

## Epoxy

### PRODUCT DESCRIPTION

A two pack epoxy zinc phosphate primer, primarily formulated to meet the requirements of the UK Highways Agency specification.

### INTENDED USES

Intergard 307 is intended to be used as a primer or blast primer under high build epoxy coating schemes for new construction.

### PRACTICAL INFORMATION FOR INTERGARD 307

<b>Colour</b>	Bamboo			
<b>Gloss Level</b>	Matt			
<b>Volume Solids</b>	43%			
<b>Typical Thickness</b>	25-40 microns (1-1.6 mils) dry equivalent to 58-93 microns (2.3-3.7 mils) wet			
<b>Theoretical Coverage</b>	17.20 m <sup>2</sup> /litre at 25 microns d.f.t and stated volume solids 690 sq.ft/US gallon at 1 mils d.f.t and stated volume solids			
<b>Practical Coverage</b>	Allow appropriate loss factors			
<b>Method of Application</b>	Airless Spray			
<b>Drying Time</b>	Overcoating Interval with recommended topcoats			
<b>Temperature</b>	<b>Touch Dry</b>	<b>Hard Dry</b>	<i>Minimum</i>	<i>Maximum</i>
5°C (41°F)	90 minutes	5 hours	30 hours	Extended <sup>1</sup>
10°C (50°F)	60 minutes	4 hours	24 hours	Extended <sup>1</sup>
20°C (68°F)	30 minutes	2 hours	16 hours	Extended <sup>1</sup>
30°C (86°F)	15 minutes	1 hour	12 hours	Extended <sup>1</sup>

<sup>1</sup> See International Protective Coatings Definitions and Abbreviations

### REGULATORY DATA

<b>Flash Point (Typical)</b>	Part A 23°C (73°F); Part B 23°C (73°F); Mixed 23°C (73°F)	
<b>Product Weight</b>	1.40 kg/l (11.7 lb/gal)	
<b>VOC</b>	351 g/kg	EU Solvent Emissions Directive (Council Directive 1999/13/EC)

See Product Characteristics section for further details

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### SURFACE PREPARATION

All surfaces to be coated should be clean, dry and free from contamination. Prior to paint application, all steel 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.

#### Steel Substrates

Abrasive blast clean to Sa2½ (ISO 8501-1:2007) or SSPC-SP6. If oxidation has occurred between blasting and application of Intergard 307, 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.

### APPLICATION

<b>Mixing</b>	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.			
	<ol style="list-style-type: none"> <li>(1) Agitate Base (Part A) with a power agitator.</li> <li>(2) Agitate Curing Agent (Part B) with a power agitator.</li> <li>(3) Combine entire contents of Curing Agent (Part B) with Base (Part A) and mix thoroughly with power agitator.</li> </ol>			
<b>Mix Ratio</b>	3 part(s) : 1 part(s) by volume			
<b>Working Pot Life</b>	5°C (41°F) 8 hours	10°C (50°F) 8 hours	20°C (68°F) 8 hours	30°C (86°F) 6 hours
<b>Airless Spray</b>	Recommended	Tip Range 0.38-0.48 mm (15-19 thou) Total output fluid pressure at spray tip not less than 176 kg/cm <sup>2</sup> (2503 p.s.i.)		
<b>Brush</b>	Suitable - small areas only			
<b>Thinner</b>	International GTA220			
<b>Cleaner</b>	International GTA822	N.B Clean all equipment immediately after use.		
<b>Work Stoppages</b>	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.			
<b>Clean Up</b>	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 307 is intended for use as a thin film epoxy primer, or blast primer, as part of approved UK Highways Agency and Network Rail protective schemes, typically under high build epoxy glass flake coatings.

Excessive film thickness may lead to splitting of the film when overcoated with high build systems.

This product contains a high proportion of zinc phosphate, to comply with the requirements of the Highways Agency.

Surface temperature must always be a minimum of 3°C (5°F) above dew point. This product will not cure adequately below 5°C (41°F). Ensure adequate ventilation is provided throughout application and curing.

In common with all epoxies Intergard 307 will chalk and discolour on exterior exposure. However, these phenomena are not detrimental to anti-corrosive performance.

Intergard 307 is not suitable as a primer for systems designed for permanent water immersion.

This product has the following specification approvals:

UK Highways Agency Item No. 110

UK Network Rail Systems N2, M21

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

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The following topcoats/intermediates are recommended for Intergard 307:

Intercure 324  
Interzone 505

For other suitable topcoats, 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 documents available at [www.international-pc.com](http://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	3.75 litre	5 litre	1.25 litre	1.5 litre
For availability of other pack sizes, contact International Protective Coatings.					
SHIPPING WEIGHT (TYPICAL)	Unit Size	Part A		Part B	
		6.39 kg		1.26 kg	
	5 litre				
STORAGE	Shelf Life	18 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](http://www.international-marine.com) or [www.international-pc.com](http://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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