

# Intergard 475

High build epoxy

**Product Description** A high build high solids two component epoxy coating

High performance intermediate / finish coat  
 Outstanding moisture, chemical and solvent resistance  
 Suitable for atmospheric and immersion service  
 Extremely tough when cured and will resist damage

**Intended Uses** As a high performance coating for structures in severe environments e.g. Offshore oil platforms, shiploaders, coal wash plants, wharf piles.  
 Intergard 475 provides resistance to fresh or salt water, petroleum products, aliphatic solvents, alkalis and other chemical products.

**Practical Information for Intergard 475**

**Colour** Wide range available via the Chromascan system plus aluminium and MIO.  
**Gloss Level** Semi gloss  
**Volume Solids** 83%  
**Typical Thickness** 125-250 microns (5-10 mils) dry equivalent to 150-300 microns (6-12 mils) wet  
**Theoretical Coverage** 5.5 m<sup>2</sup>/litre at 150 microns d.f.t and stated volume solids  
 224 sq.ft/US gallon at 6 mils d.f.t and stated volume solids  
**Practical Coverage** Allow appropriate loss factors  
**Method of Application** Airless spray  
**Drying Time\***

Temperature	Touch Dry	Hard Dry	Overcoating Interval with recommended topcoats	
			<i>Minimum</i>	<i>Maximum</i>
10°C (50°F)	12 hours	48 hours	48 hours	14 days
15°C (59°F)	8 hours	30 hours	30 hours	10 days
25°C (77°F)	4 hours	16 hours	16 hours	5 days
40°C (104°F)	2 hours	8 hours	8 hours	48 hours

\* For curing at low temperatures, an alternative curing agent is available. See Product Characteristics for details

**Regulatory Data**

**Flash Point** Base (Part A) <10°C (<50°F) C/A (Part B) >65°C (>149°F) Mixed <10°C (<50°F)  
**Product Weight** 1.52 kg/l (12.7 lb/gal)  
**VOC** 170 g/l UK - PG6/23(92), Appendix 3

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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.

### Steel

For immersion service, Intergard 475 must be applied directly to surfaces blast cleaned to a minimum of Sa2½ (ISO 8501-1:1988) SSPC SP10.

However, for atmospheric exposure Intergard 475 should be applied over approved anti-corrosive primers. The primer surface should be dry and free from all contamination, and Intergard 475 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 and patch primed prior to the application of Intergard 475.

### Galvanised steel

Degrease to SSPC-SP1 and lightly abrasive blast or abrade with power sanding. Apply Intergard 475 direct.

### Concrete

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 laitence. Large cracks should be filled with an appropriate filler.

## 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)	15°C (59°F)	25°C (77°F)	40°C (104°F)
4 hours	2 hours	1 hour	30 minutes

### Airless Spray

Recommended

- Tip range 0.53-0.66 mm (21-26 thou)
- Total output fluid pressure at spray tip not less than 211 kg/cm<sup>2</sup> (3,000 p.s.i.)

### Air Spray (Pressure Pot)

Suitable	Gun	DeVilbiss MBC or JGA
Thin up to 20%	Air Cap	704 or 765
	Fluid Tip	E

### Brush

Suitable for small areas

Typically 90 microns (3.6 mils) can be achieved

### Roller

Suitable for small areas

Typically 45 microns (1.8 mils) can be achieved

### Thinner

International GTA007

### Cleaner

International GTA220

### 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 recommence 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

Recognised as the Industry benchmark for intermediate / high build epoxies used in severe environments where additional film thickness is required for long life performance.

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 conventional 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.

Application by other methods, e.g. brush or roller, may require more than one coat and should only be used for small areas or touch-up work.

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.

Available in a wide range of colours produced via the Chromascan system.

In common with all epoxies Intergard 475 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.

When pigmented with MIO different application techniques will yield different appearances due to the MIO pigment alignment.

MIO pigment "sparkle" occurs only after prolonged exterior exposure to UV light.

### Drying times for Winter Curing Agent

Temperature	Touch Dry	Hard Dry	Overcoating Interval with recommended topcoats	
			<i>Minimum</i>	<i>Maximum</i>
10°C (50°F)	10 hours	30 hours	30 hours	14 days
15°C (59°F)	6 hours	16 hours	16 hours	7 days

### Working Pot Life using Winter Curing Agent

10°C (50°F) 3 hours	15°C (59°F) 1½ hours
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## Systems Compatibility

The following primers are recommended for Intergard 475

Interzinc 12  
Interzinc 22  
Interzinc 42  
Interzinc 52  
Interzinc 215  
Interzinc 315  
Intercure 200  
Intergard 251

The following topcoats are recommended for Intergard 475

Interfine 227  
Interfine 629  
Interthane 80  
Interthane 990

For other suitable primers/topcoats, please 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
- 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 475 Base	16 litres in a 20 litre steel container
		Intergard 475 Curing Agent	4 litres in a 4 litre steel container
	5 gallon unit	Intergard 475 Base	4 gallons in a 5 gallon steel container
		Intergard 475 Curing Agent	1 gallon in a 1 gallon steel container
For availability of other pack sizes contact International Protective Coatings			
<b>Shipping Weight</b>	U.N. Shipping No. 1263		
	20 litre unit	28 kg (61.6 lb) Base (Part A) 4.5 kg (9.9 lb) Curing Agent (Part B)	
	5 gallon unit	26.5 kg (58.3 lb) Base (Part A) 4.3 kg (9.5 lb) Curing Agent (Part B)	
<b>Storage</b>	Shelf Life	24 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: 01/10/1998*

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