

PRODUCT DESCRIPTION A two pack, heat resistant zinc silicate shop (pre-construction) primer providing good corrosion protection (even after heating up to 800°C (1472°F)), with minimum production of zinc salts. Suitable for high speed welding and cutting with excellent 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. Suitable for use in new construction situations.

PRACTICAL INFORMATION FOR INTERPLATE 937

Colour Grey, Brown

Gloss Level Matt

Volume Solids 23%

Typical Thickness 10-18 microns (0.4-0.7 mils) dry equivalent to 43-78 microns (1.7-3.1 mils) wet

Theoretical Coverage 17.70 m²/litre at 13 microns d.f.t and stated volume solids
738 sq.ft/US gallon at 0.5 mils d.f.t and stated volume solids

Practical Coverage Allow appropriate loss factors.

Method of Application Automatic Airless Spray, Air Spray, Brush, Roller

Drying Time

Temperature	Touch Dry	Hard Dry	Overcoating Interval with recommended topcoats	
			Minimum	Maximum
25°C (77°F)	¹	5 minutes	7 days	Extended ²
40°C (104°F)	¹	4 minutes	7 days	Extended ²

¹ Not applicable; Interplate 937 dries so quickly that this cannot be measured.

² See International Protective Coatings Definitions and Abbreviations

REGULATORY DATA

Flash Point Part A 10°C (50°F); Part B 14°C (57°F); Mixed 13°C (55°F)

For products used in North America, see Product Characteristics section.

Product Weight 1.25 kg/l (10.4 lb/gal)

VOC 5.41 lb/gal (649 g/l)
519 g/kg

EPA Method 24
EU Solvent Emissions Directive
(Council Directive 1999/13/EC)

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 Sa2½ (ISO 8501-1:2007) or SSPC-SP10. If oxidation has occurred between blasting and application of Interplate 937, 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 shot is used as the blasting media, it is preferable to add a minimum of 20 percent steel grit to the abrasive mixture in order to provide some angular profile in the substrate.

Remove all dust and abrasive via a suitable method prior to application of Interplate 937.

A surface profile of 30-75 microns (1.2-3.0 mils) is recommended.

APPLICATION

Mixing	Material is supplied in two containers as a unit. Always mix a complete unit in the proportions supplied.			
	(1)	Agitate Paste (Part A) with power agitator.		
	(2)	Slowly add Binder (Part B) to Paste while agitating and allow to mix for at least 5 minutes.		
	(3)	Strain material through a 30-60 mesh screen into an air agitator equipped tank, container or pressure pot.		
	(4)	Operate air agitator at low speed (~20rpm) to maintain an homogeneous mixture.		
	(5)	Keep system closed and free from moisture.		
Mix Ratio	0.6 part(s) : 1.0 part(s) by volume			
Working Pot Life	5°C (41°F)	10°C (50°F)	25°C (77°F)	40°C (104°F)
	24 hours	24 hours	24 hours	6 hours
Airless Spray	Recommended	Tip Range 0.38-0.58 mm (15-23 thou) Total output fluid pressure at spray tip not less than 60 kg/cm ² (853 p.s.i.)		
Air Spray (Pressure Pot)	Recommended	Gun	DeVilbiss MBC or JGA	
		Air Cap	704 or 765	
		Fluid Tip	E	
Air Spray (Conventional)	Recommended	Use suitable proprietary equipment		
Brush	Suitable - small areas only			
Roller	Suitable - small areas only			
Thinner	International GTA820 or International GTA840			
Cleaner	International GTA820 or International GTA840			
Work Stoppages	Do not allow material to remain in hoses, guns or spray equipment. Thoroughly flush all equipment with International GTA820 or International GTA840. 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 GTA820 or International GTA840. 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**

Interplate 937 is designed for use in an automatic plant. It can be applied by manual spray but this is not recommended for complex structures.

Above 30 microns (1.2 mils) DFT the level of weld fume and weld porosity will increase. Drying times will depend on the substrate temperature and on ventilation. Drying will also be retarded if the relative humidity is below 50%.

Shop primers are not recommended for use as touch-up primers after fabrication.

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

This product has the following specification approvals:

- Weld Fumes - Thermal Degradation on Welding (NOHA)
- Weld Fumes - Trace Gas Measurement during Welding (SLV)
- Weld Quality - Approved for Overweldable Shop Primers (GL)
- Weld Quality - Approval of Prefabrication Primers (LR)
- Weld Quality - Shop Primers for Welded Steel Structures (BV)
- Weld Quality - Shop Primers for Corrosion Protection of Steel Plates and Structures (DNV)
- Weld Quality - Russian Maritime Register of Shipping
- Weld Quality - Registro Italiano Navale
- Fire Resistance - Marine Equipment Directive compliant
- MIL SPECS
 - MIL-PRF-23236C, Type V, CL8, GrB & C
 - MIL-PRF-23236C Type 6, CL6 & 8, GrB & C

Product produced and supplied in North America has flash points of: Part A 14°C (60°F), Part B 15°C (61°F) and Mixed 14°C (60°F) due to locally sourced solvents. There is no detrimental effect on product performance.

**SYSTEMS
COMPATIBILITY**

The following primers/topcoats are recommended for Interplate 937:

Intercure 200HS
Intergard 251
Intergard 269
Intergard 345
Intergard 475HS
Interseal 670HS
Interzinc 315
Interzinc 52

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 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	7.5 litre	20 litre	12.5 litre	15 litre
	5 US gal	1.88 US gal	5 US gal	3.13 US gal	3.5 US gal

SHIPPING WEIGHT	Unit Size	Part A	Part B
	20 litre	16.26 kg	11.62 kg
	5 US gal	33.4 lb	26.1 lb

STORAGE	Shelf Life:	Part A: 12 months minimum at 25°C (77°F). Part B: 6 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

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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