

Intergard 475HS

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Product Description

A low VOC, high solids, high build, two component epoxy coating. Available with conventional pigmentation, or alternatively can be pigmented with micaceous iron oxide to provide enhanced overcoating properties.

Intended Uses

For use as a high build epoxy coating to improve barrier protection for a range of anti-corrosive coating systems in a wide range of environments including offshore structures, petrochemical plants, pulp and paper mills and bridges.

Suitable for use in both maintenance and new construction situations as part of an anti-corrosive coating system.

The micaceous iron oxide variant improves long term overcoating properties, better facilitating application in the fabrication shop, prior to shipping, with final overcoating on site.

Practical Information for Intergard 475HS

Colour	Light grey MIO and a selected range of colours			
Gloss Level	Matt			
Volume Solids	80%			
Typical Thickness	100-200 microns (4-8 mils) dry equivalent to 125-250 microns (5-10 mils) wet			
Theoretical Coverage	6.40 m ² /litre at 125 microns d.f.t and stated volume solids 257 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	Overcoating Interval with recommended topcoats			
Temperature	Touch Dry	Hard Dry	<i>Minimum</i>	<i>Maximum#</i>
-5°C (23°F)	150 minutes	48 hours	48 hours	Extended*
5°C (41°F)	90 minutes	16 hours	16 hours	Extended*
15°C (59°F)	75 minutes	10 hours	10 hours	Extended*
25°C (77°F)▲	60 minutes	5 hours	5 hours	Extended*
40°C (104°F)▲	N/A	N/A	N/A	N/A

▲ For curing at elevated temperatures an alternative curing agent is available. See Product Characteristics for details.

* See International Protective Coatings Definitions & Abbreviations

Maximum overcoating intervals are reduced when using polysiloxane topcoats. Consult International Protective Coatings for further details.

Regulatory Data

Flash Point	Base (Part A) 34°C (93°F)	C/A (Part B) 31°C (88°F)	Mixed 33°C (91°F)
Product Weight	2.1 kg/l (17.5 lb/gal)		
VOC	160 g/l	UK - PG6/23(92), Appendix 3	
	1.73 lb/gal (207 g/l)	USA - EPA Method 24	



Ecotech is an initiative by International Protective Coatings a world leader in coating technology to promote the use of environmentally sensitive products across the globe.

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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.

Primed Surfaces

Intergard 475HS should always be applied over a recommended anti-corrosive coating scheme. The primer surface should be dry and free from all contamination, and Intergard 475HS 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 (e.g. Sa2½ (ISO 8501-1:1988) or SSPC-SP6, Abrasive Blasting, or SSPC-SP11, Power Tool Cleaning) and patch primed prior to the application of Intergard 475HS.

Zinc Primed Surfaces

Ensure that the surface of the primer is clean, dry and free from contamination and zinc salts before application of Intergard 475HS. Ensure zinc primers are fully cured before overcoating.

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 (23°F) 10°C (50°F) 15°C (59°F) 25°C (77°F) 40°C (104°F)
60 minutes 60 minutes 60 minutes 60 minutes N/A

Airless Spray

Recommended - Tip range 0.53-0.63 mm (21-25 thou)
- Total output fluid pressure at spray tip not less than 190 kg/cm² (2,700 p.s.i.)

Air Spray (Pressure Pot)

Recommended Gun DeVilbiss MBC or JGA
Air Cap 704 or 765
Fluid Tip E

Brush

Suitable Typically 75 microns (3 mils) can be achieved

Roller

Suitable Typically 75 microns (3 mils) can be achieved

Thinner

International GTA007 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.

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Product Characteristics

Intergard 475HS is primarily designed for use as a high build barrier coat to impart barrier protection to a coating system. It is recommended that it should be overcoated with a durable finish from the Interfine or Interthane range when appearance is important.

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.

When applying Intergard 475HS 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.

If applying Intergard 475HS in confined spaces ensure adequate ventilation.

