

Epoxy

PRODUCT DESCRIPTION

A two component, HAPs free, low VOC, high solids, fast curing epoxy primer/finish.

INTENDED USES

Suitable for use as a one or two coat primer/finish coating or as an intermediate over recommended anti-corrosive primers.

Intergard 3450 provides a combination of anti-corrosive barrier protection and chemical fume and spillage resistance, along with good abrasion resistance. Ideal for use in moderately corrosive environments and where fast drying/rapid recoating is desired.

PRACTICAL INFORMATION FOR INTERGARD 3450

Color	White, Special colors upon request.
Gloss Level	Semi-gloss
Volume Solids	74% ± 2%
Typical Thickness	4-6 mils (100-150 microns) dry equivalent to 5.4-8.1 mils (135-203 microns) wet
Theoretical Coverage	237 sq.ft/US gallon at 5 mils d.f.t and stated volume solids 5.90 m ² /liter at 125 microns d.f.t and stated volume solids
Practical Coverage	Allow appropriate loss factors
Method of Application	Airless Spray, Plural Component Airless Spray, Conventional Spray, Brush, Roller

Drying Time

Temperature	Touch Dry	Hard Dry	Overcoating Interval with recommended topcoats	
			Minimum	Maximum
50°F (10°C)	90 minutes	7 hours	7 hours	Extended ¹
59°F (15°C)	75 minutes	5 hours	5 hours	Extended ¹
77°F (25°C)	60 minutes	2.5 hours	2.5 hours	Extended ¹
104°F (40°C)	30 minutes	60 minutes	60 minutes	Extended ¹

¹ See International Protective Coatings Definitions & Abbreviations

REGULATORY DATA

Flash Point (Typical)	Part A 91°F (33°C); Part B 109°F (43°C); Mixed 93°F (34°C)		
Product Weight	13.5 lb/gal (1.62 kg/l)		
VOC	1.90 lb/gal (228 g/l)	EPA Method 24	

See Product Characteristics section for further details

Protective Coatings

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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 Cleaning

Abrasive blast clean to Sa2½ (ISO 8501-1:2007) or SSPC-SP6. Immediately prior to coating application, the surface shall comply with the specified degree of cleaning. A sharp, angular profile of 1-2 mils maximum (25-50 microns maximum) is recommended.

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

Primed Surfaces

Weld seams and damaged areas should be blast cleaned to Sa2½ (ISO 8501-1:2007) or SSPC-SP6. If the shop primer shows extensive or widely scattered breakdown overall sweep blasting may be necessary.

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	50°F (10°C) 3 hours	59°F (15°C) 2 hours	77°F (25°C) 60 minutes	104°F (40°C) 45 minutes
Plural component airless spray	Suitable			
Airless Spray	Recommended			
Air Spray (Conventional)	Suitable			
Brush	Suitable - Touch up and small areas only		Typically 3.0-4.0 mils (75-100 microns) can be achieved	
Roller	Suitable - Touch up and small areas only		Typically 3.0-4.0 mils (75-100 microns) can be achieved	
Thinner	International GTA723	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 recommence			
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 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

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 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 3450 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 41°F (5°C). For maximum performance ambient curing temperatures should be above 50°F (10°C).

When applying Intergard 3450 in confined spaces, ensure adequate ventilation.

In moderately corrosive environments, it is recommended that a minimum of 4 mils (100 microns) dry film thickness should be specified to ensure adequate anti-corrosive performance. However, in non-aggressive, low corrosive environments such as those equating to C2 as per ISO 12944 part 2, it is acceptable to specify Intergard 3450 as a single coat at 3.2 mils (80 microns) dry film thickness.

Condensation occurring during or immediately after application may result in a matte 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 phenomena is particularly prominent in darker shades.

In common with all epoxies, Intergard 3450 will chalk and discolor on exterior exposure. However, these phenomena are not detrimental to anti-corrosive performance.

Where a durable cosmetic finish with good gloss and color 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 color and normal manufacturing tolerances.

SYSTEMS COMPATIBILITY

Intergard 3450 is normally applied directly to blast cleaned steel, however, it can also be applied over other epoxy primers.

Interzinc 52

The following topcoats are recommended:-

Interthane 990UHS

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:

- 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
	200 US gal	200 US gal	275 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	
	200 US gal	2787 lb		470.8 lb	
STORAGE	Shelf Life	18 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 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.

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