

## Polyester

### PRODUCT DESCRIPTION

A two component, glass flake reinforced ambient cure isophthalic polyester coating.

### INTENDED USES

As a high performance anti-corrosive coating for application at new construction where high build and fast cure combine to optimise the throughput of steelwork and minimise production overheads.

For the protection of steelwork exposed in aggressive environments such as offshore structures, chemical and petrochemical plants, pulp and paper mills and power plants.

Can also be applied as a maintenance coating on site where its fast cure and high build characteristics help to minimise downtime and keep maintenance costs to a minimum.

### PRACTICAL INFORMATION FOR INTERZONE 1020

<b>Colour</b>	Limited range
<b>Gloss Level</b>	Semi-gloss
<b>Volume Solids</b>	100% reactive, although determined volume solids depends upon the application conditions. A recommended working figure is 85%.
<b>Typical Thickness</b>	500-1000 microns (20-40 mils) dry equivalent to 500-1000 microns (20-40 mils) wet
<b>Theoretical Coverage</b>	2 m <sup>2</sup> /litre at 500 microns d.f.t and stated volume solids 80 sq.ft/US gallon at 20 mils d.f.t and stated volume solids
<b>Practical Coverage</b>	Allow appropriate loss factors
<b>Method of Application</b>	Airless Spray, Brush

#### Drying Time

Temperature	Touch Dry	Hard Dry	Overcoating Interval with recommended topcoats	
			Minimum	Maximum
15°C (59°F)	4 hours	7 hours	7 hours	3 days
25°C (77°F)	4 hours	7 hours	7 hours	3 days
35°C (95°F)	2 hours	2 hours	5 hours	3 days

### REGULATORY DATA

**Flash Point (Typical)** Part A 28°C (82°F); Part B 100°C (212°F); Mixed 28°C (82°F)

**Product Weight** 1.2 kg/l (10.0 lb/gal)

**VOC** 35 g/l Calculated

See Product Characteristics section for further details

## Polyester

### 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 8504:2000.

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

#### Abrasive Blast Cleaning

Abrasive blast clean to a minimum of Sa2½ (ISO 8501-1:2007) or SSPC-SP6. A sharp, angular surface profile of 75-100 microns (3-4 mils) is recommended. If oxidation has occurred between blasting and application of Interzone 1020, 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.

If a holding primer is required for Interzone 1020 then only the use of Ceilcote 380 Primer is advised. Alternatively, the blast standard can be maintained by the use of dehumidification.

#### Shop Primed Steel

Prior to application of Interzone 1020, all shop primed steelwork must be re-blasted to a visual standard as outlined above.

### APPLICATION

<b>Mixing</b>	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.		
	<ul style="list-style-type: none"> <li>(1) Agitate Base (Part A) with a power agitator.</li> <li>(2) Combine entire contents of Curing Agent (Part B) with Base (Part A) and mix thoroughly with power agitator.</li> </ul>		
<b>Mix Ratio</b>	49 part(s) : 1 part(s) by volume		
<b>Working Pot Life</b>	15°C (59°F) 60 minutes	25°C (77°F) 60 minutes	35°C (95°F) 60 minutes
<b>Airless Spray</b>	Recommended	Tip Range 0.63-1.4 mm (25-55 thou) Total output fluid pressure at spray tip not less than 176 kg/cm <sup>2</sup> (2503 p.s.i.)	
<b>Brush</b>	Suitable - Touch up and small areas only		
<b>Thinner</b>	DO NOT THIN		
<b>Cleaner</b>	International GTA853		
<b>Work Stoppages</b>	Do not allow material to remain in hoses, gun or spray equipment. Thoroughly flush all equipment with International GTA853. 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.		
<b>Clean Up</b>	Clean all equipment immediately after use with International GTA853. 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.		

## Polyester

### PRODUCT CHARACTERISTICS

The detailed guidelines for the application of vinyl esters and polyesters should be consulted prior to the use of Interzone 1020.

