

PRODUCT DESCRIPTION

A two component, ultra high solids epoxy barrier coat designed to give long term protection in a single coat application.

Designed to be applied using heated plural component airless spray only.

Interzone 954XS offers excellent cathodic disbondment resistance.

INTENDED USES

Primarily designed for use in offshore splashzones. Suitable for abrasive, immersed and corrosive environments like pulp and paper plants, chemical plants, bridge stanchions, jetties and sluice gates.

PRACTICAL INFORMATION FOR INTERZONE 954XS

Colour	Grey, Black
Gloss Level	Semi-gloss
Volume Solids	99%
Typical Thickness	500-1000 microns (20-40 mils) dry equivalent to 505-1010 microns (20.2-40.4 mils) wet
Theoretical Coverage	1.20 m ² /litre at 800 microns d.f.t and stated volume solids 50 sq.ft/US gallon at 32 mils d.f.t and stated volume solids
Practical Coverage	Allow appropriate loss factors
Method of Application	Plural component airless spray

Drying Time

Overcoating interval with self

Temperature	Touch Dry	Hard Dry	<i>Minimum</i>	<i>Maximum</i>
10°C (50°F)	5.5 hours	16 hours	16 hours	Extended ¹
15°C (59°F)	4.5 hours	10 hours	10 hours	Extended ¹
25°C (77°F)	2.5 hours	5 hours	5 hours	Extended ¹
40°C (104°F)	60 minutes	2 hours	2 hours	Extended ¹

¹ See International Protective Coatings Definitions and Abbreviations

At temperatures of 100-110°C, hard dry time will be 11 minutes.

REGULATORY DATA

Flash Point	Part A 65°C (149°F); Part B 115°C (239°F); Mixed 68°C (154°F)	
Product Weight	1.76 kg/l (14.7 lb/gal)	
VOC	0.33 lb/gal (40 g/l)	EPA Method 24

See Product Characteristics section for further details

SURFACE PREPARATION

The performance of this product will depend upon the degree of surface preparation. The surface 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.

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

Abrasive blast clean to Sa2½ (ISO 8501-1:2007) or SSPC-SP6. If oxidation has occurred between blasting and application of Interzone 954XS, 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 75-100 microns (3-4 mils) is recommended.

APPLICATION

Mixing	This material is supplied in full containers for use with plural component airless spray equipment. Once mixed, Interzone 954XS must be used within the working pot life specified.	
	<ol style="list-style-type: none"> (1) Agitate Base (Part A) with a power agitator. (2) Agitate Curing Agent (Part B) with a power agitator. (3) Add individual components to the appropriate hopper of the proportioning pump. 	
Mix Ratio	2 part(s) : 1 part(s) by volume	
Working Pot Life	10°C (50°F)	15°C (59°F)
	90 minutes	70 minutes
	25°C (77°F)	40°C (104°F)
	45 minutes	15 minutes
	At 50°C (122°F), pot life will be 10 minutes.	
Plural Component Airless Spray	Recommended	Consult International Protective Coatings for specific recommendations. See Product Characteristics
Airless Spray	Not suitable	
Trowel	Suitable - small areas only	
Thinner	International GTA220	Do not thin more than allowed by local environmental legislation
Cleaner	International GTA822	
Work Stoppages	Do not allow material to remain in hoses, gun or spray equipment. Release pressure from the material hose and thoroughly flush fluid line and spray gun with International GTA822. Do not re-pressurise equipment until ready to resume spraying operations, and ensure pot life limitations are adhered to.	
Clean Up	Clean all equipment immediately after use with International GTA822. It is good working practice to periodically clean equipment during the course of the working day. Frequency of cleaning will depend upon amount used, 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**

Interzone 954XS has been specifically designed for automatic plant application utilising a heated plural component airless spray set up in combination with heat cure capabilities.

Airless spray using heated plural component equipment. A 60:1 ratio is recommended, although it may sometimes be possible to use 48:1 depending on line conditions. Equipment should be capable of accurate proportioning and in-line mixing.

It is recommended that paint lines are insulated and tip sizes of 0.57 – 0.67 mm (22 – 26 thou) be used. Best results will be achieved when both Part A and Part B are heated prior to application. A temperature of 50°C (122°C) is recommended.

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

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

Premature exposure to ponding water will cause a colour change, especially in dark colours.

In common with all epoxies Interzone 954XS will chalk and discolour on exterior exposure. However, these phenomena are not detrimental to anti-corrosive performance.

For use in atmospheric service a minimum dry film thickness of 350 microns (14 mils) is required in one coat when applied direct to steel, for water immersion a minimum of 450 microns (18 mils) dry film thickness is recommended. In each case protection can be achieved in a single coat application by plural component airless spray.

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 954XS is designed as a single coat system. It must only be overcoated with itself or Interzone 954 should re-coats or touch-up be required.

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 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	20 litre	20 litre	20 litre	20 litre
	200 litre	200 litre	200 litre	200 litre	200 litre
For availability of other pack sizes, contact International Protective Coatings.					
SHIPPING WEIGHT	Unit Size	Part A		Part B	
	20 litre	38.59 kg		33.03 kg	
	200 litre	389.23 kg		336.7 kg	
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 International Paint representative that this data sheet is current prior to using the product.

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