

Intergard® 264



Surface Tolerant Epoxy

PRODUCT DESCRIPTION A low VOC, two component, self priming, surface tolerant epoxy with semi gloss finish. Exhibits excellent chemical and abrasion resistance. A high build formulation 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

Color FPD052-Off White, FPJ034-Light Grey, FPL274-Red, FPY999-Black

Gloss Level Low Semi-Gloss

Volume Solids 80% ± 3% (ASTM D2697-86)

Typical Thickness 4-8 mils (100-200 microns) dry equivalent to 5.2-10.4 mils (130-260 microns) wet

Theoretical Coverage 256 sq.ft./US gallon at 5 mils d.f.t. and stated volume solids
6.27 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

Temperature	Touch Dry	Hard Dry	Minimum	Overcoating Interval with Interthane 990 & Self, 740 990HS	
				Maxium	Maximum
50°F (10°C)	10 hours	24 hours	24 hours	12 weeks	10 days
59°F (15°C)	7 hours	17 hours	18 hours	10 weeks	10 days
77°F (25°C)	4 hours	8 hours	10 hours	2 months	7 days
104°F (40°C)	2 hours	4 hours	7 hours	1 month	2 days

REGULATORY DATA

Flash Point Base (Part A) 117°F (47°C) C/A (Part B) 124°F (51°C) Mixed 117°F (47°C)

Product Weight 11.47 lb/gal (1.37 kg/l)

VOC 1.62 lb/gal (194 g/l) USA - EPA Method 24



Ecotech is an initiative by International Protective Coatings, a world leader in coating technology, to promote the use of environmentally sensitive products across the globe.

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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 8504:1992.

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.

Abrasive Blast Cleaning

For atmospheric exposure best performance will be achieved when Intergard 264 is applied to surfaces prepared to a minimum of SSPC-SP6 or Sa2½ (ISO 8501-1:1988).

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.

Hand or Power Tool Preparation

Hand or power tool clean to a minimum SSPC-SP2 or St2 (ISO 8501-1:1988).

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 SSPC-SP6 or Sa2 (ISO 8501-1:1988). 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 SSPC-SP6 or Sa2½ (ISO 8501-1:1988) 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.			
	<ol style="list-style-type: none"> (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 parts : 1 part by volume			
Induction Time	15 minutes below 70°F (21°C)			
Working Pot Life	50°F (10°C) 8 hours	59°F (15°C) 6 hours	77°F (25°C) 4 hours	104°F (40°C) 1 hour
Airless Spray	Recommended	<ul style="list-style-type: none"> - Tip range 19-23 thou (0.48-0.58 mm) - Total output fluid pressure at spray tip not less than 2,500 p.s.i. (176 kg/cm²) 		
Air Spray (Pressure Pot)	Recommended	Gun Air Cap Fluid Tip	DeVilbiss MBC or JGA 704 E	
Brush	Suitable - small small areas	Typically 3-4 mils (75-100 microns) can be achieved		
Roller	Suitable small areas	Typically 3-4 mils (75-100 microns) can be achieved		
Thinner	International GTA415 (or GTA220)	Do not thin more than allowed by local environmental legislation.		
Cleaner	International GTA415 (or GTA220)			
Work Stoppages	Do not allow material to remain in hoses, gun or spray equipment. Thoroughly flush all equipment with 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.			
Clean Up	Clean all equipment immediately after use with International GTA415. 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 conventional 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 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 5°F (3°C) above dew point.

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

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

Application - Low Temperature Curing (Sub Zero)

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

Pot Life	23°F (-5°C) 8 hours	41°F (5°C) 5 hours	59°F (15°C) 3 hours	77°F (25°C) 2½ hours
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Induction Period 15 minutes below 60°F

Drying Time

Temperature	Touch Dry	Hard Dry	<i>Minimum</i>	Minimum Overcoating Interval with Interthane 990 & Self, 740 990HS	
				<i>Maximum</i>	<i>Maximum</i>
23°F (-5°C)	21 hours	72 hours	—	3 months	—
41°F (5°C)	7 hours	20 hours	16 hours	2 months	7 days
59°F (15°C)	2 hours	9 hours	10 hours	5 weeks	5 days
77°F (25°C)	2 hours	6 hours	4 hours	4 weeks	3 days

Note: Consult your International representative for specific recommendations on minimum overcoating times @ 23°F (-5°C).

SYSTEMS COMPATIBILITY

Intergard 264 is normally applied directly to correctly prepared steel substrates. However, it can also be used over suitably primed surfaces. Suitable primers are:

Intercure 200HS	Interzinc 12
Intergard 269	Interzinc 22
Interplus 256	Interzinc 22HS
Interplus 356	Interzinc 52
	Interzinc 315

Where a cosmetically acceptable finish is required. The following topcoats are recommended:

Intercryl 530	Interplus 80
Interfine 629HS	Interthane 990
Intergard 740	Interthane 990HS

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 sections of the International Protective Coatings data manual:

- Definitions & Abbreviations
- Surface Preparation
- Paint Application
- Practical & Theoretical 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, and the container(s), and should not be used without reference to the Material Safety Data Sheet 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 fume 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	5 gallon unit	Intergard 264 Base	4 gallons in a 5 gallon container
		Intergard 264 Curing Agent	1 gallon in a 1 gallon container
	For availability of other pack sizes contact International Protective Coatings		
SHIPPING WEIGHT	U.N. Shipping No. UN 1263		
	55 gallon unit	57 lb (25.9 kg) Base (Part A)	8.8 lb (4.0 kg) Curing Agent (Part B)
STORAGE	Shelf Life	12 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 given in this sheet is not intended to be exhaustive and any person using the product for any purpose other than that specifically recommended in this sheet without first obtaining written confirmation from us as to the suitability of the product for the intended purpose does so at his own risk. Any warranty, if given, or specific Terms & Conditions of Sale are contained in International's Terms & Conditions of Sale, a copy of which can be obtained on request. While we endeavor to ensure that all advice we give about the product (whether in this sheet or otherwise) is correct we have no control over either the quality or 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 whatsoever or howsoever arising for the performance of the product or for any loss or damage (other than death or personal injury resulting from our negligence) arising out of the use of the product. The information contained in this sheet is liable to modification from time to time in the light of experience and our policy of continuous product development.

It is the user's responsibility to check that this sheet is current prior to using the product. Issue date: 18th June 2004

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International Protective Coatings

Worldwide Availability

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