Interzone 1020 can be applied in a wide range of climatic conditions, including elevated material temperatures up to 35°C (95°F). However, at material temperatures greater than 15°C (59°F) the use of a retarder solution is required in order to maintain the working pot life, allowing normal airless spray methods to be employed. The recommended level of retarder is as follows:

<15°C (59°F)	No retarder required
15-25°C (59-77°F)	1 unit retarder required
26-35°C (79-95°F)	2 units retarder required

These volumes of retarder will maintain the pot life at approximately 1 hour. The retarder must always be added to the base prior to the addition of the initiator and mixed thoroughly using a power agitator.

Maximum steel temperature at the time of application is 60°C (140°F) and maximum relative humidity during the application and cure period is 80%. This product will not cure adequately below 5°C (41°F). For maximum performance ambient curing temperatures should be above 15°C (59°F). Surface temperature must always be a minimum of 3°C (5°F) above dew point.

Although Interzone 1020 is theoretically a 100% reactive mix, actual theoretical coverage rates can vary between 1.7m<sup>2</sup>/litre (68.2 sq.feet/US gallon) and 1.96 m<sup>2</sup>/litre (78.6 sq.feet/US gallon) at 500 microns (20 mils) dry film thickness. This is dependent on application and cure conditions.

Apply by airless spray only. Application by other methods, e.g. brush or roller, may require more than one coat and is suggested for small areas only or initial stripe coating.

This product must **not** be thinned as the use of thinners may severely inhibit the curing mechanism of the coating.

Maximum continuous dry temperature resistance for Interzone 1020 is 60°C (140°F).

Interzone 1020 is not intended to be used as a cosmetic finish and colour stability will not be achievable. Where a durable cosmetic finish with good gloss and colour retention is required overcoat with recommended topcoats. In order to attain the maximum degree of colour stability, the use of an optional wax solution is essential. This should be added with the retarder during mixing, prior to the addition of the initiator. See detailed Application Procedures for further advice. The wax solution must only be used in the final coat as it will impair intercoat adhesion.

Interzone 1020 is also available as a non-skid option for deck areas. Consult International Protective Coatings for details.

Elevated storage temperatures reduce shelf life. Avoid storage above 35°C (95°F). Uncatalysed Interzone 1020 is stable for 6 months from date of manufacture when stored below 25°C (77°F) in its original sealed containers. Interzone 1020 should never be stored in direct sunlight. If necessary, refrigerated storage can be used to prolong shelf life at elevated temperatures and ensure that the working pot life can be achieved.

Under direct sunlight exposures or when surface temperatures exceed 35°C (95°F), Interzone 1020 should be recoated as soon as the coating will support foot traffic, in order to prevent the possibility of intercoat disbondment.

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 1020 is normally applied to suitably prepared steel, e.g. blast cleaned. If necessary, application over a holding primer is possible, however, this is limited to: Ceilcote 380 Primer

Recommended cosmetic topcoats for exposed high profile areas are: Interfine 629HS, Intergard 740, Interthane 990

For other suitable topcoats, consult International Protective Coatings.

## Polyester

### 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](http://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 Material Safety Data Sheet and the container(s), and should not be used without reference to the Material Safety Data Sheet (MSDS) which International Protective Coatings has provided to its customers.

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 International Protective Coatings for further advice.

PACK SIZE	Unit Size	Part A		Part B	
		Vol	Pack	Vol	Pack
	20 litre	19.6 litre	20 litre	0.4 litre	0.5 litre
The optional retarder and wax solution for this product are available as follows: Retarder 40ml in a 100ml container; Wax Solution 300ml in a 500ml container.					
For availability of other pack sizes, contact International Protective Coatings.					
SHIPPING WEIGHT (TYPICAL)	Unit Size	Part A		Part B	
		26.9 kg		0.8 kg	
	20 litre				
STORAGE	Shelf Life	6 months at 25°C (77°F). Subject to re-inspection thereafter. Store in dry, shaded conditions away from sources of heat and ignition. During storage and shipment, Interzone 1020 initiator must not be exposed to temperatures exceeding 30°C (90°F). Refrigeration recommended. Best practice would be to hold Parts A and B in separate stores.			

### 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](http://www.international-marine.com) or [www.international-pc.com](http://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.*

Copyright © AkzoNobel, 02/02/2016.

All trademarks mentioned in this publication are owned by, or licensed to, the AkzoNobel group of companies.

**[www.international-pc.com](http://www.international-pc.com)**