

INERTA 270

Epoxy paint

INERTA 270 is a two-pack epoxy paint with low solvent content.

Used in Epoxy Coating System K81 on the insides of steel tanks and basins, e.g. storage tanks of paper, pulp and chemical industry as well as sewage treatment plants.



Withstands aqueous solutions of most chemicals, heating oil, diesel oil, unleaded petrol, jet fuel as well as several solvents.



TECHNICAL DATA

Fields of application	Storage tank											
Recommended substrate	Steel											
Binder	Epoxy											
Solids	75±2% by volume (ISO 3233)											
Total mass of solids	Approx. 1300 g/l											
Volatile organic compound (VOC)	Approx. 200 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	<table border="1"><thead><tr><th>Dry film (µm)</th><th>Wet film (µm)</th><th>Theoretical spreading rate (m²/l)</th></tr></thead><tbody><tr><td>150</td><td>200</td><td>5.0</td></tr><tr><td>250</td><td>333</td><td>3.0</td></tr></tbody></table>	Dry film (µm)	Wet film (µm)	Theoretical spreading rate (m ² /l)	150	200	5.0	250	333	3.0	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 double of the thickest recommended film.	
Dry film (µm)	Wet film (µm)	Theoretical spreading rate (m ² /l)										
150	200	5.0										
250	333	3.0										
Practical spreading rate	The values depend on the application technique, surface conditions, overspray, etc.											
Colours	TO-010 white, TO-320 sandy, TO-860 light grey NOTE! Sunlight and chemicals cause the colour and glossiness to change in time.											
Gloss (60°)	Gloss											
Hardener	Comp. B: INERTA HARDENER 7272											
Mixing ratio (A:B)	10:3 parts by volume											
Pot life, +23 °C	1,5 h											
Thinner	TEKNOSOLV 9506											

Storage

The storage stability is shown on the label. Store in a cool place and in tightly closed containers.

DIRECTION FOR USE**Surface preparation**

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:

STEEL SURFACES: Remove mill scale and rust by blast cleaning to preparation grade Sa 2½ (standard ISO 8501-1). The profile of the blast-cleaned surface must be at least coarse (reference comparator "G"). See standard ISO 8503-2 (G).

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.

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.

Before or after the first coat all dents and holes on the surface are to be filled with TEKNOPOX FILL epoxy putty.

Additional instructive information for surface preparation can be found in standards EN ISO 12944-4 and ISO 8501-2.

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).

Application method

Airless spraying

Application

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. After mixing the ingredients, wait 15 minutes before using.

Apply preferably by airless spray as only this method provides the recommended film thickness in a single operation. Suitable airless nozzle size 0.018 - 0.026". Brush can be used for touching up and painting small areas.

Application conditions

The surface to be painted must be dry and the relative air humidity below 85%. During the application and drying period the temperature of the ambient air and the surface shall be above +10°C, and the temperature of the paint above +15°C during mixing and spraying. The temperature of the surface and the paint must be at least 3°C above the dew point of the ambient air.

Drying time

+23°C / 50% RH

- dust free

6 h

- touch dry

7 h

- fully cured

7 d

Overcoatable

Surface temperature	By itself	
	Min.	Max.*
+10°C	after 24 h	after 4 days
+23°C	after 12 h	after 2 days

* Maximum overcoating interval without roughening.

Increase in film thickness and rise in the relative humidity of the air in the drying space usually slow down the drying process.

Cleaning

TEKNOSOLV 9506 or TEKNOSOLV 9530

HEALTH AND SAFETY

Safety and precaution measures

See safety data sheet.

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