

INERTA 165 GF

Epoxy coating

INERTA 165 GF is a 2-component glass flake containing coating based on epoxy resin with excellent corrosion protection and mechanical resistance. The product has a very low solvent content and its adhesion on steel is excellent.



INERTA 165 GF works well on objects immersed in water or buried in ground, e.g. sluice gates, pipelines of hydropower plants. Specially recommended to places where high wear or abrasion is expected such as splash-zones of offshore constructions in the wind industry and oil & gas industry and other structures exposed to sand, stones, ice etc.

INERTA 165 GF can be applied directly on metal surfaces with 500 – 1000 µm DFT in one layer.

Coating system INERTA 165 GF, 2 x 500 µm DFT comes up to the requirements of standard Norsok M-501:2022 (Edition 7) system 7A (report NO250425) and ISO 24 656, category V.

TECHNICAL DATA

Certificates, approvals and classification	NORSOK M-501
Fields of application	Steel constructions
Recommended substrate	Steel
Binder	Epoxy
Solids	Approx. 92% by volume
Total mass of solids	Approx. 1210 g/l
Volatile organic compound (VOC)	Approx. 75 g/l (DIRECTIVE 2010/75/EU) The VOC value provided is the average value for factory produced products, and consequently it will be subject to variations between individual products covered by this Technical Data Sheet.

Theoretical spreading rate

Dry film (µm)	Wet film (µm)	Theoretical spreading rate (m ² /l)
500	550	1.8
600	660	1.5
800	880	1.2
1000	1100	0.9

As many of the paint's properties will change if too thick coats are applied, it is not recommended that the product is applied to a film thickness that is more than 2000 µm DFT in single layer. This will also lead to solvent entrapment.

Practical spreading rate	The values depend on the application technique, surface conditions, overspray, etc.
Colours	Light grey. Other colours by agreement.
Gloss (60°)	Gloss
Hardener	Comp. B: INERTA 165-02 HARDENER
Mixing ratio (A:B)	2:1 parts by volume
Pot life, +23 °C	30 min.
Thinner	TEKNOSOLV 9514
Storage	The storage stability is shown on the label. Store in a cool place and in tightly closed containers.

DIRECTION FOR USE

Surface preparation	<p>Remove from the surfaces any contaminants that might be detrimental to surface preparation and application. Remove also water-soluble salts by using appropriate methods. The surfaces are prepared according to the different materials as follows:</p> <p>STEEL SURFACES: Remove mill scale and rust by blast cleaning to preparation grade Sa 2½ (standard ISO 8501-1). Roughening the surface of thin-plate improves the adhesion of the paint to the substrate.</p> <p>OLD PAINTED SURFACES SUITABLE FOR OVERCOATING: Any impurities that might be detrimental to the application of paint (e.g. grease and salts) are removed. The surfaces must be dry and clean. Old, painted surfaces that have exceeded the maximum overcoating time are to be roughened as well. Damaged parts are prepared in accordance with the requirements of the substrate and the maintenance coating. Severely pitted steel can be stopped up with INERTA 160 FILL, which is applied by twin-feed airless spray and smoothed immediately with a steel trowel (width 20 - 30 cm).</p> <p>The place and time of the preparation are to be chosen so that the prepared surface will not get dirty or damp before the subsequent treatment.</p> <p>Additional instructive information for surface preparation can be found in standards EN ISO 12944-4 and ISO 8501-2.</p> <p>Prefabrication primer: All prefabrication primer coats must be completely removed regardless of the binder type. In practice this means that when the surface is viewed vertically from a distance of 1 meter and in normal lighting conditions the surface is of an evenly grey colour, i.e. the preparation grade is Sa 2½ (ISO 8501-1).</p>
Application method	Airless spraying

Application

MIXING OF THE COMPONENTS: Take into consideration the pot life of the mixture when estimating the amount to be mixed at a time. Before application the base and hardener are mixed in right proportion. Stir thoroughly down to the bottom of the vessel. Mixing by machine is recommended, for example a slow-rotating hand-drill equipped with a mixer. Inadequate stirring or incorrect mixing ratio results in imperfect curing and impaired film properties. **THE READY MIXTURE MUST BE USED WITHIN THE POT LIFE, MIXTURES OLDER THAN THIS ARE UNFIT FOR USE.**

Apply with airless spray with great pressure ratio (over 250 bar tip pressure recommended to achieve adequate atomization). Use either one-component airless spray or hot twin-feed spray, e.g., Graco King or Graco Hydra-Cat. Remove possible filters from the gun before applying. For one component airless, if the equipment has a hopper, be sure to flush/remove all remnants of the previous mixture from it before pouring in a new mixture to avoid seizing the equipment due to end of pot life.

Suitable airless nozzle size (turn-nozzle) 0.026 - 0.035".

Brush or roller can be used for touching up. Take the pot life of the paint into consideration while painting. **WARNING!** The amount and the temperature of the mixture will affect the pot life. The spray equipment will be damaged if the paint is let to cure inside it. Directions given by the manufacturer of the twin-feed spray are to be followed when working.

Application conditions

The surface to be treated must be dry. During the application and drying period the temperature of the ambient air, the surface and the product shall be above +5°C and the relative air humidity below 80%. Temperature of the product during component mixing and application shall be above +15°C. The optimal temperature for the product before application is +20°C - +40°C. The temperature of the surface to be treated must be at least +3°C above the dew point of the ambient air.

