

## Epoxy

### PRODUCT DESCRIPTION

A two component epoxy anti-corrosive primer pigmented with zinc phosphate.

### INTENDED USES

For use on properly prepared surfaces both in new construction and as an industrial maintenance primer for a wide range of anti-corrosive coatings systems. For use in the offshore, petrochemical, chemical, pulp and paper and bridge industries.

### PRACTICAL INFORMATION FOR INTERGARD 2510

<b>Colour</b>	Red, Grey
<b>Gloss Level</b>	Semi Gloss
<b>Volume Solids</b>	78% ± 2%
<b>Typical Thickness</b>	75-250 microns (3-10 mils) dry equivalent to 96-321 microns (3.8-12.8 mils) wet
<b>Theoretical Coverage</b>	10.40 m <sup>2</sup> /litre at 75 microns d.f.t and stated volume solids 417 sq.ft/US gallon at 3 mils d.f.t and stated volume solids
<b>Practical Coverage</b>	Allow appropriate loss factors
<b>Method of Application</b>	Airless Spray, Air Spray, Brush, Roller

#### Drying Time

Temperature	Touch Dry	Hard Dry	Overcoating Interval with recommended topcoats	
			Minimum	Maximum
5°C (41°F)	3 hours	14 hours	14 hours	Extended <sup>1</sup>
10°C (50°F)	2 hours	6 hours	4 hours	Extended <sup>1</sup>
25°C (77°F)	90 minutes	3 hours	2 hours	Extended <sup>1</sup>
40°C (104°F)	60 minutes	2 hours	2 hours	Extended <sup>1</sup>

<sup>1</sup> See International Protective Coatings Definitions and Abbreviations

### REGULATORY DATA

<b>Flash Point (Typical)</b>	Part A 26°C (79°F); Part B 26°C (79°F); Mixed 26°C (79°F)	
<b>Product Weight</b>	1.58 kg/l (13.2 lb/gal)	
<b>VOC</b>	163 g/kg	EU Solvent Emissions Directive (Council Directive 1999/13/EC)

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 8504:2000.

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

#### Steel

Abrasive blast clean to Sa2½ (ISO 8501-1:2007) or SSPC-SP6. If oxidation has occurred between blasting and application of Intergard 2510, 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 40-75 microns (1.6-3.0 mils) is recommended.

#### Shop Primed Steel

Weld seams and damaged areas should be abrasive blast cleaned to a minimum Sa2½ standard (ISO 8501-1:2007) or SSPC SP6. Where this is not practical, preparation to SSPC SP11 is acceptable.

### 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.			
	(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.			
<b>Mix Ratio</b>	3 part(s) : 1 part(s) by volume			
<b>Working Pot Life</b>	5°C (41°F) 3 hours	10°C (50°F) 2 hours	25°C (77°F) 60 minutes	40°C (104°F) 35 minutes
<b>Airless Spray</b>	Recommended	Tip Range 0.43-0.53 mm (17-21 thou) Total output fluid pressure at spray tip not less than 155 kg/cm <sup>2</sup> (2204 p.s.i.)		
<b>Air Spray (Pressure Pot)</b>	Recommended	Gun Air Cap Fluid Tip	DeVilbiss MBC or JGA 704 or 765 E	
<b>Brush</b>	Suitable	Typically 40-50 microns (1.6-2.0 mils) can be achieved		
<b>Roller</b>	Recommended	Typically 40-50 microns (1.6-2.0 mils) can be achieved		
<b>Thinner</b>	International GTA220 (or GTA415)	Do not thin more than allowed by local environmental legislation.		
<b>Cleaner</b>	International GTA822 (or GTA415)			
<b>Work Stoppages</b>	Do not allow material to remain in hoses, gun or spray equipment. Thoroughly flush all equipment with International GTA822 or International GTA415. 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 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.			

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### PRODUCT CHARACTERISTICS

Intergard 2510 is preferred for use with systems for chemical environments where zinc based materials can be subject to attack in both acidic and alkaline conditions.

The maximum overcoating interval will be dependent upon the integrity of the exposed film. A film of 75 microns (3 mils) dry film thickness will normally be overcoatable after 6-12 months exposure (depending upon the corrosivity of the environment) provided it is adequately cleaned and any areas of mechanical damage repaired.

Over-application of Intergard 2510 will extend both the minimum overcoating periods and handling times, and may be detrimental to long term overcoating properties.

When applying Intergard 2510 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.

In common with all epoxies Intergard 2510 will chalk and discolour on exterior exposure. However, these phenomena are not detrimental to anti-corrosive performance.

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

The coating will appear hard dry after 26 hours at temperatures below 0°C (32°F); however minimum overcoating interval at 0°C (32°F) and -5°C (23°F) is 40 hours and 48 hours, respectively.

Intergard 2510 is capable of curing at temperatures lower than -5°C (23°F) but cure time will be significantly prolonged at these temperatures.

This product should not be applied at temperatures below 0°C (32°F) where there is a possibility of ice formation on the substrate.

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

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Recommended topcoats are:

Interfine 629HS  
Interfine 691  
Interthane 870  
Interthane 990

For other suitable 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](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	15 litre	20 litre	5 litre	5 litre
For availability of other pack sizes, contact International Protective Coatings.					
SHIPPING WEIGHT (TYPICAL)	Unit Size	Part A		Part B	
		27.7 kg		6.9 kg	
	20 litre				
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

*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.*

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