Interplate® 317

Inorganic Zinc Silicate

PRODUCT DESCRIPTION

Interplate 317 is a fast drying, two component, weldable zinc silicate pre-fabrication primer for application by manual or automatic spray.

INTENDED USES

Interplate 317 is as a temporary protective primer for the coating of steelwork prior to the fabrication process.

Interplate 317 is 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 317

Colour	Grey
Gloss Level	Matt
Volume Solids	28%
Typical Thickness	10-25 microns (0.4-1 mils) dry equivalent to 36-89 microns (1.4-3.6 mils) wet
Theoretical Coverage	18.67 m²/litre at 15 microns d.f.t and stated volume solids 749 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, Roller, Air Spray, Brush, Conventional Spray

Drying Time

			Overcoating Interval with recommended topcoats	
Temperature	**Touch Dry**	**Hard Dry**	*Minimum*	*Maximum*
10°C (50°F)	3 minutes	8 minutes	24 hours	Extended[1]
15°C (59°F)	3 minutes	8 minutes	24 hours	Extended[1]
25°C (77°F)	3 minutes	5 minutes	24 hours	Extended[1]
40°C (104°F)	3 minutes	4 minutes	24 hours	Extended[1]

[1] See International Protective Coatings Definitions and Abbreviations

REGULATORY DATA

Flash Point (Typical)	Part A 13°C (55°F); Part B 6°C (43°F); Mixed 6°C (43°F)	
Product Weight	1.5 kg/l (12.5 lb/gal)	
VOC	609 g/lt	Calculated

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

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 8504:2019.

Oil or grease should be removed in accordance with SSPC-SP1 solvent cleaning. Where necessary, remove weld spatter and where required smooth weld seams and sharp edges.

Abrasive Blast Cleaning

Abrasive blast clean to a minimum of Sa2½ (ISO 8501-1:2007) or SSPC-SP6. If oxidation has occurred between blasting and application of Interplate 317 the surface should be re-blasted 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 317 is supplied in two 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 homogenity is maintained.

Mix Ratio

1 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)
7 hours	6 hours	6 hours	4.5 hours

Airless Spray	Recommended	Automatic plant preferred Tip range 0.53-0.64 mm (21-25 thou) Manual application Tip Range 0.43-0.53 mm (17-21 thou) Total output fluid pressure at spray tip not less than 70 kg/cm² (995 p.s.i.)
Air Spray (Pressure Pot)	Recommended	Gun DeVilbiss MBC or JGA Air Cap 704 or 765 Fluid Tip E
Air Spray (Conventional)	Recommended	Use suitable proprietary equipment
Brush	Suitable	Only for small areas or touch ups
Roller	Suitable	Only for small areas or touch ups
Thinner	International GTA136	Do not thin more than allowed by local environmental legislation
Cleaner	International GTA803	

Work Stoppages

Do not allow material to remain in hoses, gun or spray equipment. Thoroughly flush all equipment with International GTA803. 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 GTA803. 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

Satisfactory welding properties will only be obtained by strict control of application to the recommended film thickness. Over application of Interplate 317 will result in increased levels of weld fume on cutting and welding, and will also increase the porosity of the welds.

Interplate 317 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 process. 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. Best results are obtained by using steel preheated to a temperature of 40°C (104°F).

Thicker films of Interplate 317 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 of 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.
Note, this product dries too quickly to enable accurate wet film thickness measurements.

The premature exposure of Interplate 317 to ponding water will cause a colour change which may be permanent. This is a cosmetic effect and will not affect the anti-corrosive protection offered by Interplate 317.

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

This product has the following specification approvals:

- Weld Quality - Approval of Prefabrication Primers (LR)
- Weld Quality - Shop Primers for Corrosion Protection of Steel Plates and Structures (DNV)
- Weld Quality - Weldable Prefabrication Shop Primer (ABS)

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

Interplate 317 can be overcoated with a number of systems suitable for steel protection in a wide range of environments.

Suitable intermediates are:

Intercure 200	Intercure 420
Intergard 251	Intergard 269
Intergard 343	Intergard 475HS
Interseal 670HS	Intershield 300
Interzone 1000	Interzone 505
Interzone 954	

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	10 litre	20 litre	10 litre	10 litre

For availability of other pack sizes, contact AkzoNobel.

SHIPPING WEIGHT (TYPICAL)	Unit Size	Part A	Part B
	20 litre	21.89 kg	9.31 kg

STORAGE		
	Shelf Life	12 months (Part A) & 6 months (Part B) 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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