

Intergard 345

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Product Description

A two component, low VOC, high solids, fast curing epoxy primer/finish containing zinc phosphate anti-corrosive pigmentation.

Intended Uses

Suitable for use as a one or two coat primer/finish coating or as an intermediate over recommended anti-corrosive primers.
 Intergard 345 provides a combination of anti-corrosive barrier protection, chemical fume and spillage resistance, along with good abrasion resistance.
 Ideal for use in moderately corrosive environments and where fast drying/rapid recoating is desired.

Practical Information for Intergard 345

Colour	Wide range via the Chromascan system
Gloss Level	Semi-gloss
Volume Solids	70%
Typical Thickness	100-150 microns (4-6 mils) dry equivalent to 143-214 microns (5.7-8.6 mils) wet
Theoretical Coverage	5.6 m ² /litre at 125 microns d.f.t and stated volume solids 225 sq.ft/US gallon at 5 mils 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	
			<i>Minimum</i>	<i>Maximum</i>
10°C (50°F)	90 minutes	7 hours	7 hours	Extended*
15°C (59°F)	75 minutes	5 hours	5 hours	Extended*
25°C (77°F)	60 minutes	2½ hours	2½ hours	Extended*
40°C (104°F)	30 minutes	1 hour	1 hour	Extended*

*See International Protective Coatings Definitions & Abbreviations

Regulatory Data

Flash Point	Base (Part A) 33°C (91°F)	C/A (Part B) 43°C (109°F)	Mixed 34°C (93°F)
Product Weight	1.45 kg/l (12.1 lb/gal)		
VOC	270 g/l	2.25 lb/gal	UK - PG6/23(92), Appendix 3 2.67 lb/gal (320 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 345, 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.

Intergard 345 is suitable for application to blast cleaned surfaces which were initially to the above standard but have been allowed to deteriorate under good shop conditions for up to 7-10 days. The surface may deteriorate to Sa2 standard but must be free from loose powdery deposits.

Primed Surfaces

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.

Concrete, Pre-cast Blockwork, etc

Intergard 345 is suitable for application to concrete. For the first coat it is recommended that Intergard 345 is thinned 10-15% by International Thinners in order to provide good penetration with the concrete substrate and act as a primer/sealer coat.

Concrete should be cured for a minimum of 28 days prior to coating. The moisture content of the concrete should be below 6%. All surfaces should be clean, dry and free from curing compounds, release agents, trowelling compounds, surface hardeners, efflorescence, grease, oil, dirt, old coatings and loose or disintegrating concrete. All poured and precast concrete must also be sweep blasted (preferred) or acid etched to remove laitance.

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	4 parts : 1 part by volume			
Working Pot Life	10°C (50°F) 3 hours	15°C (59°F) 2 hours	25°C (77°F) 60 minutes	40°C (104°F) 45 minutes
Airless Spray	Recommended	- Tip range 0.43-0.53 mm (17-21 thou) - Total output fluid pressure at spray tip not less than 176 kg/cm ² (2,500 p.s.i.)		
Air Spray (Pressure Pot)	Recommended	Gun Air Cap Fluid Tip	DeVilbiss MBC or JGA 704 or 765 E	
Brush	Suitable - Small areas only	Typically 75-100 microns (3-4 mils) can be achieved		
Roller	Suitable - Small areas only	Typically 75-100 microns (3-4 mils) can be achieved		
Thinner	International GTA220 (or GTA415)	Do not thin more than allowed by local environmental legislation.		
Cleaner	International GTA220 (or GTA415)			
Work Stoppages	Do not allow material to remain in hoses, gun or spray equipment. Thoroughly flush all equipment with International GTA220. 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 GTA220. 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

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

When applying Intergard 345 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 ambient curing temperatures should be above 10°C (50°F).

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

When applying Intergard 345 in confined spaces ensure adequate ventilation.

It is recommended that a minimum of 100 microns (4 mils) should always be applied to ensure adequate anti-corrosive performance.

Condensation occurring during or immediately after application may result in a matt 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.

Intergard 345 is not designed for continuous water immersion.

In common with all epoxies Intergard 345 will chalk and discolour on exterior exposure. However, these phenomena are not detrimental to anti-corrosive performance.

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

Systems Compatibility

Intergard 345 is normally applied directly to blast cleaned steel, however, it can also be applied directly over the following primers:-

Intercure 200
Intercure 200HS
Intergard 251
Intergard 269
Intergard 345
Interzinc 42
Interzinc 52
Interzinc 315

The following topcoats are recommended:-

Interfine 629HS
Intergard 735
Intergard 740
Interthane 870
Interthane 990

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 sections of the International Protective Coatings data manual:

- Definitions & Abbreviations
- Surface Preparation
- Paint Application
- Practical & Theoretical 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	20 litre unit	Intergard 345 Base Intergard 345 Curing Agent	16 litres in a 20 litre container 4 litres in a 5 litre container
	5 gallon unit	Intergard 345 Base Intergard 345 Curing Agent	4 gallons in a 5 gallon container 1 gallon in a 1 gallon container
For availability of other pack sizes contact International Protective Coatings			
Shipping Weight	U.N. Shipping No. 1263		
	20 litre unit	26.8 kg (59.1 lbs) Base (Part A)	4.3 kg (9.5 lbs) Curing Agent (Part B)
	5 gallon unit	22.7 kg (50 lbs) Base (Part A)	3.9 kg (8.7 lbs) Curing Agent (Part B)
Storage	Shelf Life		
	18 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: 19/12/2002

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International Protective Coatings

Worldwide Availability

<u>World Centre</u>	<u>Asia Region</u>	<u>Australasia Region</u>	<u>Europe Region</u>	<u>Middle East Region</u>	<u>North America Region</u>	<u>South America Region</u>
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