Spray2Fix Intergard 10301SC

Technical Data Sheet

Product Group

High solids epoxy primer

Characteristics

Product Information

- Aerosol Spray Can Application Intergard 10301
- This two-component high solids epoxy primer is fast drying and has enhanced corrosion performance on ferrous and nonferrous metals. It is lead, chromate and HAPS free.

Specifications

Qualified Product List

US Military	MIL-DTL-53022E, Type V

For most recent up-date or missing specifications please check the qualified product list (QPL) on **www.akzonobel.com/aerospace**

Surface Conditions

Cleaning

Surface pretreatment is an essential part of the painting process.

Cold-rolled SAE1010 Steel → Zinc Phosphate coating (TT-C-490 Type I)
Bare 2024-T3 Aluminum Alloy → Alodine-5900 (MIL-DTL-5541 Type II)

Follow surface pretreatment process per MIL-DTL-53072D for Ferrous and Non-ferrous substrates.

Instruction for Use

Activate

To Activate	Remove the red button from the over cap and attach to the plastic pin at the bottom of the aerosol. Place aerosol upright on a flat surface and push down to break the inner seal.
Activation Test	Remove red button from the bottom of the aerosol and push plastic pin with thumb, the pin should now move easily.
Mixing	Turn can upside down. Shake the aerosol vigorously for 2-3 minutes after activation to thoroughly mix catalyst.

AkzoNobel Aerospace Coatings
1 East Water Street, Waukegan, IL 60085, USA - Phone (847) 623 4200, Fax (847) 625 3200
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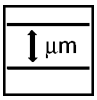
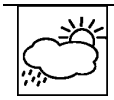
 Induction Time	30 minutes Prior to application, invert can and spray until a color is visible to clear the nozzle.
 Pot life (25ºC/77ºF)	8 hours at 77°F (25°C), and 50 ± 5% RH
 Dry Film Thickness (DFT)	33 – 43 micron (µm) 1.5 ± 0.2 mils

Application Recommendations

 Conditions	Temperature: Relative Humidity:	15 – 35°C 59 – 95°F 35 – 75%
 Note	The quality of the application of all coatings will be influenced by the spray equipment chosen and the temperature, humidity, and air flow of the paint application area. When applying the product for the first time, it is recommended that test panels be prepared in order to identify the best equipment settings to be used in optimizing the performance and appearance of the coating.	
 Application method	After activation and induction, spray in a normal fashion. You will note that the delivery of material is faster than a normal aerosol, and that the fan is larger. Both features are designed to make the application similar to that of a spray gun.	
 Number of coats	Spray uniform wet coats to recommended dry film thickness.	

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Cleaning nozzle	After use, invert can and spray until clear to clear the nozzle. If aerosol is left standing, shake vigorously prior to each use.

Physical Properties

Drying Times (25 +/- 2ºC / 77 +/- 2ºF, 55 +/- 5% RH)	Set to touch: 1 Hour Dry hard: 3 Hours Dry through/Dry to tape: 4 Hours Dry to topcoat: 3 Hours Recoat window: 48 Hours maximum
Theoretical Coverage 400 ml	**400 ml - Can size:** 336 grams, 11.9 oz 3.63 m^2 per aerosol can at 25.4 micron dry film thickness 39.4 ft^2 per aerosol can at 1.0 mil dry film thickness
Theoretical Coverage 250 ml	**250 ml - Can size:** 252 grams, 8.9 oz 2.70 m^2 per aerosol can at 25.4 micron dry film thickness 29.2 ft^2 per aerosol can at 1.0 mil dry film thickness
Dry Film Weight	1.74 g/m^2/micron 0.0090 lbs/ft^2/mil
VOC not applicable to aerosols. Alternative regulations based on reactivity method of calculating emissions	**Regulation for Reducing the Ozone Formed from Aerosol Coating Product Emissions by California Air Resources Board (CARB):** Aviation Primer Product-Weighted MIR Limit: 1.2 g O_3/g — Complies **National Volatile Organic Compound Emission Standards for Aerosol Coatings, EPA:** Aviation Primer Product-Weighted Reactivity Limit: 1.2 g O_3/g — Complies
Color	Light Gray

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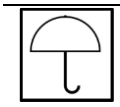
 Flash-point	-41ºC / -41.8ºF
 Storage	Store the product dry and at a temperature between 5 and 35ºC / 40 and 95ºF per AkzoNobel Aerospace Coatings specification. Store in the original unopened containers. Storage temperature may vary per OEM specification requirements. Refer to container label for specific storage life information.
Shelf life 5 - 38°C (40 - 100°F)	24 months per AkzoNobel Aerospace Coatings commercial specification. Shelf life may vary due to OEM specification requirements. Refer to container label for specific shelf life information.
Safety Precautions	Comply with all local safety, disposal and transportation regulations. Check the Material Safety Data Sheet (MSDS) and label of the individual products carefully before using the products. The MSDS's are available on request.

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