Intergard® 276

Epoxy

PRODUCT DESCRIPTION

A quick drying two component epoxy primer.

Suitable for overcoating after prolonged periods of weathering.

INTENDED USES

As a blast holding primer suitable for use in immersed and exposed conditions and overcoatable with a wide range of high performance systems.

For use at both new construction and maintenance.

Also for use as a tie coat on zinc silicate to prevent zinc salt formation on weathering and pinholing of subsequent high build topcoats.

PRACTICAL INFORMATION FOR INTERGARD 276

Colour	White, Grey
Gloss Level	Matt
Volume Solids	47%
Typical Thickness	25-40 microns (1-1.6 mils) dry equivalent to 53-85 microns (2.1-3.4 mils) wet
Theoretical Coverage	11.80 m²/litre at 40 microns d.f.t and stated volume solids 471 sq.ft/US gallon at 1.6 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**	*Minimum*	*Maximum*
5°C (41°F)	45 minutes	24 hours	24 hours	Extended[1]
10°C (50°F)	40 minutes	20 hours	15 hours	Extended[1]
25°C (77°F)	30 minutes	12 hours	6 hours	Extended[1]
35°C (95°F)	20 minutes	12 hours	6 hours	Extended[1]

[1] See International Protective Coatings Definitions and Abbreviations

REGULATORY DATA

Flash Point (Typical)	Part A 23°C (73°F); Part B 26°C (79°F); Mixed 23°C (73°F)	
Product Weight	1.53 kg/l (12.8 lb/gal)	
VOC	293 g/kg	EU Solvent Emissions Directive (Council Directive 2010/75/EU)

Coating hazard marker GB 30981.2-S-Pb≤1000-NC Qualified for GB 30981.2-2025

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 8504:2019.

Oil or grease should be removed in accordance with SSPC-SP1 solvent cleaning.

Abrasive Blast Cleaning

For immersion service, Intergard 276 must be applied to surfaces blast cleaned to Sa2½ (ISO 8501 -1:2007) or SSPC-SP10. However, for atmospheric exposure Intergard 276 may be applied to surfaces prepared to a minimum of Sa2½ (ISO 8501-1:2007) or SSPC-SP6.

Surface defects revealed by the blast cleaning process should be ground, filled, or treated in the appropriate manner.

Ultra High Pressure Hydroblasting / (non-immersed service only)

May be applied to surfaces prepared to Sa2 (ISO 8501-1:2007) or SSPC-SP6 which have flash rusted to no worse than Grade HB2M (refer to International Hydroblasting Standards). Further information is available from International Protective Coatings.

Tie Coat Applications (see Product Characteristics)

In the case of zinc primers, where necessary, remove weld spatter, smooth weld seams and sharp edges and blast clean welds and damaged primer to Sa2½ (ISO 8501-1:2007) or SSPC-SP6. The shop primer or other primer surface should be dry and free of all contamination (oil, grease, salt etc) and overcoated with Intergard 276 within the overcoating intervals specified for the primer (consult the relevant product data sheet).

Ensure that the zinc primer has fully cured and is clean, dry and free from zinc salts prior to 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

4 part(s) : 1 part(s) by volume

Working Pot Life

5°C (41°F)	10°C (50°F)	25°C (77°F)	35°C (95°F)
20 hours	16 hours	8 hours	3 hours

Airless Spray	Recommended	Tip Range 0.38-0.53 mm (15-21 thou) Total output fluid pressure at spray tip not less than 176 kg/cm² (2503 p.s.i.)	
Air Spray (Pressure Pot)	Recommended	Gun Air Cap Fluid Tip	DeVilbiss MBC or JGA 704 or 765 E
Brush	Suitable - small areas only	Typically 25-30 microns (1.0-1.2 mils) can be achieved	
Roller	Suitable - small areas only	Typically 25-30 microns (1.0-1.2 mils) can be achieved	
Thinner	International GTA220 (or GTA415)	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.

PRODUCT CHARACTERISTICS

Use as a Holding Primer

Intergard 276 is suitable for use as a blast holding primer for steelwork intended for exposure in both immersed and atmospheric exposure conditions. Apply Intergard 276 at the recommended thickness as over-application will result in a glossy surface which may not be suitable for overcoating after ageing.

When coating steel in high ambient temperatures thinning with International thinners may be necessary to prevent dry spray and control film thickness.

This product will not cure adequately below 5°C (41°F). For maximum performance ambient curing temperatures should be above 10°C (50°F).

Intergard 276 is also suitable for application to degreased and abraded stainless steel and galvanised steel. Abrasion can be carried out by light blasting using a non-ferrous abrasive or by carbarondum disking on small areas.

Use as a Tie Coat

To ensure good penetration of zinc silicate coatings Intergard 276 should be thinned by 15-25% with International thinners. Intergard 276 should be allowed to cure before topcoating with high builds otherwise the effectiveness in preventing pinholing is reduced.

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

For application at temperatures below 10°C (50°F) alternative tie coats are available. For information contact International Protective Coatings.

When used in a marine environment the schemes and overcoating intervals utilised may differ.

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 276 is suitable for use over the following primers:

Interzinc 22
Interzinc 52

The following topcoats/intermediates are recommended for Intergard 276:

Intercure 200HS
Intercure 420
Interfine 629HS
Interfine 878
Interfine 979
Intergard 251
Intergard 345
Intergard 475HS
Intergard 740
Interseal 670HS
Interthane 870
Interthane 990
Interzone 505
Interzone 954
Interzone 1000

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 Safety Data Sheet and the container(s), and should not be used without reference to the Safety Data Sheet (SDS).

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 AkzoNobel for further advice.

PACK SIZE

Unit Size	Part A		Part B	
	Vol	Pack	Vol	Pack
20 litre	16 litre	20 litre	4 litre	5 litre

For availability of other pack sizes, contact AkzoNobel.

SHIPPING WEIGHT (TYPICAL)

Unit Size	Part A	Part B
20 litre	28.9 kg	4.1 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.

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