Intergard® 1251

Epoxy

PRODUCT DESCRIPTION

A two component epoxy zinc phosphate / micaceous iron oxide primer.

INTENDED USES

For use on properly prepared surfaces in both new construction situations and as an industrial maintenance primer for a wide range of anti-corrosive coatings systems for use in the offshore, petrochemical, chemical, pulp and paper and bridge industries.

The fast drying and handling properties, together with extended overcoatability, make this an excellent primer for factory application prior to full system application on site. Intergard 1251 provides good abrasion resistance which minimises mechanical damage in transit between the factory and site.

PRACTICAL INFORMATION FOR INTERGARD 1251

Colour	Red Oxide, Grey
Gloss Level	Matt
Volume Solids	63%
Typical Thickness	75-100 microns (3-4 mils) dry equivalent to 119-159 microns (4.8-6.4 mils) wet
Theoretical Coverage	8.40 m²/litre at 75 microns d.f.t and stated volume solids 337 sq.ft/US gallon at 3 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)	30 minutes	8 hours	6 hours	Extended[1]
10°C (50°F)	30 minutes	4 hours	3 hours	Extended[1]
25°C (77°F)	25 minutes	135 minutes	1.5 hours	Extended[1]
40°C (104°F)	20 minutes	55 minutes	55 minutes	Extended[1]

[1] See International Protective Coatings Definitions and Abbreviations

Maximum overcoating intervals are shorter when using polysiloxane topcoats. Consult International Protective Coatings for further details.

REGULATORY DATA

Flash Point (Typical)	Part A 27°C (81°F); Part B 28°C (82°F); Mixed 27°C (81°F)	
Product Weight	1.53 kg/l (12.8 lb/gal)	
VOC	232 g/kg	EU Solvent Emissions Directive (Council Directive 1999/13/EC)

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 Grit Blast Cleaning
Abrasive grit blast clean to Sa2½ (ISO 8501-1:2007) or SSPC-SP6. If oxidation has occurred between blasting and application of Intergard 1251, 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.

A sharp, angular surface profile of 50-75 microns (2-3 mils) is recommended.

Shop Primed Steel
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.

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

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

Working Pot Life

5°C (41°F)	10°C (50°F)	25°C (77°F)	40°C (104°F)
6 hours	3 hours	2 hours	45 minutes

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 50-75 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 GTA220	

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

When applying Intergard 1251 by brush or roller, it may be necessary to apply multiple coats to achieve the total specified system dry film thickness.

The maximum overcoating interval will be dependent upon the integrity of the exposed film. A film of 75 microns (3 mils) dry film thickness will normally be overcoatable after 6 months exposure provided it is adequately cleaned and any areas of mechanical damage repaired.

Over-application should be avoided as thick films will not be as good a substrate for topcoat adhesion after ageing as those at the specified thickness. Over-application of Intergard 1251 will also extend both the minimum overcoating periods and handling times.

Surface temperature must always be a minimum of 3°C (5°F) above dew point.

Intergard 1251 is capable of curing at temperatures below 0°C (32°F). However, this product should not be applied at temperatures below 0°C (32°F) where there is a possibility of ice formation on the substrate.

This product must only be thinned using recommended International thinners. The use of alternative thinners, particularly those containing ketones, can severely inhibit the curing mechanism of the coating.

Intergard 1251 is not intended for use as a primer for steelwork which may be subjected to immersion conditions.

In common with all epoxies Intergard 1251 will chalk and discolour on exterior exposure. However, these phenomena are not detrimental to anti-corrosive performance.

SYSTEMS COMPATIBILITY

Intergard 1251 will normally be applied to suitably prepared steel, e.g. blast cleaned. However, if necessary, application over prefabrication blast primers can be performed. Consult International Protective Coatings for further details.

The following topcoats/intermediates are recommended for Intergard 1251:

Intercure 200HS
Intercure 420
Interfine 629HS
Interfine 691
Intergard 410
Intergard 475HS
Interseal 670HS
Interthane 990

For other suitable topcoats/intermediates, 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 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
	20 litre	15 litre	20 litre	5 litre	5 litre
	For availability of other pack sizes, contact International Protective Coatings.				
SHIPPING WEIGHT (TYPICAL)	Unit Size	Part A		Part B	
	20 litre	27.58 kg		5.25 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

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