

## Epoxy

### PRODUCT DESCRIPTION

A high build, high solids, low VOC two component epoxy primer.

### INTENDED USES

For the protection of steel structures in aggressive environments.

Demonstrates excellent resistance to alkalis, salt solutions and water.

Suitable for overcoating with epoxy, polyurethane and acrylic finishes.

### PRACTICAL INFORMATION FOR INTERGARD 235

<b>Colour</b>	Red Oxide, Light Grey, White
<b>Gloss Level</b>	Semi Gloss
<b>Volume Solids</b>	80%
<b>Typical Thickness</b>	100-160 microns (4-6.4 mils) dry equivalent to 125-200 microns (5-8 mils) wet
<b>Theoretical Coverage</b>	5.30 m <sup>2</sup> /litre at 150 microns d.f.t and stated volume solids 214 sq.ft/US gallon at 6 mils d.f.t and stated volume solids
<b>Practical Coverage</b>	Allow appropriate loss factors
<b>Method of Application</b>	Airless Spray, Air Spray, Brush, Roller
<b>Drying Time</b>	

Temperature	Touch Dry	Hard Dry	Overcoating Interval with recommended topcoats	
			Minimum	Maximum
10°C (50°F)	8 hours	30 hours	36 hours	72 hours
15°C (59°F)	6 hours	24 hours	24 hours	60 hours
25°C (77°F)	3 hours	16 hours	16 hours	48 hours
40°C (104°F)	2 hours	12 hours	10 hours	24 hours

### REGULATORY DATA

<b>Flash Point (Typical)</b>	Part A 24°C (75°F); Part B 27°C (81°F); Mixed 24°C (75°F)	
<b>Product Weight</b>	1.53 kg/l (12.8 lb/gal)	
<b>VOC</b>	199 g/l	Calculated

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 surfaces should be assessed and treated in accordance with Petrobras Standard N-5.

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

### Abrasive Blast Cleaning

Abrasive grit blast clean to Sa2½ (ISO 8501:2007) (Near-White Metal) or Petrobras Standard N-9.

### APPLICATION

<b>Mixing</b>	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.			
	Manual agitation may be used for up to 18 litres of material.			
<b>Mix Ratio</b>	5 part(s) : 1 part(s) by volume			
<b>Working Pot Life</b>	10°C (50°F) 4 hours	15°C (59°F) 3 hours	25°C (77°F) 2 hours	40°C (104°F) 1 hour
<b>Airless Spray</b>	Recommended	Tip Range 0.46-0.58 mm (18-23 thou) Total output fluid pressure at spray tip not less than 176 kg/cm <sup>2</sup> (2503 p.s.i.)		
<b>Air Spray (Pressure Pot)</b>	Recommended	Gun	502 JGA	
		Air Cap	765 or 777	
		Pressure	4.2 kg/cm <sup>2</sup> (60 p.s.i.)	
<b>Brush</b>	Recommended - Small areas only	Multiple coats may be required to achieve specified film thickness.		
<b>Roller</b>	Recommended - Small areas only	Multiple coats may be required to achieve specified film thickness.		
<b>Thinner</b>	Not recommended	Use International GTA822 only in exceptional circumstances (maximum 5% by volume)		
<b>Cleaner</b>	International GTA822			
<b>Work Stoppages</b>	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.			
<b>Clean Up</b>	Clean all equipment immediately after use with International GTA822. It is good working practice to periodically clean equipment during the course of the working day. Frequency of cleaning will depend upon amount used, 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 in good climatic conditions. The temperature of the surface to be coated must be at least 3°C (5°F) above the dew point.

Do not apply if air temperature is less than 10°C (50°F).

For optimum application properties, bring the material up to a temperature of 25-30°C (77-86°F) prior to mixing and application.

Unmixed material (in closed containers) should be maintained in protected storage in accordance with information given in the Storage section of this datasheet.

This product has the following specification approvals:

- Petrobras Standard N-2630

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.

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### SYSTEMS COMPATIBILITY

Consult International Protective Coatings regarding specific recommendations.

Suitable topcoats are:

Interlac 665	Interlac 84
Interline 491	Interseal 653
Interthane 582	

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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](http://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	16.67 litre	20 litre	3.33 litre	3.6 litre
	3.6 litre	3 litre	3.6 litre	0.6 litre	0.9 litre
For availability of other pack sizes, contact International Protective Coatings.					
SHIPPING WEIGHT (TYPICAL)	Unit Size	Part A		Part B	
	3.6 litre	5.24 kg		0.71 kg	
	20 litre	28.6 kg		3.61 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](http://www.international-marine.com) or [www.international-pc.com](http://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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