Exposure to unacceptably low temperatures and/or high humidities during, or immediately after, application may result in incomplete cure and surface contamination that could jeopardise subsequent intercoat adhesion.

Elevated Temperature Curing▲

An alternative curing agent is available for applications at temperatures greater than 25°C (77°F).

Temperature	Touch Dry	Hard Dry	Overcoating Interval with recommended topcoats	
			<i>Minimum</i>	<i>Maximum</i>
25°C (77°F)	90 minutes	6 hours	6 hours	Extended*
40°C (104°F)	60 minutes	2 hours	2 hours	Extended*

* See International Protective Coatings Definitions and Abbreviations

Interchanging standard and elevated temperature curing agents during application to a specific structure will give rise to an observable colour change due to the difference in the yellowing/discolouration process common to all epoxies on exposure to UV light.

In common with all epoxies Intergard 475HS will chalk and discolour on exterior exposure. However, these phenomena are not detrimental to anti-corrosive performance.

Intergard 475HS is not designed for continuous water immersion.

The micaceous iron oxide variant of this product is frequently used as a “travel coat” prior to final overcoating on site. To ensure best extended overcoating properties, ensure over-application does not occur and that the surface is fully cleaned of any contamination which may be present in the surface texture due to the coarse nature of the micaceous iron oxide pigmentation.

When applying Intergard 475HS at temperatures less than 15°C (59°F) or wet film thicknesses of 150 microns (6 mils) or less, addition of around 5% International GTA007 thinners will improve film appearance, sprayability and aid film thickness control.

Systems Compatibility

Intergard 475HS is designed for use over correctly primed steel. Suitable primers are:

Intercure 200	Interzinc 12 (mist coat or tie coat recommended)*
Intergard 251	Interzinc 22 (mist coat or tie coat recommended)*
Intergard 269	Interzinc 42
Intergard 270	Interzinc 52
	Interzinc 280
	Interzinc 315

Suitable topcoats are:

Intercryl 530	Intergard 475HS
Interfine 629HS	Intergard 740
Interfine 878	Interthane 990
Interfine 979	

For alternative primers and finishes, 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.

Pack Size	20 litre unit	Intergard 475HS Base	15 litres in a 20 litre container
		Intergard 475HS Curing Agent	5 litres in a 5 litre container
	5 gallon unit	Intergard 475HS Base	3 gallons in a 5 gallon container
		Intergard 475HS Curing Agent	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	35.4 kg (78.0 lb) Base (Part A) 9.3 kg (20.5 lb) Curing Agent (Part B)	
	5 gallon unit	25.9 kg (57.3 lb) Base (Part A) 3.8 kg (8.4 lb) Curing Agent (Part B)	
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.	

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: 18/01/2005

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International Protective Coatings

Worldwide Availability

World Centre	Asia Region	Australasia Region	Europe Region	Middle East Region	North America Region	South America Region
P.O Box 20980 Oriol House 16 Connaught Place London, W2 2ZB England	3 Neythal Road Jurong Town Singapore 628570	115 Hyde Road Yeronga Brisbane Queensland Australia	P.O Box 20980 Oriol House 16 Connaught Place London, W2 2ZB England	PO Box 37 Dammam 31411 Saudi Arabia	6001 Antoine Drive Houston Texas 77091	Av Paiva 999, Neves, Sao Gonçalo, Rio de Janeiro Brazil

Tel: (44) 20 7479 6000	Tel: (65) 663 3066	Tel: (61) 7 3892 8888	Tel: (44) 20 7479 6000	Tel: (966) 3 812 1044	Tel: (1) 713 682 1711	Tel: (55) 21 624 7100
Fax: (44) 20 7479 6500	Fax: (65) 266 5287	Fax: (61) 7 3892 4287 H&S (61) 1800 807 001	Fax: (44) 20 7479 6500	Fax: (966) 3 812 1169	Fax: (1) 713 684 1514	Fax: (55) 21 624 7123

Local Office:

Tel: 0191 469 6111 Fax: 0191 495 0676