

Epoxy

PRODUCT DESCRIPTION

Two component epoxy coating.

INTENDED USES

As an internal flow coating for gas transmission service.

PRACTICAL INFORMATION FOR INTERGARD 272

Colour	Red
Gloss Level	Semi Gloss
Volume Solids	56%
Typical Thickness	50-100 microns (2-4 mils) dry equivalent to 89-179 microns (3.6-7.2 mils) wet
Theoretical Coverage	11.20 m ² /litre at 50 microns d.f.t and stated volume solids 449 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, Brush, Roller

Drying Time

Temperature	Touch Dry	Hard Dry	Overcoating Interval with recommended topcoats	
			Minimum	Maximum
10°C (50°F)	45 minutes	24 hours	Not applicable	Not applicable
15°C (59°F)	30 minutes	16 hours	Not applicable	Not applicable
25°C (77°F)	30 minutes	5 hours	Not applicable	Not applicable
40°C (104°F)	30 minutes	2.5 hours	Not applicable	Not applicable

REGULATORY DATA

Flash Point (Typical)	Part A 20°C (68°F); Part B 26°C (79°F); Mixed 22°C (72°F)		
Product Weight	1.4 kg/l (11.7 lb/gal)		
VOC	3.32 lb/gal (398 g/l) 287 g/kg	EPA Method 24 EU Solvent Emissions Directive (Council Directive 1999/13/EC)	

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 surfaces should be assessed and treated in accordance with ISO 8504:2000.

Where necessary, remove weld spatter and where required smooth weld seams and sharp edges.

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. If oxidation has occurred between blasting and application of Intergard 272, the surface should be reblasted to the specified visual standard.

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

Abrasive blast cleaning should be carried out using fine shot (grit is not suitable) to ensure that the surface profile does not exceed 30-40 microns (1.2-1.6 mils) and is not sharp and angular.

Remove all dust and abrasive via a suitable method prior to application of Intergard 272.

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) : 1.00 part(s) by volume			
Working Pot Life	10°C (50°F) 7 hours	15°C (59°F) 6 hours	25°C (77°F) 4 hours	40°C (104°F) 2 hours
Airless Spray	Recommended	Tip Range 0.37-0.53 mm (15-21 thou) Total output fluid pressure at spray tip not less than 176 kg/cm ² (2503 p.s.i.)		
Air Spray (Pressure Pot)	Not recommended			
Air Spray (Conventional)	Not recommended			
Brush	Suitable - small areas only	Typically 50 microns (2.0 mils) can be achieved		
Roller	Suitable - small areas only	Typically 50 microns (2.0 mils) can be achieved		
Thinner	International GTA220 or International GTA415	Do not thin more than allowed by local environmental legislation		
Cleaner	International GTA822 or International GTA415			
Work Stoppages	Do not allow material to remain in hoses, gun or spray equipment. Thoroughly flush all equipment with International GTA822. 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. 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

Apply by airless spray only. Application by other methods, e.g. brush, roller, may require more than one coat and should only be used for small areas or touch-up work.

Do not apply at steel temperatures below 10°C (50°F).

This product will not cure adequately below 10°C (50°F). For maximum performance ambient curing temperatures should be above 10°C (50°F).

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

Intergard 272 is not designed for continuous water immersion.

Optimum performance of Intergard 272 will be obtained at a dry film thickness of 50-100 microns (2-4 mils).

This product has the following specification approvals:

- American Petroleum Institute Specification API RP 5L2.

Note: VOC values quoted are based on maximum possible for the product taking into account variations due to colour differences 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 272 is only applied directly to correctly prepared steel.

Intergard 272 should never be overcoated with another product.

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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
	20 litre	15 litre	20 litre	5 litre	5 litre
For availability of other pack sizes, contact International Protective Coatings.					
SHIPPING WEIGHT (TYPICAL)	Unit Size	Part A		Part B	
	20 litre	25.5 kg		5.1 kg	
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 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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