Interzone® 954GF

International

Modified Epoxy

PRODUCT DESCRIPTION

A surface tolerant, high solids, low VOC epoxy barrier coat, reinforced with chemical-resistant high aspect ratio lamellar glass flake for enhanced durability, abrasion and corrosion protection with excellent cathodic disbondment performance.

INTENDED USES

For the protection of steelwork in areas where high abrasion and corrosion resistance are required including splashzone and subsea areas of offshore structures, jetties, decks, bridges, chemical plants, pulp and paper mills, water treatment plants and underground pipework.

Excellent resistance to cathodic disbondment, gives good compatibility with both sacrificial anode and impressed current systems, making Interzone 954GF particularly suitable for the long term protection of sub-sea structures.

Can be used as part of a non-slip deck system in conjunction with appropriate aggregate.

PRACTICAL INFORMATION FOR INTERZONE 954GF

Colour	Limited colour range available
Gloss Level	Semi Gloss
Volume Solids	85% ± 2% (ISO 3233:1998)
Typical Thickness	200-500 microns (8-20 mils) dry equivalent to 235-588 microns (9.4-23.5 mils) wet
Theoretical Coverage	1.70 m²/litre at 500 microns d.f.t and stated volume solids 68 sq.ft/US gallon at 20 mils d.f.t and stated volume solids
Practical Coverage	Allow appropriate loss factors
Method of Application	Airless Spray, Air Spray, Brush, Roller

Drying Time

			Overcoating Interval with recommended topcoats	
Temperature	**Touch Dry**	**Hard Dry**	*Minimum*	*Maximum*
-5°C (23°F)	22 hours	48 hours	48 hours	21 days
5°C (41°F)	21 hours	40 hours	40 hours	21 days
10°C (50°F)	14 hours	16 hours	16 hours	21 days
25°C (77°F)	3.5 hours	5.5 hours	5.5 hours	21 days
40°C (104°F)	90 minutes	3 hours	3 hours	21 days

REGULATORY DATA

Flash Point (Typical)	Part A 37°C (99°F); Part B 37°C (99°F); Mixed 37°C (99°F)	
Product Weight	1.56 kg/l (13.0 lb/gal)	
VOC	1.87 lb/gal (225 g/lt)	EPA Method 24
	145 g/kg	EU Solvent Emissions Directive (Council Directive 2010/75/EU)

See Product Characteristics section for further details

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SURFACE PREPARATION

The performance of this product will depend upon the degree of surface preparation. The surface to be coated must be clean and free from contamination. Prior to paint application all surfaces should be assessed and treated in accordance with ISO 8504:2000.

Accumulated dirt and soluble salts must be removed. Dry bristle brushing will normally be adequate for accumulated dirt. Soluble salts should be removed by fresh water washing.

Oil or grease should be removed in accordance with SSPC-SP1 solvent cleaning.

Abrasive Blast Cleaning
For optimum performance, abrasive blast clean to Sa2½ (ISO 8501-1:2007) or SSPC-SP6. If oxidation has occurred between blasting and application of Interzone 954GF, 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 surface profile of 50-75 microns (2-3 mils) is recommended.

Hand or Power Tool Preparation
Hand or power tool clean to a minimum St3 (ISO 8501-1:2007) or SSPC-SP3 for atmospheric use only.

Note, all scale must be removed and areas which cannot be prepared adequately by chipping or needle gun should be spot blasted to a minimum standard of Sa2 (ISO 8501-1:2007) or SSPC-SP6. Typically this would apply to C or D grade rusting in this standard.

Ultra High Pressure Hydroblasting / Abrasive Wet Blasting
May be applied to surfaces prepared to Sa2 (ISO 8501-1:2007) or SSPC SP6 which have flash rusted to no worse than Grade HB2M (refer to International Hydroblasting Standards) or Grade SB2M (refer to International Slurry Blasting Standards). It is also possible to apply to damp surfaces in some circumstances. Further information is available from International Protective Coatings.

Aged Coatings
Interzone 954GF is suitable for overcoating some sound intact aged coatings. To ensure compatibility, application and evaluation of a test patch is required.

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)
2 hours	60 minutes	45 minutes	20 minutes

Airless Spray	Recommended	Tip Range 0.48-0.66 mm (19-26 thou) Total output fluid pressure at spray tip not less than 176 kg/cm² (2503 p.s.i.)	
Air Spray (Pressure Pot)	Recommended	Gun Air Cap Fluid Tip	DeVilbiss MBC or JGA 62 AC
Brush	Suitable	Typically 100-150 microns (4.0-6.0 mils) can be achieved	
Roller	Suitable	Typically 75-125 microns (3.0-5.0 mils) can be achieved	
Thinner	International GTA007 Maximum recommended thinning 5%	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 GTA822 (or International GTA415)	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 GTA822 or International GTA415. 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 or International GTA415. It is good working practice to periodically flush out spray equipment during the course of the working day. Frequency should 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. Low or high temperatures may require specific application techniques to achieve maximum film build.

When applying Interzone 954GF by brush or roller, it may be necessary to apply multiple coats to achieve the total specified system dry film thickness.

Surface temperature must always be a minimum of 3°C (5°F) above dew point. Do not apply at steel temperatures below 4°C (39°F).

When applying Interzone 954GF in confined spaces ensure adequate ventilation.

In special cases where overcoating is required and curing has been at low temperature and high relative humidity, ensure no amine bloom is present prior to application of subsequent topcoats.

Condensation occurring during or immediately after application may result in a matt finish and an inferior film. Premature exposure to ponding water will cause a colour change, especially in dark colours.

In common with all epoxies, Interzone 954GF will chalk and discolour on exterior exposure.

Where a durable cosmetic finish with good gloss and colour retention is required overcoat with recommended topcoats.

When applied between tides on jetties, piling etc., Interzone 954GF can be immersed after 2 hours. This will lead to whitening of dark colours but will not affect ultimate anti-corrosive performance.

Interzone 954GF can be used as a non-skid deck system by modification with addition of GPA900 or GMA132 aggregate. Typical thicknesses will be between 750-1,000 microns (30-40 mils). Preferred application is by a suitable large tip hopper gun (e.g. Sagola 429 or Air texture gun fitted with a 5-10 mm nozzle). Trowel or roller can be used for small areas. Alternatively, a broadcast method of application can be used. Consult International Protective Coatings for further details.

Interzone 954GF is compatible with sacrificial and impressed current cathodic protection systems.

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

Interzone 954GF will generally be applied to bare steel prepared by dry abrasive blasting, wet abrasive blasting or ultra high pressure hydroblasting.

The following primers are recommended for Interzone 954GF:

Intercure 200	Intergard 269 (for underwater use)
Intercure 200HS	Interline 982 (for underwater use)
Intergard 251	Interzinc 315
Interzinc 52	Interzone 1000

The following topcoats are recommended for Interzone 954GF:

Intergard 740
Interthane 870
Interthane 990
Interzone 954
Interzone 954GF

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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	14 litre	20 litre	3.5 litre	5 litre

For availability of other pack sizes, contact AkzoNobel.

SHIPPING WEIGHT (TYPICAL)

Unit Size	Part A	Part B
20 litre	25.5 kg	4.08 kg

STORAGE

Shelf Life	12 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

www.international-pc.com