Intergard® 345

International

Epoxy

PRODUCT DESCRIPTION

A two component, low VOC, high solids, fast curing epoxy primer/finish containing zinc phosphate anti-corrosive pigmentation.

INTENDED USES

Suitable for use as a one or two coat primer/finish coating or as an intermediate over recommended anti-corrosive primers.

Intergard 345 provides a combination of anti-corrosive barrier protection, chemical fume and spillage resistance, along with good abrasion resistance. Ideal for use in moderately corrosive environments and where fast drying/rapid recoating is desired.

PRACTICAL INFORMATION FOR INTERGARD 345

Color	Wide range via the Chromascan® system
Gloss Level	Semi Gloss
Volume Solids	70%
Typical Thickness	4-6 mils (100-150 microns) dry equivalent to 5.7-8.6 mils (143-214 microns) wet
Theoretical Coverage	225 sq.ft/US gallon at 5 mils d.f.t and stated volume solids 5.60 m²/liter at 125 microns 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*
50°F (10°C) [1]	90 minutes	7 hours	7 hours	Extended[2]
59°F (15°C) [1]	75 minutes	5 hours	5 hours	Extended[2]
77°F (25°C) [1]	60 minutes	2.5 hours	2.5 hours	Extended[2]
104°F (40°C) [1]	30 minutes	1 hour	1 hour	Extended[2]

[1] See Product Characteristics section for further details
[2] See International Protective Coatings Definitions & Abbreviations

REGULATORY DATA

Flash Point (Typical) Part A 91°F (33°C); Part B 109°F (43°C); Mixed 93°F (34°C)

Product Weight 12.1 lb/gal (1.45 kg/l)

VOC

2.67 lb/gal (320 g/lt)	EPA Method 24
235 g/kg	EU Solvent Emissions Directive (Council Directive 2010/75/EC)
214 g/lt (1.78 lb/US Gal)	Chinese National Standard GB23985

Coating hazard marker GB 30981.2-S-Pb≤1000-NC Qualified for GB 30981.2-2025

See Product Characteristics section for further details

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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 8504:2019.

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

Abrasive Blast Cleaning

Abrasive blast clean to a minimum of SSPC-SP6 or Sa2½ (ISO 8501-1:2007). If oxidation has occurred between blasting and application of Intergard 345, 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 2-3 mils (50-75 microns) is recommended. Intergard 345 is suitable for application to blast cleaned surfaces which were initially to the above standard but have been allowed to deteriorate under good shop conditions for up to 7-10 days. The surface may deteriorate to Sa2 standard but must be free from loose powdery deposits.

Primed Surfaces

Weld seams and damaged areas should be blast cleaned to SSPC SP6 or Sa2½ (ISO 8501-1:2007).

If the shop primer shows extensive or widely scattered breakdown overall sweep blasting maybe necessary.

Concrete, Pre-cast Blockwork, etc

Intergard 345 is suitable for application to concrete. For the first coat it is recommended that Intergard 345 is thinned 10-15% by International Thinners in order to provide good penetration with the concrete substrate and act as a primer/sealer coat.

Concrete should be cured for a minimum of 28 days prior to coating. The moisture content of the concrete should be below 6%. All surfaces should be clean, dry and free from curing compounds, release agents, trowelling compounds, surface hardeners, efflorescence, grease, oil, dirt, old coatings and loose or disintegrating concrete. All poured and precast concrete must also be sweep blasted (preferred) or acid etched to remove laitence.

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

50°F (10°C)	59°F (15°C)	77°F (25°C)	104°F (40°C)
3 hours	2 hours	60 minutes	45 minutes

Airless Spray

Recommended

Tip Range 17-21 thou (0.43-0.53 mm)
Total output fluid pressure at spray tip not less than 2503 psi (176 kg/cm²)

Air Spray (Pressure Pot)

Recommended

Gun	DeVilbiss MBC or JGA
Air Cap	704 or 765
Fluid Tip	E

Brush

Suitable - Small areas only

Typically 3.0-4.0 mils (75-100 microns) can be achieved

Roller

Suitable - Small areas only

Typically 3.0-4.0 mils (75-100 microns) can be achieved

Thinner

International GTA220
(International GTA415)

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 GTA220 or International GTA415

Choice of cleaner may be 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 GTA220. 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 GTA220. 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.

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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. Application by air spray may require a multiple cross spray pattern to attain maximum film build. Lower or high temperatures may require specific application techniques to achieve maximum film build.

When applying Intergard 345 by brush or roller, it may be necessary to apply multiple coats to achieve the total specified system dry film thickness.

This product will not cure adequately below 41°F (5°C). For maximum performance ambient curing temperatures should be above 50°F (10°C).

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

When applying Intergard 345 in confined spaces, ensure adequate ventilation.

In moderately corrosive environments, it is recommended that a minimum of 4 mils (100 microns) dry film thickness should be specified to ensure adequate anti-corrosive performance. However, in non-aggressive, low corrosive environments such as those equating to C2 as per ISO 12944 part 2, it is acceptable to specify Intergard 345 as a single coat at 3.2 mils (80 microns) dry film thickness.

Condensation occurring during or immediately after application may result in a matte finish and an inferior film.

When utilizing certain colors, particularly the darker shades via the Chromascan system where maximum addition of colorants is required, it is necessary to allow an increase in the quoted drying and overcoating times. Consult International Protective Coatings for further details.

Exposure to dew or rain prior to specified hard dry time may cause a deterioration in surface appearance which may in turn impair overall performance. This phenomena is particularly prominent in darker shades.

In common with all epoxies, Intergard 345 will chalk and discolor on exterior exposure. However, these phenomena are not detrimental to anti-corrosive performance.

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

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 color 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

Intergard 345 is normally applied directly to blast cleaned steel, however, it can also be applied directly over the following primers:-

- Intercure 200HS
- Intercure 200
- Intergard 251
- Intergard 269
- Intergard 345
- Interzinc 52
- Interzinc 315

The following topcoats are recommended:-

- Interfine 629HS
- Intergard 740
- Interthane 870
- Interthane 990

For other suitable primers/topcoats, consult International Protective Coatings.

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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 liter	16 liter	20 liter	4 liter	5 liter
5 US gal	4 US gal	5 US gal	1 US gal	1 US gal

For availability of other pack sizes, contact AkzoNobel.

SHIPPING WEIGHT (TYPICAL)

Unit Size	Part A	Part B
20 liter	26.8 kg	4.3 kg
5 US gal	50 lb	8.6 lb

STORAGE

Shelf Life	18 months minimum at 77°F (25°C). Subject to re-inspection thereafter. Store in dry, shaded conditions away from sources of heat and ignition.

Disclaimer

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 or 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.

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