

Epoxy

PRODUCT DESCRIPTION

A low VOC, high solids, high build, two component epoxy coating. Available with conventional pigmentation, or alternatively can be pigmented with micaceous iron oxide to provide enhanced overcoating properties.

INTENDED USES

For use as a high build epoxy coating to improve barrier protection for a range of anti-corrosive coating systems in a wide range of environments including offshore structures, petrochemical plants, pulp and paper mills and bridges. Suitable for use in both maintenance and new construction situations as part of an anti-corrosive coating system. The micaceous iron oxide variant improves long term overcoating properties, better facilitating application in the fabrication shop, prior to shipping, with final overcoating on site.

PRACTICAL INFORMATION FOR INTERGARD 475HS

Color	Light gray MIO and a selected range of colors
Gloss Level	Matte
Volume Solids	80%
Typical Thickness	4-8 mils (100-200 microns) dry equivalent to 5-10 mils (125-250 microns) wet
Theoretical Coverage	257 sq.ft/US gallon at 5 mils d.f.t and stated volume solids 6.40 m ² /liter at 125 microns 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
23°F (-5°C)	150 minutes	48 hours	48 hours	Extended ¹
41°F (5°C)	90 minutes	16 hours	16 hours	Extended ¹
50°F (10°C)	80 minutes	14 hours	13 hours	Extended ¹
59°F (15°C)	75 minutes	10 hours	10 hours	Extended ¹
77°F (25°C)	60 minutes	5 hours	5 hours	Extended ¹

¹ See International Protective Coatings Definitions & Abbreviations

Maximum overcoating intervals are shorter when using polysiloxane topcoats. Consult International Protective Coatings for further details.

For curing at elevated temperatures an alternative curing agent is available. See Product Characteristics for details.

REGULATORY DATA Flash Point (Typical) Part A 93°F (34°C); Part B 88°F (31°C); Mixed 91°F (33°C)

VOC	1.72 lb/gal (207 g/lit)	EPA Method 24
	92 g/kg	EU Solvent Emissions Directive (Council Directive 1999/13/EC)
	159 g/lit (1.32 lb/US Gal)	Chinese National Standard GB23985

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 ISO 8504:2000.

Primed Surfaces

Intergard 475HS should always be applied over a recommended anti-corrosive coating scheme. The primer surface should be dry and free from all contamination, and Intergard 475HS must be applied within the overcoating intervals specified (consult the relevant product data sheet).

Areas of breakdown, damage etc., should be prepared to the specified standard (e.g. SSPC-SP6 or Sa2½ (ISO 8501 -1:2007), Abrasive Blasting, or SSPC-SP11, Power Tool Cleaning) and patch primed prior to the application of Intergard 475HS.

Zinc Primed Surfaces

Ensure that the surface of the primer is clean, dry and free from contamination and zinc salts before application of Intergard 475HS. Ensure zinc primers are fully cured before overcoating.

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 part(s) : 1 part(s) by volume			
Working Pot Life	23°F (-5°C) 3 hours	41°F (5°C) 3 hours	59°F (15°C) 2.5 hours	77°F (25°C) 2 hours
Airless Spray	Recommended	Tip Range 21-25 thou (0.53-0.63 mm) Total output fluid pressure at spray tip not less than 2702 psi (190 kg/cm²)		
Air Spray (Pressure Pot)	Recommended	Gun Air Cap Fluid Tip	DeVilbiss MBC or JGA 704 or 765 E	
Brush	Suitable	Typically 3.0 mils (75 microns) can be achieved		
Roller	Suitable	Typically 3.0 mils (75 microns) can be achieved		
Thinner	International GTA007	Thinning is not normally required. Consult the local representative for advice during application in extreme conditions. Do not thin more than allowed by local environmental legislation.		
Cleaner	International GTA822 (or International GTA415)	Choice of cleaner may be subject to local legislation. Please consult your local representative for specific advice.		
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

Intergard 475HS is primarily designed for use as a high build barrier coat to impart barrier protection to a coating system. It is recommended that it should be overcoated with a durable finish from the Interfine or Interthane range when appearance is important.

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

When applying Intergard 475HS by brush or roller, it may be necessary to apply multiple coats to achieve the total specified system dry film thickness.

Surface temperature must always be a minimum of 5°F (3°C) above dew point. When applying Intergard 475HS in confined spaces, ensure adequate ventilation. Exposure to unacceptably low temperatures and/or high humidities during, or immediately after, application may result in incomplete cure and surface contamination that could jeopardize subsequent intercoat adhesion.

Elevated Temperature Curing

An alternative curing agent is available for applications at temperatures greater than 77°F (25°C).

<u>Temperature</u>	<u>Touch Dry</u>	<u>Hard Dry</u>	<u>Overcoating Interval with recommended topcoats</u>	
			<u>Minimum</u>	<u>Maximum</u>
77°F (25°C)	90 minutes	6 hours	6 hours	Extended *
104°F (40°C)	60 minutes	2 hours	2 hours	Extended *

* See International Protective Coatings Definitions and Abbreviations

Interchanging standard and elevated temperature curing agents during application to a specific structure will give rise to an observable color change due to the difference in the yellowing/discoloration process common to all epoxies on exposure to UV light. In common with all epoxies, Intergard 475HS will chalk and discolor on exterior exposure. However, these phenomena are not detrimental to anti-corrosive performance.

Intergard 475HS is not designed for continuous water immersion.

The micaceous iron oxide variant of this product is frequently used as a "travel coat" prior to final overcoating on site. To ensure best extended overcoating properties, ensure overapplication does not occur and that the surface is fully cleaned of any contamination which may be present in the surface texture due to the coarse nature of the micaceous iron oxide pigmentation.

When applying Intergard 475HS at temperatures less than 59°F (15°C) or wet film thicknesses of 6 mils (150 microns) or less, addition of around 5% International GTA007 thinners will improve film appearance, sprayability and aid film thickness control.

On consultation with International Protective Coatings this product is compatible with alternative application methods such as flow coating.

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.

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 475HS is designed for use over correctly primed steel. Suitable primers are:

Intercure 200	Interzinc 22 (mist coat or tie coat recommended)*
Intergard 251	Interzinc 315
Intergard 251HS	Interzinc 52
Intergard 269	Interzinc 52E
Interzinc 2280(mist coat or tie coat recommended)*	

Suitable topcoats are:

Intergard 740	Interfine 629HS
Interfine 878	Interfine 979
Interthane 990	Intergard 475HS

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Interthane 990E

For alternative primers and finishes, consult International Protective Coatings.

* See relevant product data sheet for details.