

## Epoxy

### PRODUCT DESCRIPTION

A two component, ultra high solids, ultra low VOC, HAPs free, versatile epoxy primer/finish.

### INTENDED USES

Designed for use in the rail industry as a one coat direct-to-metal (DTM) exterior finish or can be used as a primer for approved topcoats.

Intergard 3500 has excellent edge retention properties and provides a combination of anti-corrosive barrier protection and chemical fume and spillage resistance. Intergard 3500 is formulated with ultra-high solids, providing an option where regulations or customer preference require low VOCs and zero HAPs coatings. This versatile epoxy is ideal for high production, high through put environments where rapid overcoating products are needed.

### PRACTICAL INFORMATION FOR INTERGARD 3500

**Colour** White, Black, Light Grey, Dark Grey, Special colours upon request

**Gloss Level** High Gloss

**Volume Solids** 94% ± 2%

**Typical Thickness** 100-200 microns (4-8 mils) dry equivalent to  
106-213 microns (4.2-8.5 mils) wet

**Theoretical Coverage** 6.27 m<sup>2</sup>/litre at 150 microns d.f.t and stated volume solids  
251 sq.ft/US gallon at 6 mils d.f.t and stated volume solids

**Practical Coverage** Allow appropriate loss factors

**Method of Application** Plural Component Airless Spray, Brush, Roller

#### Drying Time

Temperature	Touch Dry	Hard Dry	Overcoating Interval with recommended topcoats	
			Minimum	Maximum
15°C (59°F)	12 hours	18 hours	18 hours	14 days
25°C (77°F)	6 hours	8 hours	8 hours	14 days
40°C (104°F)	3 hours	4 hours	4 hours	14 days

### REGULATORY DATA

**Flash Point (Typical)** Part A >101°C (>214°F); Part B >101°C (>214°F); Mixed >101°C (>214°F)

**Product Weight** 1.61 kg/l (13.4 lb/gal)

**VOC** 0.33 lb/gal (40 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 steel 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 clean to Sa2½ (ISO 8501-1:2007) or SSPC-SP6.  
A sharp, angular profile of 50-100 microns (2-4 mils) should be achieved.

Immediately prior to coating application, the surface shall comply with the specified degree of cleaning.

Please refer to Application Guidelines for further information.

### APPLICATION

<b>Mixing</b>	Material is supplied in two containers as a unit. Complete units should be stored, mixed and applied in accordance with the relevant Application Guidelines.	
<b>Mix Ratio</b>	2 part(s) : 1 part(s) by volume	
<b>Working Pot Life</b>	15°C (59°F)	25°C (77°F) 40°C (104°F)
	2 hours	45 minutes 20 minutes
<b>Plural Component Airless Spray</b>	Recommended	Plural component application requires volumetric check of the mix ratio (utilizing a ratio monitoring system) before and during the application process. Variation in product colour during application can indicate the plural pump ratio is incorrect. Please refer to Application Guidelines for further information.
<b>Brush</b>	Suitable - small areas only	Typically 3.0-4.0 mils (75-100 microns) can be achieved
<b>Roller</b>	Suitable - small areas only	Typically 3.0-4.0 mils (75-100 microns) can be achieved
<b>Cleaner</b>	International GTA415 (or GTA220)	
<b>Work Stoppages</b>	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.	
<b>Clean Up</b>	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 should depend upon amount sprayed, temperature and elapsed time, including any delays.	
	All surplus material and empty containers should be disposed of in accordance with appropriate regional regulations/legislation.	

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### PRODUCT CHARACTERISTICS

**The detailed Application Guidelines should be consulted prior to use.**

Apply in good climatic conditions. The temperature of the surface to be coated must be at least 3°C (5°F) above the dew point.

When applying Intergard 3500 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 5°C (41°F). For maximum performance ambient curing temperatures should be above 10°C (50°F).

When applying Intergard 3500 in confined spaces ensure adequate ventilation.

When applying Intergard 3500 as a one coat direct-to-metal (DTM) exterior finish, it is recommended to specify and achieve a dry film thickness of 150-200 microns (6-8 mils).

When applying Intergard 3500 as a primer coat, it is recommended to specify and achieve a dry film thickness of 150-200 microns (4-6 mils).

Condensation occurring during or immediately after application may result in a matt finish and an inferior film. 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 phenomenon is particularly prominent in darker shades.

In common with all epoxies Intergard 3500 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.

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.

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### SYSTEMS COMPATIBILITY

The following topcoats are recommended:

Interfine 2700  
Interfine 979

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](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 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 International Protective Coatings for further advice.

PACK SIZE	Unit Size	Part A		Part B	
		Vol	Pack	Vol	Pack
	5 US gal	5 US gal	5 US gal	5 US gal	5 US gal
	50 US gal	50 US gal	55 US gal	50 US gal	55 US gal

For availability of other pack sizes, contact International Protective Coatings.

SHIPPING WEIGHT (TYPICAL)	Unit Size	Part A	Part B
		81.1 lb	52.3 lb
	50 US gal	817.7 lb	529 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

*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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