

DATA SHEET 190 10 08.12.2017	INERTA 160 FILL Epoxy Coating			
PRODUCT TYPE	INERTA 160 FILL is a two-pack epoxy coating that is almost free of solvent, based on liquid epoxy resin.			
USAGE	To be used as a coating or stopper on subterranean and submerged steel surfaces e.g hull plating, on corrosivity classes Im1, Im2 and Im3 in coating system K31. Can also be used on concrete surfaces.			
SPECIAL PROPERTIES	INERTA 160 FILL has a good adhesion properties onto a blast-cleaned steel.			
TECHNICAL DATA				
Mixing ratio	Base (Comp. A): 2 parts by volume Hardener (Comp B): INERTA 160 FILL HARDENER 1 part by volume or INERTA 160-01 FILL HARDENER. Special hardener INERTA 160-01 FILL HARDENER with a different solvent composition			
Pot life, +23 °C	20 min			
Solids	96 ±2% by volume			
Total mass of solids	over 1400 g/l			
Volatile organic compound (VOC)	abt. 40 g/l			
Recommended film thickness and theoretical spreading rate	Dry film (µm)	Wet film (µm)	Theoretical s	spreading rate (m²/l)
	800 1000	833 1041		1,2 1,0
Drying time at +23°C / 50% RH - dust free, +23°C - touch dry, +23 °C - fully cured, +23°C Overcoatable	after 4 h after 8 h after 7 d			
	by itself or with INERTA 160]
	surface temperature	min.	max.*	
	+10°C	after 8 h	after 12 h	
	+23°C	after 4 h	after 12 h	
01	* Maximum overcoal Increase in film thick down the drying proc	ing interval without roughen mess and rise in the relative cess.	ing. humidity of the air in the dryir	ng space usually slow
Clean up	TEKNUSULV 9530	J		

Colours White, black, red and T-M 338. The Hardener is turquoise, so it will stand out in the Base if the components are not properly mixed. This has no essential effect on the colour of the paint.

SAFETY MARKINGS

See Safety Data Sheet.

РТО

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 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 coarse (reference comparator "G") 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 BETONI-PEITTAUSLIUOS Agent or by grinding or blast-cleaning.
	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.
Preliminary stopping	Deep corrosion pits (1 - 10 mm) are filled with putty prepared of INERTA 160 FILL epoxy coating and 0.1 - 0.6 mm sand. The quantity of sand can be between 1 - 2 parts by volume of INERTA 160 FILL epoxy coating.
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).
Application conditions	The surface to be treated must be dry. The temperature of the ambient air, the surface and the coating/stopper shall be above +10°C and the relative air humidity below 80% during the application and drying period.
Application method	INERTA 160 FILL is applied by a powerful hot twin-feed spray, that will obtain at least 200 bar nozzle pressure and is fitted with a heater. Turn-nozzle 0.021 - 0.026".
	The coating is kept at a temperature of +20 - +25°C before use so that they are fluid enough for the feed pumps. The mixing ratio of the dosage pump must be 2 : 1. The heating of the components shall be adjusted so that the temperature in the gun is +40 - +50 C. The pot life of the mixture is then 5 min. If required, also the hoses must be heated. The film thickness is controlled by a wet film gauge. Check the feed pump pressure and the consumption of the components to ensure correct mixing ratios. The operation of the mixing tube is controlled by watching the colour of a discharged coating. If the tube does not function correctly, stripes of a hardener are visible in the base. The operation of the mixing tube is controlled by watching the colour of a discharged stopper. If the tube does not function correctly, stripes of a hardener are visible in the base.
	When treating pitted surfaces, process levelling immediately after spraying with a wide trowel 20 - 30 cm.
	To fill the pores in concrete surfaces, a coat of 200 - 300 μ m is first sprayed and smoothed by brush or rubber spatula over porous areas.
	Directions given by the manufacturer of the twin-feed spray are to be followed when working.
	The components must be mixed and stirred thoroughly. Inadequate stirring or incorrect mixing ratio results in imperfect curing and impaired film properties.
ADDITIONAL INFORMATION	The storage stability is shown on the label. Store in a tightly closed containers. The best storage temperature is +10°C - +25°C.

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.

