

PRODUCT DESCRIPTION

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

INTENDED USES

For use on correctly prepared surfaces in both new construction situations and as an industrial maintenance primer for a wide range of anti-corrosive coating systems for use in the offshore, petrochemical, chemical pulp and paper and HVI industries.

PRACTICAL INFORMATION

Colour	Red, Grey
Gloss Level	Semi-Gloss
Volume Solids	82%
Typical Thickness	75-220 microns (3-8.7 mils) dry equivalent to 91-268 microns (3.6-10.6 mils) wet
Theoretical Coverage	10.9 m ² /litre @ 75 microns d.f.t. and stated volume solids 444 sq.ft/US gallon @ 3 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>
5°C (41°F)	3 hours	14 hours	14 hours	Extended*
10°C (50°F)	2 hours	6 hours 30	4 hours	Extended*
25°C (77°F)	90 mins	3 hours	2 hours	Extended*
40°C (104°F)	60 mins	2 hours	2 hours	Extended*

* See International Protective Coatings Definitions & Abbreviations

REGULATORY DATA

Flash Point	Base (Part A) 26°C (79°F)	C/A (Part B) 26°C (79°F)	Mixed 26°C (79°F)
Product Weight	1.58 kg/l		
SED VOC	138 g/kg	EU Solvent Emissions Directive (Council Directive 1999/13/EC)	

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.

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

Abrasive Blast Cleaning

Abrasive blast clean to Sa2½ (ISO 8501-1:2007) or SSPC-SP6. If oxidation has occurred between blasting and application of this primer, 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.

A surface profile of 40-75 microns (1.6-3.0 mils) is recommended.

Shop Primed Steelwork

Weld seams and damaged areas should be blast cleaned to a minimum Sa2½ (ISO 8501-1:2007). Where this is not practical, preparation to SSPC-SP11 is recommended.

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 parts : 1 part by volume			
Working Pot Life	5°C (41°F) 3 hours	10°C (50°F) 2 hours	25°C (77°F) 1 hour	40°C (104°F) 35 mins
Airless Spray	Recommended.	- Tip range 0.43-0.53mm (17-21 thou) - Total output fluid pressure at spray tip not less than 155 kg/cm ² (2204 p.s.i.)		
Air Spray (Pressure Pot)	Recommended.	Gun Air Cap Fluid Tip	DeVilbiss MBC or JGA 704 or 765 E	
Brush	Suitable	Typically 40-50 microns (1.6-2.0 mils) can be achieved.		
Roller	Suitable	Typically 40-50 microns (1.6-2.0 mils) can be achieved.		
Thinner	International GTA220 (or GTA415)	Do not thin more than allowed by local environmental legislation.		
Cleaner	International GTA822 (or GTA415)			
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.			

PRODUCT CHARACTERISTICS

Intergard 2510 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 dependant 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 will extend both the minimum overcoating periods and handling times, and may be detrimental to long term overcoating properties.

When applying this primer 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 3°C (5°F) above dew point.

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

Intergard 2510 is not designed for continuous water immersion.

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

The coating will appear hard dry after 26 hours at temperatures below 0°C (32°F). However minimum overcoating interval at 0°C (32°F) and -5°C (23°F) is 40 hours and 48 hours, respectively.

Intergard 2510 is capable of curing at temperatures lower than -5°C (23°F); however, cure time will be significantly prolonged at these temperatures.

This primer should not be applied at temperatures below 0°C (32°F) where there is a possibility of ice formation on the substrate.

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.

Intergard 2510 is designed for application to correctly prepared steel. It is possible to apply over approved prefabrication primers. Details of these can be obtained from International Protective Coatings.

SYSTEM COMPATIBILITY

Recommended topcoats are:-

Interthane 870
Interthane 990

For other suitable topcoats, consult International Protective Coatings.

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

Intergard 2510 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	15 litre	20 litre	5 litre	5 litre

For availability of other pack sizes contact International Protective Coatings.

SHIPPING WEIGHT

Unit Size	Part A	Part B
20 litre	25.7kg	6.4 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.
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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 datasheet or otherwise) is correct to the best of our knowledge but we have not 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 product development. It is the user's responsibility to check with their local International Paint representative that this data sheet is current prior to using the product.

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