

Epoxy

PRODUCT DESCRIPTION A two pack, tar free, modified epoxy tie coat.

INTENDED USES As a tie coat between anticorrosives and either antifoulings or cosmetic finishes to ensure maximum system adhesion and performance on outside shell vessel areas.
As a sealer coat over Tributyltin (TBT) antifoulings.
Suitable for use in both New Construction and Industrial Maintenance and Repair situations.

PRACTICAL INFORMATION FOR INTERGARD 263

Colour	Limited colour range available
Gloss Level	Matt
Volume Solids	57% ±2% (ISO 3233:1998)
Typical Thickness	100 microns (4 mils) dry equivalent to 175 microns (7 mils) wet
Theoretical Coverage	5.70 m ² /litre at 100 microns d.f.t and stated volume solids 229 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 (41°F)	12 hours	24 hours	24 hours	5 days ¹
15°C (59°F)	8 hours	20 hours	8 hours	5 days ¹
25°C (77°F)	6 hours	16 hours	6 hours	5 days ¹
40°C (104°F)	3 hours	10 hours	4 hours	5 days ¹

¹ The minimum / maximum data may change depending on the recommended topcoat. Consult your International Protective Coatings representative for Intersmooth Anti Fouling top coat.

REGULATORY DATA

Flash Point (Typical)	Part A 45°C (113°F); Part B 21°C (70°F); Mixed 38°C (100°F)		
Product Weight	1.54 kg/l (12.9 lb/gal)		
VOC	3.71 lb/gal (445 g/l) 306 g/kg 420 g/l	EPA Method 24 EU Solvent Emissions Directive Chinese National Standard GB23985	

See Product Characteristics section for further details

Epoxy

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.

Intergard 263 should always be applied over a recommended anti-corrosive coating scheme. The primer surface should be dry and free of all contamination (oil, grease, salt etc.) and overcoated with Intergard 263 within the overcoating intervals specified. Consult the relevant primer data sheet.

Areas of breakdown, damage etc., should be prepared to the specified standard (e.g Sa2½ (ISO 8501-1:2007) or SSPC-SP6, Abrasive Blasting, or SSPC-SP11, Power Tool Cleaning) and patch primed prior to the application of Intergard 263.

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	4 part(s) : 1 part(s) by volume			
Working Pot Life	5°C (41°F)	15°C (59°F)	25°C (77°F)	40°C (104°F)
	8 hours	7 hours	6 hours	3 hours
Airless Spray	Recommended	Tip Range 0.46-0.66 mm (18-26 thou) Total output fluid pressure at spray tip not less than 176 kg/cm ² (2503 p.s.i.)		
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	Thinning is not normally required. Consult the local representative for advice during application in extreme conditions. Do not thin more than allowed by local environmental legislation.		
Cleaner	International GTA220, International GTA822, International GTA415	Choice of cleaner maybe subject to local legislation. Please consult your local representative for specific advice.		
Work Stoppages	Do not allow material to remain in hoses, gun or spray equipment. Thoroughly flush all equipment with International GTA220/GTA822 or 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 GTA220/GTA822 or 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. Do not exceed pot life limitations. All surplus materials and empty containers should be disposed of in accordance with appropriate regional regulations/legislation.			

Epoxy

PRODUCT CHARACTERISTICS

Intergard 263 is primarily designed for use as a tie coat between anti-corrosives and either anti-fouling or cosmetic finishes, ensuring maximum system adhesion and performance on outside shell vessel areas.

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.

Low or high temperatures may require specific application techniques to achieve maximum film build.

When applying Intergard 263 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).

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

When applying Intergard 263 in confined spaces ensure adequate ventilation.

Overcoating information is given for guidance only and is subject to regional variation depending upon local climate and environmental conditions. Consult your local International Paint representative for specific recommendations.

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 263 will chalk and discolour on exterior exposure.

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.

SYSTEMS COMPATIBILITY

Intergard 263 is designed for use over correctly primed steel.
Suitable primers are:

Intergard 343
Intergard 787
Intershield 300
Interzinc 22*
Interzinc 52

*mist coat may be required

Suitable topcoats are:

Intergard 263 Interthane 870
Intergard 740 Interthane 990
Intersmooth 7465HS SPC Interthane 989

For other suitable primers/topcoats consult International Protective Coatings.

Epoxy

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 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 AkzoNobel for further advice.

PACK SIZE	Unit Size	Part A		Part B	
		Vol	Pack	Vol	Pack
	20 litre	16 litre	20 litre	4 litre	5 litre

For availability of other pack sizes, contact AkzoNobel.

SHIPPING WEIGHT (TYPICAL)	Unit Size	Part A	Part B
	20 litre	26.24 kg	4.08 kg

STORAGE	Shelf Life	
		18 months 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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