Intergard® 563

International

Epoxy

PRODUCT DESCRIPTION

A high solids, high build, two component epoxy primer, intermediate or finish, not containing low molecular weight epoxy resins.

INTENDED USES

Designed as a factory or site applied coating for steel in an aggressive industrial or coastal environment.

Can also be applied to aluminium and stainless steel.

PRACTICAL INFORMATION FOR INTERGARD 563

Colour	Green, Grey, White
Gloss Level	Eggshell
Volume Solids	61%
Typical Thickness	100 microns (4 mils) dry equivalent to 164 microns (6.6 mils) wet
Theoretical Coverage	6.10 m²/litre at 100 microns d.f.t and stated volume solids 245 sq.ft/US gallon at 4 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	16 hours	Extended[1]
25°C (77°F)	2 hours	5 hours	5 hours	Extended[1]
40°C (104°F)	1 hour	2 hours	2 hours	Extended[1]

[1] See International Protective Coatings Definitions and Abbreviations

REGULATORY DATA

Flash Point (Typical)	Part A 27°C (81°F); Part B 23°C (73°F); Mixed 23°C (73°F)	
Product Weight	1.6 kg/l (13.4 lb/gal)	
VOC	266 g/kg	EU Solvent Emissions Directive (Council Directive 2010/75/EU)
	342 g/lt	Chinese National Standard GB23985

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 563, 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.

Primed Surfaces
Intergard 563 should always be applied over a recommended anti-corrosive coating scheme. The primer surface should be dry and free from all contamination and Intergard 563 must be applied within the overcoating intervals specified (consult the relevant product data sheet).

Areas of breakdown, damage etc., should be prepared to the specified standard (e.g. Sa2½ (ISO 8501-1:2007) or SSPC-SP6, Abrasive Blasting, or SSPC-SP11, Power Tool Cleaning) and patch primed prior to the application of Intergard 563.

Shop Primed Steelwork
Intergard 563 is suitable for application to steelwork freshly coated with zinc silicate shop primers.

If the zinc shop primer shows extensive or widely scattered breakdown, or excessive zinc corrosion products, overall sweep blasting will be necessary. Other types of shop primer are not suitable for overcoating and will require complete removal by abrasive blast cleaning.

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

Non-Ferrous Surfaces
Degrease according to SSPC-SP1 solvent cleaning, and ensure surface is clean, dry and free from metal corrosion products.

When substrate is aluminium or light alloy, the surface should be solvent cleaned according to SSPC-SP1 and then either etched chemically, or physically by light blast cleaning. When light blast cleaning is employed, a low air pressure should be used with a fine grade of abrasive (80 mesh) and gun held 1 metre from the surface. It is important to follow application of Intergard 563 with a paint system appropriate to the painting of aluminium.

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

Working Pot Life

10°C (50°F)	15°C (59°F)	25°C (77°F)	40°C (104°F)
16 hours	16 hours	8 hours	2 hours

Airless Spray
Recommended
Tip Range 0.43-0.53 mm (17-21 thou)
Total output fluid pressure at spray tip not less than 176 kg/cm² (2503 p.s.i.)

Air Spray (Pressure Pot)
Recommended

Gun	DeVilbiss MBC or JGA
Air Cap	704 or 765
Fluid Tip	E

Brush
Suitable - small areas only
Typically 50-60 microns (2.0-2.4 mils) can be achieved

Roller
Suitable - small areas only
Typically 50-60 microns (2.0-2.4 mils) can be achieved

Thinner
International GTA220
Thinning is not normally required. Consult the local representative for advice during application in extreme conditions. 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

Maximum film build in one coat is best attained by airless spray. When applying by methods other than airless spray, the required film build is unlikely to be achieved. Application by air spray may require a multiple cross spray pattern to attain maximum film build. Low or high temperatures may require specific application techniques to achieve maximum film build.

When applying Intergard 563 by brush or roller, it may be necessary to apply multiple coats to achieve the total specified system dry 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).

In common with all epoxies Intergard 563 will chalk and discolour on exterior exposure. However, these phenomena are not detrimental to anti-corrosive performance.

Intergard 563 is not designed for continuous water immersion.

Absolute measured adhesion of topcoats to aged Intergard 563 is less than that to fresh material, however, it is adequate for the specified end use.

Where a durable cosmetic finish with good gloss and colour retention is required overcoat with recommended topcoats.

This product has the following specification approvals:
- SIS 185201

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 563:

Intergard 251
Intergard 269
Intergard 562
Interplate 11
Interplate 398

The following topcoats are recommended for Intergard 563:

Intergard 410
Intergard 563
Intergard 740
Interthane 990

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	16.67 litre	20 litre	3.33 litre	5 litre
5 litre	4.17 litre	5 litre	0.83 litre	1 litre

For availability of other pack sizes, contact AkzoNobel.

SHIPPING WEIGHT (TYPICAL)

Unit Size	Part A	Part B
20 litre	28.7 kg	3.6 kg
5 litre	7.2 kg	0.9 kg

STORAGE

Shelf Life	24 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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