

Epoxy

PRODUCT DESCRIPTION

A general purpose, two component epoxy anti-corrosive primer pigmented with zinc phosphate to comply with BS5493:1977.

INTENDED USES

For use on properly prepared surfaces as an industrial maintenance primer for a wide range of anti-corrosive paint systems for use in the offshore, petrochemical, chemical, pulp and paper and bridge industries.

The fast drying and handling properties, together with extended overcoatability, make this an excellent primer for factory application prior to full system application on site. Intergard 242 provides good abrasion resistance which minimises mechanical damage in transit between factory and site.

Ideal as a primer for steel likely to be subjected to acid or alkaline environments. Also suitable for use as a blast holding primer where required.

PRACTICAL INFORMATION FOR INTERGARD 242

Colour	Buff, Red Oxide
Gloss Level	Matt
Volume Solids	53%
Typical Thickness	50-100 microns (2-4 mils) dry equivalent to 94-189 microns (3.8-7.6 mils) wet
Theoretical Coverage	7.10 m ² /litre at 75 microns d.f.t and stated volume solids 283 sq.ft/US gallon at 3 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	
			Minimum	Maximum
10°C (50°F)	6 hours	20 hours	24 hours	Extended ¹
15°C (59°F)	3 hours	12 hours	16 hours	Extended ¹
25°C (77°F)	60 minutes	4 hours	12 hours	Extended ¹
40°C (104°F)	30 minutes	2 hours	8 hours	Extended ¹

¹ See International Protective Coatings Definitions and Abbreviations

REGULATORY DATA

Flash Point (Typical)	Part A 24°C (75°F); Part B 27°C (81°F); Mixed 24°C (75°F)	
Product Weight	1.47 kg/l (12.3 lb/gal)	
VOC	314 g/kg	EU Solvent Emissions Directive (Council Directive 1999/13/EC)
	465 g/l	UK - PG6/23(04), Appendix 3

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.

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 242, 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.

This product is NOT recommended over hand prepared steel.

Shop Primed Steel

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	10°C (50°F) 10 hours	15°C (59°F) 8 hours	25°C (77°F) 5 hours	40°C (104°F) 2 hours
Airless Spray	Recommended	Tip Range 0.38-0.53 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)	Recommended	Gun Air Cap Fluid Tip	DeVilbiss MBC or JGA 704 or 765 E	
Brush	Suitable - small areas only	Typically 40-50 microns (1.6-2.0 mils) can be achieved		
Roller	Suitable - small areas only	Typically 40-50 microns (1.6-2.0 mils) can be achieved		
Thinner	International GTA220	Do not thin more than allowed by local environmental legislation		
Cleaner	International GTA822			
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 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

Intergard 242 is preferred for use with systems for chemical environments where zinc based materials can be subject to attack in both acidic and alkaline conditions.

The maximum overcoating interval will be dependent upon the integrity of the exposed film. A film of 75 microns (3 mils) dry film thickness will normally be overcoatable after 6-12 months exposure (depending upon the corrosivity of the environment) provided it is adequately cleaned and any areas of mechanical damage repaired.

Over-application should be avoided as thick films will not be as good a substrate for topcoat adhesion after ageing as those at the specified thickness. When using as a blast holding primer avoid over-application as thick films may suffer from cohesive film splitting if subsequent coats are also over-applied.

Over-application of Intergard 242 will extend both the minimum overcoating periods and handling times, and may be detrimental to long term overcoating properties.

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

When applying Intergard 242 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). For maximum performance ambient curing temperatures should be above 10°C (50°F). Surface temperature must always be a minimum of 3°C (5°F) above dew point.

In common with all epoxies Intergard 242 will chalk and discolour on exterior exposure. However, these phenomena are not detrimental to anti-corrosive performance.

Intergard 242 is not designed for continuous water immersion.

Where a durable cosmetic finish with good gloss and colour retention is required overcoat with recommended topcoats.

This product complies with the requirements of

- BS5493:1977 KP1A

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 242 will normally be applied to suitably prepared steel, e.g. blast cleaned. However, if necessary, application over prefabrication blast primers can be performed. Consult International Protective Coatings for further details.

The following topcoats and intermediates can be applied to Intergard 242:

Intercryl 525	Intercryl 700	Interfine 629HS
Intergard 251	Intergard 400	Intergard 410
Intergard 475HS	Intergard 740	Interlac 658
Interplus 770	Interplus 880	Interprime 306
Interprime 466	Interseal 670HS	Intersheen 73
Interthane 990	Interzone 505	Interzone 954

For other suitable topcoats/intermediates 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
	20 litre	16 litre	20 litre	4 litre	5 litre
For availability of other pack sizes, contact International Protective Coatings.					
SHIPPING WEIGHT (TYPICAL)	Unit Size	Part A		Part B	
		kg		kg	
	20 litre	27.7		4.2	
STORAGE	Shelf Life	18 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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