

Epoxy

PRODUCT DESCRIPTION

A two pack, low temperature cure, epoxy universal primer which can be overcoated with various finish coats such as polyurethane, epoxy and alkyd finishes after extended periods, without the use of a tie coat. It is also used as a primer over galvanised steel and stainless steel.

INTENDED USES

As a general purpose universal primer for above water areas and immersion areas for outfitting, including non-ferrous metals.

- For use at Newbuilding and Maintenance & Repair.
- Suitable for use with controlled cathodic protection.
- Suitable for use at low temperature.
- Good anti-corrosive seawater resistance.
- Good adhesion to various substrates including non-ferrous metal.
- Good adhesion with various finish coats after extended periods.

PRACTICAL INFORMATION FOR INTERGARD 361

Colour Buff, Grey, Light Red, White, Yellow, and a limited range of colours.

Gloss Level Matt

Volume Solids 65% ± 2%

Typical Thickness 75-150 microns (3-6 mils) dry equivalent to
115-231 microns (4.6-9.2 mils) wet

Theoretical Coverage 6.50 m²/litre at 100 microns d.f.t and stated volume solids
261 sq.ft/US gallon at 4 mils d.f.t and stated volume solids

Practical Coverage Allow appropriate loss factors

Method of Application Airless Spray, Brush, Roller

Drying Time

Temperature	Touch Dry	Hard Dry	Overcoating Interval with recommended topcoats	
			Minimum	Maximum
-5°C (23°F)	10 hours	48 hours	14 hours ¹	Extended ²
5°C (41°F)	6 hours	30 hours	12 hours ¹	Extended ²
25°C (77°F)	4 hours	9 hours	8 hours ¹	Extended ²
40°C (104°F)	2 hours	5 hours	5 hours ¹	Extended ²

¹ The minimum data may change depending on the top coat.

² See International Protective Coatings Definitions and Abbreviations

Consult your International Protective Coatings representative for specific recommendations

REGULATORY DATA

Flash Point (Typical) Part A 23°C (73°F); Part B 23°C (73°F); Mixed 25°C (77°F)

Product Weight 1.49 kg/l (12.4 lb/gal)

VOC 2.75 lb/gal (330 g/l) EPA Method 24

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.

Abrasive Blast Cleaning

Abrasive blast clean to Sa2½ (ISO 8501-1:2007) or SSPC-SP6. If oxidation has occurred between blasting and application of Intergard 361, the surface should be reblasted to the specified visual standard.

Shop Primed Steel

Intact shop primers must be clean, dry and free from soluble salts and any other surface contaminants. If the shop primer shows extensive or widely scattered breakdown overall sweep blasting may be necessary.

Non-Ferrous Surfaces and Galvanized Steel

Ensure surface is clean, dry and free from metal corrosion products. Oil or grease should be removed in accordance with SSPC-SP1 solvent cleaning.

Consult your International Protective Coatings representative for specific recommendations.

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	6 part(s) : 1 part(s) by volume			
Working Pot Life	-5°C (23°F) 8 hours	5°C (41°F) 6 hours	25°C (77°F) 3 hours	40°C (104°F) 2 hours
Airless Spray	Recommended	Tip Range 0.46-0.58 mm (18-23 thou) Total output fluid pressure at spray tip not less than 176 kg/cm ² (2503 p.s.i.)		
Air Spray (Pressure Pot)	Recommended	Gun Air Cap Fluid Tip	DeVilbiss MBC or JGA 704 or 765 E	
Air Spray (Conventional)	Not recommended			
Brush	Suitable - small areas only	Multiple coats may be required to achieve specified film thickness.		
Roller	Suitable - small areas only	Multiple coats may be required to achieve specified film thickness.		
Thinner	International GTA220	DO NOT thin more than allowed by local environmental legislation.		
Cleaner	International GTA822 or International GTA220			
Work Stoppages	Do not allow material to remain in hoses, gun or spray equipment. Thoroughly flush all equipment with International GTA822 or 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 GTA822 or International GTA220. It is good working practise 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

Intergard 361 is primarily designed to be overcoated with various finish coats such as polyurethane, epoxy, alkyd finishes after extended periods, without a tie coat.

When overcoating with Intergard 415, Intergard 740, Interthane 989, Interthane 990 and Interlac 665 the anticipated level of intercoat adhesion can only be achieved in extended overcoating situations when:

a) the aged coating has the "extended" surface characteristics required for long term overcoatability. For example, an over applied epoxy MIO may not have its usual "textured" surface and will no longer be overcoatable after ageing unless it is abraded.

b) the coating to be overcoated is intact, tightly adherent, clean, dry and free of all contaminants.

c) coatings with a glossy surface are treated by light surface abrasion, sweep blasting or other suitable processes which do not cut through or detract from the performance of the underlying coating.

Intergard 361 is also used as a primer for non-ferrous surfaces such as galvanized, aluminium and stainless steel. Intergard 361 gives good adhesive performance with non-ferrous substrates compared with other epoxy primers. The preparing of substrate should be a minimum SSPC-SP1 solvent cleaning. Consult International Protective Coatings about the paint system with Intergard 361 over non-ferrous substrates.

The anti-corrosive performance of Intergard 361 is due to barrier protection. The anti-corrosive performance of Intergard 361 and its long overcoating interval contribute to increased productivity for applicators, as it is possible to replace some three coat systems with Intergard 361 and a finish.

Intergard 361 is suitable for low temperature application down to -5°C (23°F).

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

In common with all epoxies Intergard 361 will chalk and discolour on exterior exposure. However, these phenomena are not detrimental to anti-corrosive performance.

Due to regional regulations, Intergard 269 at 40 microns DFT can be substituted for direct to metal applications where Intergard 361 is unavailable. Consult your International Protective Coatings representative for specific recommendations.

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

Suitable primers are:

Interzinc 22* Interzinc 52

* (mist coat or tie coat may be required)

Suitable topcoats are:

Intergard 740 Interthane 989
Interthane 870 Interthane 990

For other suitable primers, consult International Protective Coatings. See relevant product data sheet for details.

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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 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				
	15 litre	12.85 litre	18 litre	2.15 litre	3 litre
For availability of other pack sizes, contact International Protective Coatings.					
SHIPPING WEIGHT (TYPICAL)	Unit Size		Part A	Part B	
	15 litre		24.4 kg	2.3 kg	
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 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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