Intergard® 343

Epoxy

PRODUCT DESCRIPTION

A high volume solids, light coloured, aluminium pure epoxy universal primer with good corrosion and abrasion resistance. Suitable for application at low temperatures.

INTENDED USES

As a universal primer which can be applied directly to mechanically prepared shop primer.

Suitable for use with controlled cathodic protection.

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

PRACTICAL INFORMATION FOR INTERGARD 343

Colour	Bronze, Grey, Light Red
Gloss Level	Not applicable
Volume Solids	68% ±2% (ISO 3233:1998)
Typical Thickness	100-200 microns dry equivalent to 147-294 microns wet
Theoretical Coverage	5.40 m²/litre at 125 microns d.f.t and stated volume solids 218 sq.ft/US gallon at 5 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

			Overcoating interval with self	
Temperature	**Touch Dry**	**Hard Dry**	*Minimum*	*Maximum*
5°C (41°F)	9 hours	14 hours	14 hours	14 days
15°C (59°F)	5 hours	8 hours	8 hours	14 days
25°C (77°F)	2 hours	6 hours	6 hours	14 days
40°C (104°F)	30 minutes	4 hours	4 hours	14 days

The minimum / maximum data may change depending on the recommended topcoat.

REGULATORY DATA

Flash Point (Typical)	Part A 29°C (84°F); Part B 27°C (81°F); Mixed 30°C (86°F)	
Product Weight	1.27 kg/l (10.6 lb/gal)	
VOC	2.44 lb/gal (293 g/lt)	EPA Method 24

See Product Characteristics section for further details

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.

Primed Surfaces

Intergard 343 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 343 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 343.

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

3.00 part(s) : 1.0 part(s) by volume

Working Pot Life

5°C (41°F)	15°C (59°F)	25°C (77°F)	40°C (104°F)
7 hours	5 hours	4 hours	1.5 hours

Airless Spray	Recommended	Tip Range 0.63-0.79 mm (25-31 thou) Total output fluid pressure at spray tip not less than 211 kg/cm² (3000 p.s.i.)
Air Spray (Pressure Pot)	Recommended	Gun: DeVilbiss MBC or JGA Air Cap: 704 or 765 Fluid Tip: E
Air Spray (Conventional)	Suitable	Use suitable proprietary equipment
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 343 is a high performance, light coloured, abrasion resistant, aluminium pure epoxy coating suitable for use on multiple 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 343 by brush or roller, it may be necessary to apply multiple coats to achieve the total specified system dry film thickness.

Intergard 343 may be applied at substrate temperatures down to -15°C. Before applications are made below 5°C consult your local IP representative for further detail of application procedure.

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

When applying Intergard 343 in confined spaces ensure adequate ventilation.

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 343 will chalk and discolour on exterior exposure. However, these phenomena are not detrimental to anti-corrosive performance.

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

Intergard 343 is designed for use over correctly primed steel.
Suitable primers are:

Intergard 343	Intershield 300
Interplate 11	Interzinc 22*
Interplate 937	

(mist coat or tie coat may be required)*

Suitable topcoats are:

Intergard 263	Interthane 990
Intergard 343	
Intergard 740	

For other suitable primers/topcoats consult International Protective Coatings.

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
	15 litre	11.25 litre	18 litre	3.75 litre	4 litre
	For availability of other pack sizes, contact International Protective Coatings.				
SHIPPING WEIGHT (TYPICAL)	Unit Size	Part A		Part B	
	15 litre	15.57 kg		3.58 kg	
STORAGE	Shelf Life	12 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

www.international-pc.com