

**INERTA 205**
Epoxy Coating

PAINT TYPE	INERTA 205 is a two-pack, solvent-free epoxy coating based on liquid epoxy resin.
USAGE	Used on steel and concrete surfaces.
SPECIAL PROPERTIES	INERTA 205 has good adhesion to blast-cleaned steel (grade Sa 2½), to aluminium and concrete. It has excellent abrasion resistance. The coating has good resistance to water, chemical solutions, grease and certain solvents even on immersion. In water immersion the temperature must not be over +40°C. For other chemicals the highest temperature allowed is defined individually.

TECHNICAL DATA

Mixing ratio	Base (Comp. A): Hardener (Comp B): INERTA 205 HARDENER	2 parts by volume 1 part by volume	
Pot life, +23 °C	30 - 40 min		
Solids	abt. 100 % by volume		
Total mass of solids	abt. 1500 g/l		
Volatile organic compound (VOC)	abt. 0 g/l		
Recommended film thickness and theoretical spreading rate	Dry film (µm)	Wet film (µm)	Theoretical spreading rate (m ² /l)
	125	125	8,0
	200	200	5,0

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.

Practical spreading rate The values depend on the application technique, surface conditions, overspray, etc.

Drying time, +23°C / 50% RH (dry film 125 µm)

- dust free (ISO 9117-3:2010) after 6 h

Overcoatable, 50% RH (dry film 125 µm)

surface temperature	by itself	
	min.	max.*
+15°C	after 10 h	after 36 h
+23°C	after 6 h	after 24 h

* 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.

Clean up TEKNOSOLV 9506

Finish Gloss

Colours White

SAFETY MARKINGS See Safety Data Sheet.

PTO

DIRECTION FOR USE**Surface preparation**

Remove from the surfaces any contaminants that might be detrimental to surface preparation and painting. 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 (ISO 8501-1). The profile of the blast-cleaned surface must be at least coarse (reference comparator "G"). See standard ISO 8503-2 (G).

CONCRETE SURFACES: The concrete must be at least 4 weeks old, well-hardened and solid. The water content of the top layer must not exceed 4% by weight.

Smooth down any spatter and irregularities on the surfaces by grinding. Brush away loose cement, sand and dust. Wash oily and greasy surfaces with detergent or solvent. Remove dense laitance if present by etching with RENSA ETCHING etching liquid or by grinding or blast-cleaning.

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.

Stopping, smoothing

Big cavities in the concrete are repaired with cement mortar immediately after the removal of moulds. Before the paint is applied, all holes are to be filled. If necessary, the whole surface is stopped up with water-borne TEKNOPOX AQUA V FILL Epoxy Stopper or with TEKNOPOX FILL Epoxy Stopper.

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).

Mixing of the components

Take into consideration the pot life of the mixture when estimating the amount to be mixed at a time. Before painting the base and hardener are mixed in right proportion. Stir thoroughly down to the bottom of the vessel. Inadequate stirring or incorrect mixing ratio results in imperfect curing and impaired film properties.

Application conditions

The surface to be painted must be dry. During the application and drying period the temperature of the ambient air, the surface and the paint shall be above +10°C and the relative air humidity below 80%.

Additionally during the application and the drying period the temperature of the coating and the surface to be coated shall be at least 3°C above of the dew point of the air.

Application

Apply with airless spray. Suitable nozzle size is 0.018 - 0.021". Brush or roller can be used for touching up. Note the pot life of the paint at the application.

ADDITIONAL INFORMATION

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

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

The information of this data sheet is normative and based on laboratory tests and practical experience. Teknos guarantees that the product quality conforms to our quality system. Teknos accepts, however, no liability for the actual application work, as this is to a great extent dependent on the conditions during handling and application. Teknos accepts no liability for any damage resulting from misapplication of the product. This product is intended for professional use only. This implies that the user possesses sufficient knowledge for using the product correctly with regard to technical and working safety aspects. The latest versions of Teknos data sheets, material safety data sheets and system sheets are on our home pages www.teknos.com.



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