

INERTA 300

Epoxy phenol novolac paint

INERTA 300 is a two-pack epoxy phenol novolac paint with low solvent content.

Used for epoxy coating systems 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 as well as oil products. Withstands high temperatures, even 200°C dry heat. Epoxy coatings are prone to chalking and "yellowing" on exterior exposure. This affects the aesthetics of the coating, not its protective performance. Elevated temperatures may also lead to colour changes especially in lighter shades.



TECHNICAL DATA

Recommended substrate	Steel, Concrete											
Binder	Epoxy phenol novolac											
Solids	65 ±2% by volume (ISO 3233:1988)											
Total mass of solids	Approx. 1280 g/l											
Volatile organic compound (VOC)	Approx. 330 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>80</td><td>123</td><td>8.1</td></tr><tr><td>150</td><td>230</td><td>4.3</td></tr></tbody></table>	Dry film (µm)	Wet film (µm)	Theoretical spreading rate (m ² /l)	80	123	8.1	150	230	4.3		
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	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.											
Practical spreading rate	The values depend on the application technique, surface conditions, overspray, etc.											
Colours	Red, grey, black and white.											
Gloss (60°)	Matt											
Hardener	Comp. B: INERTA 300 HARDENER											
Mixing ratio (A:B)	5:1 parts by volume											
Pot life, +23°C	2 h											
Thinner	TEKNOSOLV 9506											
Storage	The storage stability is shown on the label. Must be stored tightly closed and kept cool.											

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).

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.

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).

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

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.

Stir thoroughly before use.

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 treated has to be dry. During the application and drying period the temperature of the ambient air, the surface and the product shall be above +10°C and the relative air humidity below 80%. Additionally, the temperature of the surface to be treated and the product must be at least +3°C above the dew point of the ambient air.

Drying time	+23°C / 50% RH (dry film 80 µm)				
- dust free	1 h (ISO 9117-3:2010)				
- touch dry	3 h (ISO 9117-5:2012)				
- fully cured	7 d				
Overcoatable	surface	by itself		with TEKNOPLAST 50	
	temperature	min.	max.*	min.	max.*
	+10°C	10 h	14 d	10 h	14 d
	+23°C	4 h	14 d	4 h	14 d

* 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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