

# Intergard 251

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## Product Description

A two component epoxy anti-corrosive primer pigmented with zinc phosphate.

## Intended Uses

For use on properly prepared surfaces in both new construction situations and as an industrial maintenance primer for a wide range of anti-corrosive coatings 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 251 provides good abrasion resistance which minimises mechanical damage in transit between the factory and site.

## Practical Information for Intergard 251

<b>Colour</b>	Buff, Grey, Red oxide			
<b>Gloss Level</b>	Matt			
<b>Volume Solids</b>	63%			
<b>Typical Thickness</b>	50-75 microns (2-3 mils) dry equivalent to 79-119 microns (3.2-4.8 mils) wet			
<b>Theoretical Coverage</b>	8.40 m <sup>2</sup> /litre at 75 microns d.f.t and stated volume solids 337 sq.ft/US gallon at 3 mils d.f.t and stated volume solids			
<b>Practical Coverage</b>	Allow appropriate loss factors			
<b>Method of Application</b>	Air Spray, Airless spray, Brush, Roller			
<b>Drying Time</b>	Overcoating Interval with recommended topcoats			
Temperature	Touch Dry	Hard Dry	<i>Minimum</i>	<i>Maximum*</i>
10°C (50°F)	2 hours	7 hours	7 hours	6-12 months
15°C (59°F)	1 hour	5 hours	5 hours	6-12 months
25°C (77°F)	45 minutes	3 hours	3 hours	6-12 months
40°C (104°F)	30 minutes	2 hours	2 hours	6-12 months

\* See Product Characteristics section

## Regulatory Data

<b>Flash Point</b>	Base (Part A) 24°C (75°F)	C/A (Part B) 27°C (81°F)	Mixed 24°C (75°F)
<b>Product Weight</b>	1.38 kg/l (11.52 lb/gal)		
<b>VOC</b>	385 g/l	UK - PG6/23(92), Appendix 3	
	3.25 lb/gal (390 g/l)	USA - EPA Method 24	

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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 8504:1992.

Oil or grease should be removed in accordance with SSPC-SP1 solvent cleaning.

### Abrasive Blast Cleaning

Abrasive blast clean to Sa2½ (ISO 8501-1:1988) or SSPC-SP6. If oxidation has occurred between blasting and application of Intergard 251, 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.

### Shop Primed Steelwork

Weld seams and damaged areas should be blast cleaned to Sa2½ (ISO 8501-1:1988) or SSPC-SP6.

If the shop primer shows extensive or widely scattered breakdown overall sweep blasting may be necessary.

## Application

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<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			
<b>Mix Ratio</b>	4 parts : 1 parts by volume			
<b>Working Pot Life</b>	10°C (50°F) 10 hours	15°C (59°F) 8 hours	25°C (77°F) 6 hours	40°C (104°F) 3 hours
<b>Airless Spray</b>	Recommended	- Tip range 0.38-0.53 mm (15-21 thou) - Total output fluid pressure at spray tip not less than 155 kg/cm <sup>2</sup> (2,200 p.s.i.)		
<b>Air Spray (Pressure Pot)</b>	Recommended	Gun Air Cap Fluid Tip	DeVilbiss MBC or JGA 704 or 765 E	
<b>Brush</b>	Suitable	Typically 40-50 microns (1.5-2.0 mils) can be achieved		
<b>Roller</b>	Suitable	Typically 40-50 microns (1.5-2.0 mils) can be achieved		
<b>Thinner</b>	International GTA220 (or GTA415)	Do not thin more than allowed by local environmental legislation.		
<b>Cleaner</b>	International GTA822 (or GTA415)			
<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 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 251 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 251 will extend both the minimum overcoating periods and handling times, and may be detrimental to long term overcoating properties.

When applying Intergard 251 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 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 251 will chalk and discolour on exterior exposure. However, these phenomena are not detrimental to anti-corrosive performance.

Intergard 251 is not designed for continuous water immersion.

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

## Systems Compatibility

Intergard 251 is designed for application to correctly prepared steel. However, it is also possible to apply over approved prefabrication primers. Further details of these can be obtained from International Protective Coatings.

The following primers are recommended for Intergard 251:

Interzinc 12 (mist coat or tie coat may be required)\*  
Interzinc 22 (mist coat or tie coat may be required)\*  
Interzinc 42  
Interzinc 52  
Interzinc 280  
Interzinc 315

The following topcoats are recommended for Intergard 251:

Intercryl 530	Intergard 735
Intercure 420	Intergard 740
Interfine 629 HS	Interplus 770
Intergard 251	Interplus 880
Intergard 401	Interseal 670 HS
Intergard 475 HS	Interthane 990

Alternative topcoats are also available, consult International Protective Coatings

\* See relevant product data sheet for details.

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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 sections of the International Protective Coatings data manual:

- 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.

<b>Pack Size</b>	20 litre unit	Intergard 251 Base	16 litres in a 20 litre container
	5 gallon unit	Intergard 251 Curing Agent Intergard 251 Base Intergard 251 Curing Agent	4 litres in a 5 litre container 4 gallons in a 5 gallon container 1 gallon in a 1 gallon container
For availability of other pack sizes contact International Protective Coatings			
<b>Shipping Weight</b>	U.N. Shipping No. 1263		
	20 litre unit	26.0 kg (57.3 lb) Base (Part A) 4.2 kg (9.3 lb) Curing Agent (Part B)	
	5 gallon unit	24.6 kg (54.1 lb) Base (Part A) 4.0 kg (8.8 lb) Curing Agent (Part B)	
<b>Storage</b>	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.	

## Disclaimer

*The information given in this sheet is not intended to be exhaustive and any person using the product for any purpose other than that specifically recommended in this sheet without first obtaining written confirmation from us as to the suitability of the product for the intended purpose does so at his own risk. Any warranty, if given, or specific Terms & Conditions of Sale are contained in International's Terms & Conditions of Sale, a copy of which can be obtained on request. Whilst we endeavour to ensure that all advice we give about the product (whether in this sheet or otherwise) is correct we have no control over either the quality or 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 whatsoever or howsoever arising for the performance of the product or for any loss or damage (other than death or personal injury resulting from our negligence) arising out of the use of the product. The information contained in this sheet is liable to modification from time to time in the light of experience and our policy of continuous product development.*

*It is the user's responsibility to check that this sheet is current prior to using the product. Issue date: 10/04/2000*

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## International Protective Coatings

### Worldwide Availability

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