

Epoxy

PRODUCT DESCRIPTION

A low VOC, two component, high solids epoxy anti-corrosive flow coat.

INTENDED USES

To reduce friction for internal pipe lines carrying natural gas and to improve flow efficiency and corrosion protection.

Intergard 2272 conforms to ISO 15741 - 2001, BSEN - 10301:2003, American Petroleum Institute - API 5L2 4th Edition.

PRACTICAL INFORMATION FOR INTERGARD 2272

Colour	Red			
Gloss Level	Semi-gloss			
Volume Solids	63%			
Typical Thickness	75-150 microns (3-6 mils) dry equivalent to 119-238 microns (4.8-9.5 mils) wet			
Theoretical Coverage	6.30 m ² /litre at 100 microns d.f.t and stated volume solids 253 sq.ft/US gallon at 4 mils d.f.t and stated volume solids			
Practical Coverage	Allow appropriate loss factors			
Method of Application	Airless Spray, Plural Component Airless Spray, Brush, Roller			
Drying Time	Overcoating interval with self			
Temperature	Touch Dry	Hard Dry	<i>Minimum</i>	<i>Maximum</i>
25°C (77°F)	45 minutes	6 hours	6 hours	24 hours
40°C (104°F)	30 minutes	4 hours	4 hours	16 hours

REGULATORY DATA

Flash Point (Typical)	Part A 26°C (79°F); Part B 26°C (79°F); Mixed 26°C (79°F)		
Product Weight	1.34 kg/l (11.2 lb/gal)		
VOC	340 g/lit	Calculated	
See Product Characteristics section for further details			

Epoxy

SURFACE PREPARATION

The performance of this product will depend upon the degree of 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. Accumulated dirt and soluble salts must be removed by fresh water washing.

Abrasive Blast Cleaning

Intergard 2272 must be applied to surfaces blast cleaned to Sa2½ (ISO 8501-1:2007) or SSPC-SP10. Surface defects revealed by the blast cleaning process should be ground, filled or treated in the appropriate manner. A surface profile of 30-60 microns (1.2 - 2.4 mils) is recommended.

APPLICATION

Mixing	This material is supplied in full containers suitable for use with plural component airless spray equipment.	
	For use with airless spray equipment:	
	(1) Agitate Base (Part A) with a power agitator	
	(2) Combine Curing Agent (Part B) with Base (Part A) and mix thoroughly with a power agitator	
Mix Ratio	1.00 part(s) : 1.00 part(s) by volume	
Working Pot Life	15°C (59°F) 6 hours	25°C (77°F) 4 hours
		40°C (104°F) 2 hours
Plural Component Airless Spray	Recommended	
Airless Spray	Recommended	Tip Range 0.45-0.58 mm (18-23 thou) Total output fluid pressure at spray tip not less than 281 kg/cm ² (3996 p.s.i.)
Brush	Suitable - small areas only	Typically 75 microns (3.0 mils) can be achieved
Roller	Suitable - small areas only	Typically 75 microns (3.0 mils) can be achieved
Thinner	International GTA220	Do not thin more than allowed by local environmental legislation
Cleaner	International GTA415 or International GTA822	
Work Stoppages	Do not allow material to remain in hoses, gun or spray equipment. Thoroughly flush all equipment with International GTA822 or International GTA415. 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 or 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 materials and empty containers should be disposed of in accordance with appropriate regional regulations/legislation.	

Epoxy

PRODUCT CHARACTERISTICS

Intergard 2272 is suitable for the internals of natural gas pipelines.

This product must be applied with airless equipment only. Plural component application is preferred; Intergard 2272 is supplied in quantities that suit this method. Maximum film build in one coat is best attained by spray. When applying by other methods, the film build is unlikely to be achieved.

When using plural component equipment it is important to regularly check that the mix ratio is correct.

Surface temperature must always be a minimum of 3°C (5°F) above dew point.

Level of sheen and surface finish is dependent on application method. 50% overlap is recommended during application to ensure the surface is properly coated and to avoid pinholes in the dry film.

Optimum performance is achieved at dry film thicknesses of 70-100 microns (2.8-3.0 mils).

If an exterior coating specification calls for fusion bonded epoxy (FBE) then Intergard 2272 is resistant for short term baking at temperatures up to 250°C (482°F) for 15 minutes.

Intergard 2272 is not designed for continuous water immersion.

This product meets the following specifications:

- American Petroleum Institute - API 5L2 4th Edition.
- ISO 15741 - 2001
- BSEN - 10301:2003

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.

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 2272 is designed as a single coat system. It must only be overcoated with itself should re-coats or touch-up be required.

Epoxy

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
	40 litre	20 litre	20 litre	20 litre	20 litre
	400 litre	200 litre	200 litre	200 litre	200 litre
For availability of other pack sizes, contact International Protective Coatings.					
SHIPPING WEIGHT (TYPICAL)	Unit Size	Part A		Part B	
	40 litre	26.8 kg		26.8 kg	
	400 litre	268 kg		268 kg	
STORAGE	Shelf Life	12 months 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.

Copyright © AkzoNobel, 05/02/2015.

All trademarks mentioned in this publication are owned by, or licensed to, the AkzoNobel group of companies.

www.international-pc.com