Intergard® 400

Epoxy

PRODUCT DESCRIPTION

A high build, two component epoxy, pigmented with lamellar micaceous iron oxide for enhanced corrosion resistance and improved overcoating properties after ageing.

INTENDED USES

As a corrosion resistant high build primer/intermediate or finish coat, to provide excellent barrier protection as part of a high performance system in aggressive environments including offshore structures, bridges, chemical and petrochemical plants, and power stations.

The incorporation of plate-like micaceous iron oxide pigment both increases the barrier effect and improves long term overcoating properties of the system, making this material ideally suitable for application in the fabrication shop, prior to shipping, with final overcoating at site.

Ideally suited as a damage and handling resistant coating which can be factory applied and then overcoated on site with minimum surface preparation.

Suitable for use in both new construction and industrial maintenance situations.

PRACTICAL INFORMATION FOR INTERGARD 400

Colour	Dark Grey, Silver Grey, Light Grey
Gloss Level	Matt
Volume Solids	65%
Typical Thickness	100-150 microns (4-6 mils) dry equivalent to 154-231 microns (6.2-9.2 mils) wet
Theoretical Coverage	5.20 m²/litre at 125 microns d.f.t and stated volume solids 209 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, Air Spray, Brush, Roller

Drying Time

			Overcoating Interval with recommended topcoats	
Temperature	**Touch Dry**	**Hard Dry**	*Minimum*	*Maximum*
10°C (50°F)	6 hours	24 hours	24 hours	Extended[1]
15°C (59°F)	4 hours	16 hours	20 hours	Extended[1]
25°C (77°F)	2 hours	8 hours	12 hours	Extended[1]
40°C (104°F)	1 hour	5 hours	8 hours	Extended[1]

[1] See International Protective Coatings Definitions and Abbreviations

REGULATORY DATA

Flash Point (Typical)	Part A 23°C (73°F); Part B 23°C (73°F); Mixed 25°C (77°F)	
Product Weight	1.68 kg/l (14.0 lb/gal)	
VOC	2.56 lb/gal (307 g/lt)	EPA Method 24
	221 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

Abrasive blast clean to Sa2½ (ISO 8501-1:2007) or SSPC-SP6. If oxidation has occurred between blasting and application of Intergard 400, 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.

Shop Primed Surfaces

Weld seams and damaged areas should be blast cleaned to Sa2½ (ISO 8501-1:2007) or SSPC-SP6.

If the shop primer shows extensive or widely scattered breakdown overall sweep blasting may be necessary.

Metallic Zinc Primed Surfaces

Ensure that the surface of the primer is clean, dry and free from contamination and zinc salts before application of Intergard 400. Ensure zinc primers are fully cured before 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

5.67 part(s) : 1.00 part(s) by volume

Working Pot Life

10°C (50°F)	15°C (59°F)	25°C (77°F)	40°C (104°F)
8 hours	5 hours	3 hours	2 hours

Airless Spray	Recommended	Tip Range 0.48-0.63 mm (19-25 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 50-75 microns (2.0-3.0 mils) can be achieved	
Roller	Suitable - small areas only	Typically 50-75 microns (2.0-3.0 mils) can be achieved	
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.

PRODUCT CHARACTERISTICS

This product will not cure adequately below 5°C (41°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.

In common with all epoxies Intergard 400 will chalk and discolour on exterior exposure. However, these phenomena are not detrimental to anti-corrosive performance.The actual rate of chalking will depend on climatic conditions and will normally be limited to a thin surface layer.

Products with high micaceous iron oxide levels tend to produce films which are relatively dark colours, consequently with some colours of thin film finishes two coats may be needed to give good coverage, especially with brush and roller application.

This product is frequently used as a 'travel coat' prior to final overcoating on site. To ensure best extended overcoating properties ensure over-application does not occur and that the surface is fully cleaned of any contamination which may be present in the surface texture due to the coarse nature of the micaceous iron oxide pigmentation.

Aged overcoating is achieved due to the physical roughness imparted to the surface by the micaceous iron oxide. Over-application of Intergard 400 can result in a glossy resin rich surface layer which may require abrasion before satisfactory adhesion and overcoating can be achieved.

Absolute measured adhesion of topcoats to aged Intergard 400 is less than that to fresh material, however, it is adequate for the specified end use.

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

On consultation with International Protective Coatings this product is compatible with alternative application methods such as flow coating.

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

The following primers are recommended for Intergard 400:

Intercure 200	Interzinc 42
Intergard 251	Interzinc 52
Intergard 269	Interzinc 72
Interzinc 22*	Interzinc 315

(mist or tie coat recommended)*

Suitable topcoats are:

Intergard 400	Interseal 670HS
Intergard 410	Interthane 990
Intergard 475HS	Interthane 990E
Intergard 740	

For other suitable primers/topcoats, consult International Protective Coatings.

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	17 litre	20 litre	3 litre	5 litre
	For availability of other pack sizes, contact AkzoNobel.				

SHIPPING WEIGHT (TYPICAL)	Unit Size	Part A	Part B
	20 litre	32.8 kg	3.3 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.

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