

Epoxy

PRODUCT DESCRIPTION

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

INTENDED USES

Suitable for use in both new construction and industrial maintenance situations.

PRACTICAL INFORMATION FOR INTERGARD 1032

Colour	Limited colour range available
Gloss Level	Matt
Volume Solids	47% ± 2%
Typical Thickness	40-50 microns (1.6-2 mils) dry equivalent to 85-106 microns (3.4-4.2 mils) wet
Theoretical Coverage	9.40 m ² /litre at 50 microns d.f.t and stated volume solids 377 sq.ft/US gallon at 2 mils 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	Overcoating Interval with recommended topcoats	
			<i>Minimum</i>	<i>Maximum</i>
25°C (77°F)	45 minutes	4 hours	3 hours	Extended ¹
40°C (104°F)	30 minutes	3 hours	2 hours	Extended ¹

¹ See International Protective Coatings Definitions and Abbreviations

REGULATORY DATA

Flash Point (Typical)	Part A 23°C (73°F); Part B 23°C (73°F); Mixed 23°C (73°F)	
Product Weight	1.41 kg/l (11.8 lb/gal)	
VOC	452 g/l (3.77 lb/gal)	(Calculated)

See Product Characteristics section for further details

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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 8504:2000.

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.

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. Surface defects revealed by the blast cleaning process should be ground, filled, or treated in the appropriate manner.

Intergard 1032 is suitable for application to blast cleaned surfaces which were initially to the above standard but have been allowed to deteriorate under good shop conditions for up to 7-10 days. The surface may deteriorate to Sa2 standard but must be free from loose powdery deposits.

Maintenance and Site Touch-up

The product is designed for application to surfaces prepared to St2 (ISO 8501-1:2007) or SSPC-SP2. When using power tools care should be taken to avoid surface polishing. The product may also be applied to surfaces which have been brush blasted to Sa1 (ISO 8501-1:2007) or SSPC-SP7. On poor surfaces brush application will assist performance.

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	4 part(s) : 1 part(s) by volume			
Working Pot Life	10°C (50°F)	15°C (59°F)	25°C (77°F)	40°C (104°F)
	10 hours	8 hours	6 hours	3 hours
Airless Spray	Recommended	Tip Range 0.38-0.53 mm (15-21 thou) Total output fluid pressure at spray tip not less than 155 kg/cm ² (2204 p.s.i.)		
Air Spray (Pressure Pot)	Recommended	Gun	DeVilbiss MBC or JGA	
		Air Cap	704 or 765	
		Fluid Tip	E	
Brush	Recommended	Typically 40-50 microns (1.6-2.0 mils) can be achieved.		
Roller	Recommended	Typically 40-50 microns (1.6-2.0 mils) can be achieved. Care should be taken to avoid under-application.		
Thinner	International GTA132 or International GTA220	Do not thin more than allowed by local environmental legislation		
Cleaner	International GTA132 or International GTA220			
Work Stoppages	Do not allow material to remain in hoses, gun or spray equipment. Thoroughly flush all equipment with International GTA132 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 GTA132 or 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.			

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PRODUCT CHARACTERISTICS

Anti-corrosive performance on hand prepared steel is related directly to both the degree of surface preparation and the dry film thickness of the system applied.

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

This product is not intended for use in aggressive, corrosive environments, or on heavily pitted or contaminated steel.

Intergard 1032 is not suitable for use as a barrier coat for upgrading old chlorinated rubber and vinyl systems.

When used in a marine environment the schemes and overcoating intervals utilised may differ. Coating systems incorporating Intergard 1032 are not suitable for immersion service.

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.

SYSTEMS COMPATIBILITY

The following topcoats are approved for use with Intergard 1032

Interthane 1022
Interthane 1023
Interthane 1024

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:

- 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 litre	4 litre	5 litre	1 litre	1 litre
SHIPPING WEIGHT (TYPICAL)	Unit Size	Part A		Part B	
	5 litre	6.03 kg		1.03 kg	
STORAGE	Shelf Life	24 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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