Primed Surfaces
The primer surface should be dry and free from all contamination and Interzone 278 must be applied within the overcoating intervals specified (consult the relevant product data sheet). Areas of breakdown, damage etc., should be prepared to the specified standard and patch primed prior to the application of Interzone 278.

Galvanised Steel
Degrease to SSPC-SP1 and lightly abrasive blast to SSPC SP7 or power tool prepare to SSPC SP3 then apply full coat of Interzone 278.

Concrete
Concrete should be cured for a minimum of 28 days prior to coating. The moisture content of the concrete should be below 6%. All surfaces should be clean, dry and free from curing compounds, release agents, trowelling compounds, surface hardeners, efflorescence, grease, oil, dirt, old coatings and loose or disintegrating concrete. All poured and precast concrete must also be sweep blasted (preferred) or acid etched to remove laitence. Large cracks should be filled with the appropriate filler. First coat may require thinning to assist penetration of the substrate.

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

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

Working Pot Life

10°C (50°F)	15°C (59°F)	25°C (77°F)	40°C (104°F)
4 hours	2 hours	1 hour	30 minutes

Airless Spray	Recommended	Tip Range 0.53-0.66 mm (21-26 thou) Total output fluid pressure at spray tip not less than 211 kg/cm² (3000 p.s.i.)	
Air Spray (Pressure Pot)	Suitable-Thin up to 20% (Note: Air Spray suitable for atmospheric applications only).	Gun Air Cap Fluid Tip	DeVilbiss MBC or JGA 704 or 765 E
Brush	Suitable - small areas only	Typically 100 microns (4.0 mils) can be achieved	
Roller	Suitable - small areas only	Typically 100 microns (4.0 mils) can be achieved	
Thinner	International GTA007	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		

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

Maximum film build in one coat is best attained by airless spray. When applying by methods other than airless spray, the required film build is unlikely to be achieved. Application by air spray may require a multiple cross spray pattern to attain maximum film build. Low or high temperatures may require specific application techniques to achieve maximum film build.

Application by other methods, e.g. brush or roller, may require more than one coat and should only be used for small areas or touch-up work and should only be used when Interzone 278 is being employed in atmospheric applications. Application by techniques other than airless spray should be avoided for immersion service.

For airless spray application, avoid thinning, thin only in exceptional circumstances for ease of application.

This product will not cure adequately below 5°C (41°F). For maximum performance ambient curing temperatures should be above 10°C (50°F).

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

In common with all epoxies Interzone 278 will chalk and discolour on exterior exposure. However, these phenomena are not detrimental to anti-corrosive performance.

Drying times for Winter Curing Agent

			Overcoating Interval with Self.	
Temperature	Touch Dry	Hard Dry	Minimum	Maximum
10°C (50°F)	10 hours	30 hours	30 hours	14 days
15°C (59°F)	6 hours	16 hours	16 hours	7 days

Working Pot Life using Winter Curing Agent

10°C (50°F)	15°C (59°F)
3 hours	1½ hours.

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.

SYSTEMS COMPATIBILITY

For immersion service Interzone 278 must be applied direct to correctly prepared bare steel. However for atmpospheric splash and spill applications suitable anticorrosive primers may be employed such as:

Intercure 200	Interzinc 52
Intergard 251	Interzinc 86
Interzinc 42	Interzinc 315

Interzone 278 should only be topcoated with itself, and should never be overcoated with another product.

Consult International Protective Coatings for further details.

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
20 litre	16 litre	20 litre	4 litre	4 litre

For availability of other pack sizes, contact AkzoNobel.

SHIPPING WEIGHT (TYPICAL)

Unit Size	Part A	Part B
20 litre	32 kg	4.3 kg

STORAGE

Shelf Life	24 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 representative that this data sheet is current prior to using the product.

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