Interzinc® 315

Rapid Recoat Epoxy Zinc Rich

PRODUCT DESCRIPTION

A two component high solids, low VOC metallic zinc-rich epoxy primer formulated on proprietary polymer technology which provides rapid cure and overcoating even under low temperature conditions.

Interzinc 315 uses zinc dust conforming to the requirements of ASTM D520 Type II as a minimum standard.

INTENDED USES

As a zinc-rich primer to form part of a coating system to provide corrosion protection for steel substrates, for use in a wide range of industrial situations including offshore, petrochemical and chemical plants, refineries, pulp and paper plants, and bridges.

The rapid curing and overcoating properties of Interzinc 315 provide production flexibility, making this product suitable for use both in new construction and on site as a maintenance coating.

PRACTICAL INFORMATION FOR INTERZINC 315

Colour	Blue, Grey
Gloss Level	Matt
Volume Solids	69%
Typical Thickness	50-75 microns (2-3 mils) dry equivalent to 72-109 microns (2.9-4.4 mils) wet
Theoretical Coverage	13.80 m²/litre at 50 microns d.f.t and stated volume solids 553 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)	30 minutes	5 hours	4 hours	Extended[1]
15°C (59°F)	20 minutes	3 hours	3 hours	Extended[1]
25°C (77°F)	15 minutes	2 hours	2 hours	Extended[1]
40°C (104°F)	10 minutes	1 hour	1 hour	Extended[1]

[1] See International Protective Coatings Definitions and Abbreviations

Maximum overcoating intervals are shorter when using polysiloxane topcoats. Consult International Protective Coatings for further details.

REGULATORY DATA

Flash Point (Typical)	Part A 27°C (81°F); Part B 26°C (79°F); Mixed 27°C (81°F)	
Product Weight	3.16 kg/l (26.4 lb/gal)	
VOC	2.79 lb/gal (335 g/lt) 103 g/kg	EPA Method 24 EU Solvent Emissions Directive (Council Directive 2010/75/EU)

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.

Abrasive Grit Blast Cleaning

Abrasive grit blast clean to Sa2½ (ISO 8501-1:2007) or SSPC-SP6. If oxidation has occurred between blasting and application of Interzinc 315, 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 50-75 microns (2-3 mils) is recommended.

Shop Primed Steelwork

Interzinc 315 is suitable for application to steelwork freshly coated with zinc silicate shop primers.

If the shop primer was applied over shot blasted surfaces, overall grit sweep blasting will be necessary prior to the application of Interzinc 315. If the zinc shop primer shows extensive or widely scattered breakdown, or excessive zinc corrosion products, overall grit sweep blasting will be necessary. Other types of shop primer are not suitable for overcoating and will require complete removal by grit abrasive blast cleaning.

Weld seams and damaged areas should be grit blast cleaned to Sa2½ (ISO 8501-1:2007) or SSPC SP6.

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.

For three pack material see product characteristics

Mix Ratio

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

Working Pot Life

5°C (41°F)	15°C (59°F)	25°C (77°F)	40°C (104°F)
6 hours	3 hours	2 hours	1 hour

Airless Spray

Recommended

Tip Range 0.43-0.53 mm (17-21 thou)
Total output fluid pressure at spray tip not less than 141 kg/cm² (2005 p.s.i.)

Air Spray (Pressure Pot)

Suitable - small areas only

Brush

Suitable - small areas only

Typically 40-50 microns (1.6-2.0 mils) can be achieved

Roller

Not recommended

Thinner

International GTA220 (or International GTA415)

Do not thin more than allowed by local environmental legislation

Cleaner

International GTA822 (or International GTA415)

Work Stoppages

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 Up

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.

All surplus materials and empty containers should be disposed of in accordance with appropriate regional regulations/legislation.

PRODUCT CHARACTERISTICS

Due to the high solids level and high zinc content of this coating, in some countries it has become necessary to supply as a three pack material to meet local transport and shipping requirements. The mixed paints and dry films achieved from the two and three pack materials are identical in both application properties and performance.

The following is mixing information for the three pack material:-

Material is supplied in three 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 specified pot life.

(1) Agitate Base (Part A), then combine the entire contents of Base (Part A) and Curing Agent (Part B) and mix thoroughly with power agitator.
(2) The Powder Component (Part C) should be slowly added to the thoroughly mixed Part A and Part B whilst stirring with a power agitator.
(3) Material should be sieved prior to application and should be constantly agitated in the pot during spraying.

Interzinc 315 can be applied at dry film thicknesses between 50 microns (2 mils) and 150 microns (6 mils). Care should be excercised to avoid over application 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.

This product must only be thinned using recommended International thinners. The use of alternative thinners, particularly those containing ketones, can severely inhibit the curing mechanism of the coating.

Interzinc 315 is not normally recommended for underwater use. Please consult International Protective Coatings for details in this situation.

Low Temperature Curing

Interzinc 315 is capable of curing at temperatures below 0°C (32°F). However, this product should not be applied at temperatures below 0°C (32°F) where there is a possibility of ice formation on the substrate.

For further details regarding cure times and overcoatability, please contact International Protective Coatings.

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

This product has the following specification approvals:

- SSPC Paint Specification No. 20, Type II
- BS5493 (1977) : DF & KP1B
- BS4652:1995
- ASTM A490 Class B Slip Coefficient

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

Interzinc 315 is designed for use over correctly prepared grit blasted steel but can be applied over approved prefabrication primers.

Recommended topcoats are:

Intercure 200	Intergard 740
Intercure 200HS	Interseal 670HS
Intercure 420	Interthane 870
Interfine 629HS	Interthane 990
Interfine 979	Interzone 505
Intergard 475HS	Interzone 954

For other suitable primers/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		Part C	
		Vol	Pack	Vol	Pack	Vol	Pack
	10 litre	8 litre	10 litre	2 litre	2.5 litre	-	-
	4 US gal	1.77 US gal	5 US gal	0.8 US gal	1 US gal	1.43 US gal	3 US gal
	For availability of other pack sizes, contact AkzoNobel.						

SHIPPING WEIGHT (TYPICAL)	Unit Size	Part A	Part B	Part C
	10 litre	31.4 kg	2.2 kg	0 kg
	4 US gal	24.2 lb	5.5 lb	88.4 lb

STORAGE	Shelf Life	6 months minimum at 25°C. 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.

This Technical Data Sheet is available on our website at www.international-marine.com or 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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