

Sealer Aluminium

PRODUCT DESCRIPTION

A two component epoxy sealer coat pigmented with aluminium flake.

INTENDED USES

For the effective penetration and sealing of thermally sprayed aluminium coatings to eliminate porosity.

PRACTICAL INFORMATION FOR INTERGARD 214

Colour	Aluminium
Gloss Level	Not applicable
Volume Solids	30%
Typical Thickness	15-25 microns (0.6-1 mils) dry equivalent to 50-83 microns (2-3.3 mils) wet
Theoretical Coverage	12 m ² /litre at 25 microns d.f.t and stated volume solids 481 sq.ft/US gallon at 1 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	
			Minimum	Maximum
5°C (41°F)	45 minutes	5 hours	6 hours	Extended ¹
15°C (59°F)	30 minutes	3 hours	3 hours	Extended ¹
25°C (77°F)	20 minutes	2 hours	2 hours	Extended ¹
40°C (104°F)	15 minutes	1 hour	1 hour	Extended ¹

¹ See International Protective Coatings Definitions and Abbreviations

REGULATORY DATA

Flash Point (Typical)	Part A 27°C (81°F); Part B 33°C (91°F); Mixed 32°C (90°F)		
Product Weight	0.98 kg/l (8.2 lb/gal)		
VOC	619 g/kg	EU Solvent Emissions Directive (Council Directive 1999/13/EC)	
See Product Characteristics section for further details			

Protective Coatings

Sealer Aluminium

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.

Thermally Sprayed Metal Coatings

Application of Intergard 214 should be undertaken within the recommended overcoating limits for metal spray. Normally, application of the sealer should take place within 4 hours of the final application of metal spray. The surface to be coated should be clean, dry and free from contamination before application of Intergard 214.

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	2 part(s) : 3 part(s) by volume			
Working Pot Life	5°C (41°F) 16 hours	15°C (59°F) 10 hours	25°C (77°F) 5 hours	40°C (104°F) 3 hours
Airless Spray	Suitable (See Product Characteristics)	Tip Range 0.33-0.38 mm (13-15 thou) Total output fluid pressure at spray tip not less than 141 kg/cm ² (2005 p.s.i.)		
Air Spray (Pressure Pot)	Suitable (See Product Characteristics)	Gun Air Cap Fluid Tip	DeVilbiss MBC or JGA 704 or 765 E	
Air Spray (Conventional)	Recommended	Use suitable proprietary equipment		
Brush	Recommended			
Roller	Recommended			
Thinner	International GTA220	Do not thin more than allowed by local environmental legislation		
Cleaner	International GTA822			
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.			

Sealer Aluminium

PRODUCT CHARACTERISTICS

Intergard 214 is designed to seal porosity in aluminium metal spray. When applying by brush, work the sealer thoroughly into the surface of the aluminium metal spray.

When application is by spray rather than by brush, careful inspection will be needed to ensure thorough sealing of the aluminium metal spray. Any runs, sags or pooling on horizontal surfaces should be brushed out immediately.

Best results will be achieved at temperatures above 0°C (32°F).

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

In common with all epoxies, Intergard 214 will chalk when exposed to weathering but this will not reduce efficiency in sealing metal spray.

Level of sheen and surface finish are dependent on application method. Avoid using a mixture of application methods whenever possible.

Intergard 214 is not suitable for exposure to acid or alkaline environments.

This product has the following specification approvals:

- UK Department of Transport Item No.159

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.

SYSTEMS COMPATIBILITY

Intergard 214 can be overcoated with a wide range of products, including:

Intercure 200
Intercure 200HS
Intercure 324
Intercure 384
Intergard 475HS
Interseal 670HS
Interzone 505

For other suitable topcoats, consult International Protective Coatings.

Sealer Aluminium

ADDITIONAL INFORMATION

Further information regarding industry standards, terms and abbreviations used in this data sheet can be found in the following documents available at www.international-pc.com:

- 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	Unit Size	Part A		Part B	
		Vol	Pack	Vol	Pack
	5 litre	2 litre	5 litre	3 litre	3.7 litre
For availability of other pack sizes, contact International Protective Coatings.					
SHIPPING WEIGHT (TYPICAL)	Unit Size	Part A		Part B	
	5 litre	2.7 kg		3.2 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.			

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.

Issue date: 05/02/2015

Copyright © AkzoNobel, 05/02/2015.

All trademarks mentioned in this publication are owned by, or licensed to, the AkzoNobel group of companies.

www.international-pc.com