Intergard 264

Epoxy

PRODUCT DESCRIPTION

LOW TEMPERATURE
A two pack, self priming, surface tolerant epoxy with low semi-gloss finish. Exhibits excellent chemical and abrasion resistance. Suitable for use at low temperatures (down to -5°C). An ambient temperature cure version is available. Low VOC.

INTENDED USES

A universal anticorrosive for use on underwater hulls, above water and internal areas of marine vessels, barges and offshore structures.
For use at Newbuilding, Maintenance & Repair or On Board Maintenance.

PRODUCT INFORMATION

Colour	FPJ034-Light Grey, FPL274-Red, FPY999-Black For the availability of other colours, consult International Paint.
Finish/Sheen	Low Semi-Gloss
Part B (Curing Agent)	FCA321 for low temperature
Volume Solids	80% ±3% (ASTM D2697-86)
Mix Ratio	4.00 volume(s) Part A to 1 volume(s) Part B
Typical Film Thickness	125 microns dry (156 microns wet)
Theoretical Coverage	6.4 m²/litre at 125 microns dft, allow appropriate loss factors
Method of Application	Airless Spray, Conventional Spray
Flash Point (Typical)	Part A 47°C; Part B 52°C; Mixed 47°C (Setaflash) (ASTM D-3278)
Induction Period	15 minutes at temperatures below 16°C

Drying Information	-5°C	5°C	15°C	25°C
Touch Dry [ISO 9117/3:2010]	21 hrs	8 hrs	2 hrs	2 hrs
Hard Dry [ISO 9117-1:2009]	72 hrs	20 hrs	9 hrs	6 hrs
Pot Life	8 hrs	5 hrs	3 hrs	2.5 hrs

Overcoating Data - see limitations

	Substrate Temperature							
	-5°C		5°C		15°C		25°C	
Overcoated By	Min	Max	Min	Max	Min	Max	Min	Max
Intergard 264	*	12 wks	16 hrs	8 wks	10 hrs	5 wks	4 hrs	28 days
Intergard 267	*	12 wks	16 hrs	8 wks	10 hrs	5 wks	4 hrs	28 days
Intergard 740	*	12 wks	16 hrs	8 wks	10 hrs	5 wks	4 hrs	28 days
Intershield 6GV	-	-	24 hrs	7 days	24 hrs	7 days	24 hrs	7 days
Intershield 7100LWT	-	-	-	-	20 hrs	14 days	16 hrs	14 days
Intershield 9L	-	-	24 hrs	7 days	24 hrs	7 days	24 hrs	7 days
Interthane 990	-	-	16 hrs	7 days	10 hrs	5 days	4 hrs	3 days
Interthane 990HS	-	-	16 hrs	7 days	10 hrs	5 days	4 hrs	3 days

Note * Consult your International Paint representative for specific recommendations on minimum overcoating times at -5°C.
Times listed above are for low temperature recoating situations of Intergard 264. Stated drying times are for FCA321 converter only. For ambient temperature application information with FPA327 converter see Intergard 264 Temperate data sheet.

REGULATORY DATA

VOC 194 g/lt as supplied (EPA Method 24)

Note: VOC values are typical and are provided for guidance purposes only. These may be subject to variation depending on factors such as differences in colour and normal manufacturing tolerances.

SYSTEMS AND COMPATIBILITY

Consult your International Paint representative for the system best suited for the surfaces to be protected.
If overcoating Intergard 264 with antifoulings, the first coat of antifouling must be applied while the Intergard 264 is soft to thumbprint or slightly tacky.
When using in cargo holds, consult the Intergard 264 Cargo Hold Application Guidelines.

SURFACE PREPARATIONS

Use in accordance with the standard Worldwide Marine Specifications.
All surfaces to be coated should be clean, dry and free from contamination.
High pressure fresh water wash or fresh water wash, as appropriate, and remove all oil or grease, soluble contaminants and other foreign matter in accordance with SSPC-SP1 solvent cleaning.

NEWBUILDING
Dependent on yard procedures. Consult International Paint.

MAJOR REFURBISHMENT
Steel:
For optimum performance "Near White Blast Cleaning" (SSPC-SP10) is recommended.
"Commercial Blast Cleaning" (SSPC-SP6) is acceptable in many areas. Consult your International Paint representative for specific recommendations.
If oxidation has occurred between blasting and application of Intergard 264, the surface should be reblasted to the specified standard.

Previously Painted Surfaces
"Power Tool Clean" (SSPC-SP3 or SP11, as specified) or "Commercial Blast" (SSPC-SP6) bare areas of steel.
Hydroblasting to International Paint HB2M standard for non-immersed areas and HB2L for immersed areas is also acceptable.

Apply one or more spot coats of Intergard 264, as specified.

RECOATING:
When maximum recoat times have been exceeded, wash surface with International 950 Cleaner as recommended and rinse thoroughly. After 90 days more extensive surface preparation may be required.

