Intergard® 3500

International®

Epoxy

PRODUCT DESCRIPTION

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

INTENDED USES

Designed for use in the rail industry as a one coat direct-to-metal (DTM) exterior finish or can be used as a primer for approved topcoats.

Intergard 3500 has excellent edge retention properties and provides a combination of anti-corrosive barrier protection and chemical fume and spillage resistance. Intergard 3500 is formulated with ultra-high solids, providing an option where regulations or customer preference require low VOCs and zero HAPs coatings. This versatile epoxy is ideal for high production, high through put environments where rapid overcoating products are needed.

PRACTICAL INFORMATION FOR INTERGARD 3500

Color	White, Black, Light gray, Dark Gray, Special colors upon request
Gloss Level	High Gloss
Volume Solids	94% ± 2%
Typical Thickness	4-8 mils (100-200 microns) dry equivalent to 4.2-8.5 mils (106-213 microns) wet
Theoretical Coverage	251 sq.ft/US gallon at 6 mils d.f.t and stated volume solids 6.27 m²/liter at 150 microns d.f.t and stated volume solids
Practical Coverage	Allow appropriate loss factors
Method of Application	Plural component airless spray, Brush, Roller

Drying Time

			Overcoating Interval with recommended topcoats	
Temperature	**Touch Dry**	**Hard Dry**	*Minimum*	*Maximum*
59°F (15°C)	12 hours	18 hours	18 hours	14 days
77°F (25°C)	6 hours	8 hours	8 hours	14 days
104°F (40°C)	3 hours	4 hours	4 hours	14 days

REGULATORY DATA

Flash Point (Typical)	Part A >214°F (>101°C); Part B >214°F (>101°C); Mixed >214°F (>101°C)	
Product Weight	13.4 lb/gal (1.61 kg/l)	
VOC	0.33 lb/gal (40 g/lt)	EPA Method 24

See Product Characteristics section for further details

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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 clean to Sa2½ (ISO 8501-1:2007) or SSPC-SP6.
A sharp, angular profile of 2-4 mils (50-100 microns) should be achieved.

Immediately prior to coating application, the surface shall comply with the specified degree of cleaning.

Please refer to Application Guidelines for further information.

APPLICATION

Mixing

Material is supplied in two containers as a unit. Complete units should be stored, mixed and applied in accordance with the relevant Application Guidelines.

Mix Ratio

2 part(s) : 1 part(s) by volume

Working Pot Life

59°F (15°C)	77°F (25°C)	104°F (40°C)
2 hours	45 minutes	20 minutes

Plural component airless spray	Recommended	Plural component application requires volumetric check of the mix ratio (utilizing a ratio monitoring system) before and during the application process. Variation in product color during application can indicate the plural pump ratio is incorrect. Please refer to Application Guidelines for further information.
Brush	Suitable - Small areas only	Typically 3.0-4.0 mils (75-100 microns) can be achieved
Roller	Suitable - Small areas only	Typically 3.0-4.0 mils (75-100 microns) can be achieved

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

The detailed Application Guidelines should be consulted prior to use.

Apply in good climatic conditions. The temperature of the surface to be coated must be at least 5°F (3° C) above the dew point.

When applying Intergard 3500 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 3500 in confined spaces, ensure adequate ventilation.

When applying Intergard 3500 as a one coat direct-to-metal (DTM) exterior finish, it is recommended to specify and achieve a dry film thickness of 6-8 mils (150-200 microns).

When applying Intergard 3500 as a primer coat, it is recommended to specify and achieve a dry film thickness of 4-6 mils (150-200 microns).

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 3500 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

The following topcoats are recommended:-

Interfine 2700
Interfine 979

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 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 International Protective Coatings for further advice.

PACK SIZE

Unit Size	Part A		Part B	
	Vol	Pack	Vol	Pack
5 US gal	5 US gal	5 US gal	5 US gal	5 US gal
50 US gal	50 US gal	55 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
5 US gal	81.1 lb	52.3 lb
50 US gal	817.7 lb	529 lb

STORAGE

Shelf Life	12 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

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