International

Intergard® 264
Epoxy

PRODUCT DESCRIPTION

A low VOC, two component, self-priming surface tolerant epoxy with semi-gloss finish. Exhibits excellent chemical and abrasion resistance. The high build formulation is capable of low temperature cure.

INTENDED USES

For use in severe industrial and marine environments subject to acids, alkalis, solvents and salts. Typically used on structural steel, concrete, tanks, bridges, offshore, pulp and paper, power plants and chemical plants.

PRACTICAL INFORMATION FOR INTERGARD 264

Colour	Off White, Light Grey, Red, Black
Gloss Level	Semi-gloss
Volume Solids	80% ± 2%
Typical Thickness	100-200 microns (4-8 mils) dry equivalent to 125-250 microns (5-10 mils) wet
Theoretical Coverage	6.40 m²/litre at 125 microns d.f.t and stated volume solids 257 sq.ft/US gallon at 5 mils d.f.t and stated volume solids
Practical Coverage	Allow appropriate loss factors
Method of Application	Airless Spray, Roller, Air Spray, Brush

Drying Time

			Overcoating Interval with recommended topcoats	
Temperature	**Touch Dry**	**Hard Dry**	*Minimum*	*Maximum*
10°C (50°F)	10 hours	24 hours	24 hours	10 days[1]
15°C (59°F)	7 hours	17 hours	18 hours	9 days[1]
25°C (77°F)	4 hours	8 hours	10 hours	7 days[1]
30°C (86°F)	2 hours	4 hours	7 hours	3 days[1]

[1] Where overcoating Intergard 264 with itself or with Intergard 740, the maximum overcoating interval will be longer. See Product Characteristics section for details.

For curing at low temperatures an alternative curing agent is available. See Product Characteristics for details.

REGULATORY DATA

Flash Point	Part A 47°C (117°F); Part B 51°C (124°F); Mixed 47°C (117°F)
Product Weight	1.37 kg/l (11.4 lb/gal)
VOC	1.61 lb/gal (194 g/lt) EPA Method 24

See Product Characteristics section for further details

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. Accumulated dirt and soluble salts must be removed by fresh water washing. Oil or grease should be removed in accordance with SSPC-SP1 solvent cleaning.

Abrasive Blast Cleaning
For best performance in atmospheric exposure, apply Intergard 264 to surfaces which have been abrasive blast cleaned to a minimum standard of ISO 8501-:2007 Sa2½ or SSPC-SP6. Surface defects revealed by the blast cleaning process should be ground, filled, or treated in the appropriate manner.

Hand or Power Tool Preparation
Hand or power tool clean to a minimum of St2 (ISO 8501-1:2007) or SSPC-SP2.

Note, all scale must be removed and areas which cannot be prepared adequately by chipping or needle gun should be spot blasted to a minimum standard of Sa2 (ISO 8501-1:2007) or SSPC-SP6. Typically this would apply to C or D grade rusting in this standard.

Ultra High Pressure Hydroblasting / Abrasive Wet Blasting
May be applied to surfaces prepared to Sa2½ (ISO 8501-1:2007) or SSPC-SP6 which have flash rusted to no worse than Grade HB2½M (refer to International Hydroblasting Standards). It is also possible to apply to damp surfaces in some circumstances. Further information is available from International Protective Coatings.

Aged Coatings
Intergard 264 is suitable for overcoating a limited range of intact, tightly adherent aged coatings. Loose or flaking coatings should be removed back to a firm edge. Glossy finishes may require light abrasion to provide a physical 'key'. See Product Characteristics section for further information.

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.

At temperatures below 21ºC (70ºF) it is recommended that Intergard 264 is allowed a 15 minute induction period after mixing, prior to commencing application.

Mix Ratio

4 part(s) : 1 part(s) by volume

Working Pot Life

10°C (50°F)	15°C (59°F)	25°C (77°F)	30°C (86°F)
8 hours	6 hours	4 hours	1 hour

Airless Spray	Recommended	Tip Range 0.48-0.68 mm (19-27 thou) Total output fluid pressure at spray tip not less than 176 kg/cm² (2503 p.s.i.)	
Air Spray (Pressure Pot)	Recommended	Gun Air Cap Fluid Tip	DeVilbiss MBC or JGA 704 or 765 E
Brush	Suitable - Small areas	Typically 75-100 microns (3.0-4.0 mils) can be achieved	
Roller	Suitable - Small areas	Typically 75-100 microns (3.0-4.0 mils) can be achieved	
Thinner	International GTA220 (or GTA415)	Do not thin more than allowed by local environmental legislation	

Cleaner

International GTA220 (or GTA415)

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.

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. Low or high temperatures may require specific application techniques to achieve maximum film build.

When applying Intergard 264 by brush or roller, it may be necessary to apply multiple coats to achieve the total specified system dry film thickness.

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

If applying Intergard 264 in enclosed maintenance conditions ensure adequate ventilation.

In common with all epoxies Intergard 264 will chalk and discolour on exterior exposure. However, these phenomena are not detrimental to anti-corrosive performance.

Low Temperature Curing (Sub Zero)

Intergard 264 is capable of curing at temperatures below 0°C (32°F). However, this product should not be applied at temperatures below 0°C (32°F) where there is a possibility of ice formation on the substrate.

Pot Life	**-5°C (23°F)**	**5°C (41°F)**	**15ºC (59ºF)**	**25ºC (77ºF)**
	8 hours	5 hours	3 hours	2½ hours

At temperatures below 16ºC (60ºF) it is recommended that Intergard 264 is allowed a 15 minute induction period after mixing, prior to commencing application.

			Overcoating Interval with recommended topcoats	
Temperature	Touch Dry	Hard Dry	*Minimum*	*Maximum*
-5°C (23°F)	21 hours	72 hours	*	*
5°C (41°F)	7 hours	20 hours	16 hours	7 days
15°C (59°F)	2 hours	9 hours	10 hours	5 days
25°C (77°F)	2 hours	6 hours	4 hours	3 days

* Consult International Protective Coatings for specific recommendations on overcoating interval at -5ºC (23ºF).

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

Intergard 264 is normally applied directly to steel, however, it can be applied over the following primers:

Intercure 200HS	Intergard 269
Interplus 256	Interplus 356
Interzinc 22	Interzinc 22HS
Interzinc 315	Interzinc 52
Intergard 263	

The following topcoats are approved for use with Intergard 264:

Intergard 740	Intershield 349
Intersleek 381	Intersleek 731
Interthane 990	Interthane 990HS

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
	5 US gal	4 US gal	5 US gal	1 US gal	1 US gal
	For availability of other pack sizes, contact International Protective Coatings.				
SHIPPING WEIGHT	Unit Size	Part A		Part B	
	5 US gal	57.1 lb		8.8 lb	
STORAGE	Shelf Life	12 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

www.international-pc.com