NOTE
For use in Marine situations outside North America, the following surface preparation standards can be used:
Sa2 (ISO 8501-1:2007) in place of SSPC-SP6
Sa2½ (ISO 8501-1:2007) in place of SSPC-SP10

APPLICATION	Apply by conventional or airless spray. Application by other methods, brush or roller may require more than one coat and is suggested for small areas only of stripe coating. Strain material through a minimum 60 mesh screen before application. Apply at 160 microns wet which will yield 127 microns dry film thickness. Consult the following equipment recommendations or utilize suitable equal.
Mixing	Material is supplied in 2 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.
Thinner	DO NOT THIN BEYOND YOUR STATE'S COMPLIANCY. Material is supplied at spray viscosity and normally does not need thinning. If thinning is necessary, thin up to a maximum of 4 ounces/gal. (118 ml) with International GTA220 Thinner.
Airless Spray	Minimum 30:1 ratio pump; 0.019"- 0.027" (483-686 microns) orifice tip; 3/8" (9.5 mm) ID high pressure material hose; 60 mesh tip filter
Conventional Spray	DeVilbiss MBC-510 gun E tip and 704 air cap; 3/8" (9.5 mm) ID material hose; double regulated pressure tank with oil and moisture separator.
Brush	Use appropriate size China bristle brush.
Roller	Use All Purpose Roller cover with 3/8" (9.5 mm) smooth to medium nap. Prewash roller cover to remove loose fibres prior to use.
Work Stoppages and Cleanup	Clean all equipment immediately after use with International GTA220. Spray equipment requires flushing with this solvent. It is good working practice to periodically flush out spray equipment during the course of the working day. Frequency will depend upon factors such as amount sprayed, temperature and elapsed time including work stoppages. Monitor material condition. Do not exceed pot life limitations. All surplus materials and empty containers should be disposed of in accordance with appropriate regional regulations/legislation.
Welding	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. In North America do so in accordance with instruction in ANSI/ASC Z49.1 "Safety in Welding and Cutting."

SAFETY

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.

Prior to use, obtain, consult and follow the Material Safety Data Sheet for this product concerning health and safety information. Read and follow all precautionary notices on the Material Safety Data Sheet and container labels. If you do not fully understand these warnings and instructions or if you can not strictly comply with them, do not use this product. Proper ventilation and protective measures must be provided during application and drying to keep solvent vapour concentrations within safe limits and to protect against toxic or oxygen deficient hazards. Take precautions to avoid skin and eye contact (ie. gloves, goggles, face masks, barrier creams etc.) Actual safety measures are dependant on application methods and work environment.
EMERGENCY CONTACT NUMBERS:
USA/Canada - Medical Advisory Number 1-800-854-6813
Europe - Contact (44) 191 4696111. For advice to Doctors & Hospitals only contact (44) 207 6359191
R.O.W. - Contact Regional Office

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LIMITATIONS

Apply in good weather when air and surface temperatures are above -5°C. Surface temperatures must be at least 3° C above dew point. Unmixed material (in closed containers) should be held in protected storage between 4-38°C. Care should be taken at temperatures close to freezing that surfaces are free from ice.
Reaction with ultraviolet light may cause color variations when the product is used as a cosmetic finish coat. Overcoating information is given for guidance only and is subject to regional variation depending upon local climate and environmental conditions. Consult your local International Paint representative for specific recommendations. Technical and application data herein is for the purpose of establishing a general guideline of the coating and proper coating application guidelines. Test performance results were obtained in a controlled laboratory environment and International Paint makes no claim that the exhibited published test results, or any other tests, accurately represent results actually found in all field environments. As application, environmental and design factors can vary significantly, due care should be exercised in the selection, verification of performance and use of the coating.

UNIT SIZE

Unit Size	Part A		Part B	
	Vol	Pack	Vol	Pack
1 US gal	0.8 US gal	1 US gal	0.2 US gal	1 US quart
5 US gal	4 US gal	5 US gal	1 US gal	1 US gal

UNIT SHIPPING WEIGHT (TYPICAL)

Unit Size	Unit Weight
1 US gal	14.3 lb
5 US gal	70 lb

STORAGE

Shelf Life: 18 months minimum from date of manufacture when maintained in protected storage af 4-38° C.
Subject to reinspection thereafter. Store in dry, shaded conditions away from sources of heat and ignition.

WORLDWIDE AVAILABILITY

Consult International Paint.

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 data sheet or otherwise) is correct to the best of our knowledge but we have no 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 development. It is the user's responsibility to check with their local representative that this data sheet is current prior to using the product.

This Technical Data Sheet is available on our website at www.international-marine.com or www.international-pc.com, and should be the same as this document. Should there be any discrepancies between this document and the version of the Technical Data Sheet that appears on the website, then the version on the website will take precedence.

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