Interplate 8010

IMO Resolution MSC.215 (82) compliant Zinc Silicate Shop Primer

PRODUCT DESCRIPTION

Low dry film thickness, two pack, heat resistant, zinc silicate shop (pre-construction) primer providing excellent corrosion protection (even after heating up to 800°C), with minimum production of zinc salts. Excellent welding and cutting properties and resistance to damage caused by welding, gas cutting and fairing thereby reducing secondary surface preparation requirements in comparison to typical zinc silicate products.

INTENDED USES

As a shop (pre-construction) primer for the protection of steel during fabrication and assembly.
Suitable for use with controlled cathodic protection.
For use at Newbuilding.

PRODUCT INFORMATION

Colour	NQA080-Grey, NQA081-Green, NQA082-Red
System Film Thickness	1 coat at 8 microns dry (29 microns wet) per coat
Finish/Sheen	Matt
Part B (Curing Agent)	NQA086
Volume Solids	28% ±2% (ISO 3233:1998)
Mix Ratio	1.00 volume(s) Part A to 1.22 volume(s) Part B
Specific Gravity	Paste (Part A) 1.57-1.67 Binder (Part B) 0.81-0.87 Mixed Paint 1.16-1.22
Theoretical Coverage	35 m²/litre at 8 microns dft, allow appropriate loss factors
Method of Application	Airless Spray, Brush, Conventional Spray, Roller
Flash Point (Typical)	Part A 14°C; Part B 13°C; Mixed 13°C

Drying Information	5°C	10°C	25°C	35°C
Hard Dry [ISO 9117-1:2009]	5 mins	5 mins	5 mins	3 mins
Pot Life	24 hrs	24 hrs	24 hrs	18 hrs

Overcoating Data - see limitations	**Substrate Temperature**							
	5°C		10°C		25°C		35°C	
Overcoated By	Min	Max	Min	Max	Min	Max	Min	Max

Note Consult your local representative, miminum of 24 hours for appropriate primers.

REGULATORY DATA

VOC

621 g/lt as supplied (EPA Method 24)
640 g/lt Chinese National Standard GB23985

Note: VOC values are typical and are provided for guidance purposes only. These may be subject to variation depending on factors such as differences in colour and normal manufacturing tolerances.

CERTIFICATION

When used as part of an approved scheme, this material has the following certification:

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

- IMO PSPC Resolution MSC.215 (82) - American Bureau of Shipping (ABS)
- IMO PSPC Resolution MSC.215 (82) - Det Norske Veritas (DNV)

Consult your local representative for details.
Approvals issued by external bodies may be dependent upon formulation and/ or manufacturing site.

SURFACE PREPARATIONS

Use in accordance with the standard Worldwide Marine Specifications.
All surfaces to be coated should be clean, dry and free from contamination.

NEWBUILDING
Shop primers should be applied using automatic blasting/spraying equipment.
Blast to a minimum of Sa2½ (ISO 8501-1:2007) or SSPC-SP10. Steel grit or a mixture of steel grit of particle size 0.6-1.0mm and steel shot of particles size 0.6-1.4mm are normally used to give a predominantly angular profile
Apply Interplate 8010 before oxidation occurs. If oxidation does occur the entire oxidised area should be reblasted to the standard specified above.
Ensure that the area is clean and dry prior to application of Interplate 8010.

Consult your local representative for specific recommendations.

Cleanliness

All surfaces to be coated must be clean, dry and free from contamination.

Residual dust levels prior to paint application must not exceed rating "1" for dust size classes "3", "4" or "5" (ISO 8502-3:1993).

Residual soluble salt levels prior to coating application must not exceed 50mg/m² as extracted and measured in accordance with ISO 8502-6 (1995) and ISO 8502-9 (1998) respectively.

Surface profile

The surface profile must lie in the range 30-75 microns (ISO 8503-1/2:1988).

