

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 µm 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.

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