

INERTA 165 –EPOXY SYSTEM

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Coating systems for anti-corrosive painting on steel surfaces immersed in water. The system consists of chemically curing epoxy coating with low solvent content.

The coating system structure:	EP500/2- FeSa 2½
INERTA 165 epoxy paint	2 x 250 µm
Total film thickness	500 µm
Paint system VOC, g/m ²	54

Usage For steel surfaces of containers and pipelines immersed in water.

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 (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).

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.

For more detailed information about the above-mentioned products please see individual product data sheets.

Application

Stir the components until they are homogeneous before use. Mix base and hardener with each other in the proportions given on the paint labels and stir the mixture thoroughly. Take into consideration the pot life of the mixture when estimating the amount to be mixed.

Apply with airless spray with great pressure ratio. Use either one-component airless spray or hot twin-feed spray, e.g. Graco Hydra-Cat with turn-nozzle 0.021 - 0.026". Brush or roller can be used for touching up. Take the pot life of the paint into consideration while painting. **WARNING!** The amount and the temperature of the mixture will affect the pot life. The spray equipment will be damaged if the paint is let to cure inside it. Directions given by the manufacturer of the twin-feed spray are to be followed when working.

The technical data of the paint are given in the table below and in the product data sheet.

Maintenance

Touch-up: Surfaces with rust grades Ri 1 to Ri 3 can be repaired by touching up. Remove flaking paint and rust from damaged areas by scraping and blast-cleaning. Small damages can be prepared by discing. Feather the edges of prepared areas. Touch up the prepared patches with the paints of the system to the original film thickness.

If a uniform appearance is required, the whole surface should be cleaned by sweep-blasting or grinding. Thereafter the system's top coat can be applied.

Complete renewal: Surfaces with rust grade Ri 4 are to be repainted completely. Blast-clean the whole surface to grade Sa 2½ and paint from priming to top coat as for new work.

Technical data

Paint	INERTA 165	
Data Sheet	No.	155
Paint type	two-pack epoxy paint with low solvent content	
Colours	by agreement	
Finish	gloss	
Thinner	TEKNOSOLV 9506	
Methods of application	airless spray	
Airless spray nozzle	0.021 – 0.026"	
Application conditions		
- min. temperature	°C	+10
- max. relative humidity	%	80
Safety markings	See safety data sheet	
Volume solids	%	92 ±2
Total mass of solids	g/l	abt. 1300
Volatile organic compound (VOC)	g/l	abt. 100
Recommended film thickness		
- wet	µm	271
- dry	µm	250
Theoretical spreading rate	m ² /l	3.7
Drying time, +23°C / 50% RH	(dry film 250 µm)	
- dust free, (ISO 9117-3:2010)	after 6 h	
- touch dry, (ISO 9117-5:2012)	after 12 h	
Overcoatable, 50% RH	by itself:	
	min.	max.*
+10°C	after 10 h	after 2 d
+23°C	after 6 h	after 24 h

* Maximum overcoating interval without roughening.