NOTE
For use in Marine situations in North America, the following surface preparation standards can be used: SSPC-SP10 or Sa2½ (ISO 8501-1:2007)

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APPLICATION

Mixing	Interplate 8010 is supplied in 2 parts, a liquid Binder component (Part B) and a Paste component (Part A). The 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 sieved 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. This is a low viscosity material and agitation is required during application to ensure homegeneity is maintained.
Thinner	International GTA810. 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.
Airless Spray	Recommended Tip Range 0.43-0.53 mm (17-21 thou) Total output fluid pressure at spray tip not less than 70 - 141 kg/cm² (1000 - 2010 p.s.i.)
Conventional Spray	Use suitable proprietary equipment. Thinning may be required.
Brush	Application by brush is recommended for small areas only.
Roller	Application by roller is recommended for small areas only.
Cleaner	International GTA810
Work Stoppages and Cleanup	Do not allow material to remain in hoses, gun or spray equipment. Thoroughly flush all equipment with International GTA810. 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 all equipment immediately after use with International GTA810. 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. Do not exceed pot life limitations. All surplus materials and empty containers should be disposed of in accordance with appropriate regional regulations/legislation.
Welding	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. In North America do so in accordance with instruction in ANSI/ASC Z49.1 "Safety in Welding and Cutting."

SAFETY

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.

Prior to use, obtain, consult and follow the Material Safety Data Sheet for this product concerning health and safety information. Read and follow all precautionary notices on the Material Safety Data Sheet and container labels. If you do not fully understand these warnings and instructions or if you can not strictly comply with them, do not use this product. Proper ventilation and protective measures must be provided during application and drying to keep solvent vapour concentrations within safe limits and to protect against toxic or oxygen deficient hazards. Take precautions to avoid skin and eye contact (ie. gloves, goggles, face masks, barrier creams etc.) Actual safety measures are dependant on application methods and work environment.
EMERGENCY CONTACT NUMBERS:
USA/Canada - Medical Advisory Number 1-800-854-6813
Europe - Contact (44) 191 4696111. For advice to Doctors & Hospitals only contact (44) 207 6359191
China – Contact (86) 532 83889090
R.O.W. - Contact Regional Office

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LIMITATIONS

Drying times will depend on the substrate temperature and ventilation conditions.
If the relative humidity is below 50%, cure will be retarded.
Interplate 8010 is not recommended for manual spray application.
Shop primers are not recommended for use as touch-up primers after fabrication.

Film Thickness

Minimum Film Thickness

Film thicknesses below 6 microns may result in premature breakdown of the shop primer and substrate corrosion, necessitating additional secondary surface preparation.

Maximum Film Thickness

Film thicknesses above 8 microns may adversely affect welding and cutting properties and may affect the performance of subsequently applied coating systems. Thicknesses above 30 microns should be avoided.

Overcoating information is given for guidance only and is subject to regional variation depending upon local climate and environmental conditions. Consult your local International Paint representative for specific recommendations. Apply in good weather. Temperature of the surface to be coated must be at least 3°C above the dew point and the relative humidity must not exceed 85%. For optimum application properties bring the material to 21-27°C, unless specifically instructed otherwise, prior to mixing and application. Unmixed material (in closed containers) should be maintained in protected storage in accordance with information given in the STORAGE Section of this data sheet. Technical and application data herein is for the purpose of establishing a general guideline of the coating application procedures. Test performance results were obtained in a controlled laboratory environment and International Paint makes no claim that the exhibited published test results, or any other tests, accurately represent results found in all field environments. As application, environmental and design factors can vary significantly, due care should be exercised in the selection, verification of performance and use of the coating.

UNIT SIZE

Unit Size	Part A		Part B	
	Vol	Pack	Vol	Pack
18 lt	8.1 lt	20 lt	9.9 lt	10 lt

For availability of other unit sizes consult International Paint

UNIT SHIPPING WEIGHT (TYPICAL)

Unit Size	Unit Weight
18 lt	23.45 Kg

STORAGE

Shelf Life: Low flash storage required.
Part A - 12 months at 25°C
Part B - 12 months at 25°C
Subject to reinspection thereafter. Store in dry, shaded conditions away from sources of heat and ignition.

PLACE OF MANUFACTURE

Korea

IMPORTANT NOTE

www.international-marine.com