

PRODUCT DESCRIPTION

A two component, low HAPS, low VOC, high solids, fast curing epoxy primer/finish.

INTENDED USES

Suitable for use as a one or two coat primer/finish, Intergard 774 provides a combination of barrier protection, mild chemical fume and spillage resistance along with good abrasion resistance.

Ideal for use in moderately corrosive environments and where fast drying/rapid recoating is desired.

Formulated to meet the demands of the rail industry. Ideal for new and repainting in rail.

Intergard 774 can also be used as a lining for service in cars transporting carbon black. Please refer to Product Characteristics for details.

PRACTICAL INFORMATION FOR INTERGARD 774

Colour	Black, Grey, White. Special colours upon request
Gloss Level	High Gloss
Volume Solids	80% (± 2%)
Typical Thickness	100-150 microns (4-6 mils) dry equivalent to 125-188 microns (5-7.5 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, Brush, Plural Feed Airless Spray
Drying Time	

Temperature	Touch Dry	Hard Dry	Overcoating Interval with recommended topcoats	
			<i>Minimum</i>	<i>Maximum</i>
10°C (50°F)	8 hours	20 hours	12 hours	Extended ¹
15°C (59°F)	5 hours	12 hours	5 hours	Extended ¹
25°C (77°F)	3.5 hours	6 hours	3.5 hours	Extended ¹
40°C (104°F)	50 minutes	2 hours	1 hour	Extended ¹

¹ See International Protective Coatings Definitions and Abbreviations

See Product Characteristics section for further details

REGULATORY DATA

Flash Point	Part A 35°C (95°F); Part B 60°C (140°F); Mixed 41°C (106°F)	
Product Weight	1.4 kg/l (11.7 lb/gal)	
VOC	1.61 lb/gal (194 g/l)	USA - EPA Method 24

See Product Characteristics section for further details

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.

Abrasive Blast Cleaning

Abrasive blast clean to Sa2½ (ISO 8501-1:2007) or SSPC-SP6. If oxidation has occurred between blasting and application of Intergard 774, 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.

Intergard 774 is suitable for application to blast cleaned surfaces which were initially to the above standard but have been allowed to deteriorate under good shop conditions for up to 7-10 days. The surface may deteriorate to Sa2 standard but must be free from loose powdery deposits.

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 part(s) : 1 part(s) by volume			
Working Pot Life	10°C (50°F)	15°C (59°F)	25°C (77°F)	35°C (95°F)
	2 hours	90 minutes	60 minutes	30 minutes
Airless Spray	Recommended	Tip Range 0.43-0.53 mm (17-21 thou) Total output fluid pressure at spray tip not less than 197 kg/cm ² (2801 p.s.i.) Maximum recommended thinning 5% with GTA220 for single feed airless applications (WFT 188-225 microns; 7.5-9 mils)		
Air Spray (Pressure Pot)	Recommended	Gun DeVilbiss MBC or JGA Air Cap 704 or 765 Fluid Tip E		
Brush	Suitable - small areas only	Typically 75-100 microns (3.0-4.0 mils) can be achieved		
Roller	Suitable - small areas only	Typically 75-100 microns (3.0-4.0 mils) can be achieved		
Thinner	International GTA220 or International GTA415	Do not thin more than allowed by local environmental legislation		
Cleaner	International GTA220 or International GTA415			
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 recommences 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.

**PRODUCT
CHARACTERISTICS**

Maximum film build in one coat is best attained by airless spray (single or plural component). Low or high temperatures may require specific application techniques to achieve maximum film build.

This product will not cure adequately below 10°C (50°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.

When applying Intergard 774 in confined spaces ensure adequate ventilation.

Condensation occurring during or immediately after application may result in a matt finish and an inferior film.

In common with all epoxies Intergard 774 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 utilised as a lining for carbon black service, the proper Intergard 774 order number code is EEA045 and the appropriate dry film thickness for service is increased to a range of 150-250 microns (6-10 mils).

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.

Low molecular weight reactive additives, which will form part of the film during normal ambient cure conditions, will also affect VOC values determined using EPA Method 24.

**SYSTEMS
COMPATIBILITY**

Intergard 774 is normally applied directly to blast cleaned steel, however, it can also be applied directly over itself and other epoxy primers.

For other suitable primers/topcoats consult International Protective Coatings.

Decal time:
16°C (60°F) 24 hours
25°C (77°F) 9 hours
52°C (125°F) 1 hour

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 US gal	4 US gal	5 US gal	1 US gal	1 US gal
For availability of other pack sizes, contact International Protective Coatings.					
SHIPPING WEIGHT	Unit Size	Part A		Part B	
	5 US gal	50 lb		8.6 lb	
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 International Paint 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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