Intertuf® 262

Surface Tolerant Epoxy

PRODUCT DESCRIPTION

A low VOC, two component corrosion inhibitive surface tolerant epoxy. Provides surface tolerant application and high build formulation. Can be utilised with an alternate converter for low temperature or fast recoat applications.

INTENDED USES

A corrosion resistant primer for structural steel and processing vessel exteriors with excellent water resistance. Exhibits excellent performance in industrial and marine environments subject to acids, alkalis, solvents, salts and other aggresive exposure.

PRACTICAL INFORMATION FOR INTERTUF 262

Colour	Black, Buff, Grey, Red, Off White
Gloss Level	Matt
Volume Solids	73%
Typical Thickness	100-175 microns (4-7 mils) dry equivalent to 137-240 microns (5.5-9.6 mils) wet
Theoretical Coverage	5.80 m²/litre at 125 microns d.f.t and stated volume solids 234 sq.ft/US gallon at 5 mils d.f.t and stated volume solids
Practical Coverage	Allow appropriate loss factors
Method of Application	Airless Spray, Air Spray, Brush, Roller

Drying Time

			Overcoating interval with self	
Temperature	**Touch Dry**	**Hard Dry**	*Minimum*	*Maximum*
10°C (50°F)	7 hours	29 hours	18 hours	28 days
15°C (59°F)	5 hours	26 hours	15 hours	28 days
25°C (77°F)	4 hours	9 hours	6 hours	28 days
35°C (95°F)	3 hours	5 hours	4 hours	15 days

*For curing at low temperatures an alternative curing agent is available. See Product Characteristics for details.

REGULATORY DATA

Flash Point (Typical)	Part A 28°C (82°F); Part B 34°C (93°F); Mixed 29°C (84°F)	
Product Weight	1.42 kg/l (11.8 lb/gal)	
VOC	1.91 lb/gal (229 g/lt)	EPA Method 24

See Product Characteristics section for further details

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SURFACE PREPARATION

The performance of this product will depend upon the degree of surface preparation. The surface to be coated must be clean and free from contamination. Prior to paint application all surfaces should be assessed and treated in accordance with ISO 8504:2000.

Accumulated dirt and soluble salts must be removed. Dry bristle brushing will normally be adequate for accumulated dirt. Soluble salts should be removed by fresh water washing.

Abrasive Blast Cleaning
For immersion service, Intertuf 262 must be applied to surfaces blast cleaned to Sa2½ (ISO 8501-1:2007) or SSPC-SP10. However, for atmospheric exposure Intertuf 262 may be applied to surfaces prepared to a minimum of Sa2½ (ISO 8501-1:2007) or SSPC-SP6.

Surface defects revealed by the blast cleaning process should be ground, filled, or treated in the appropriate manner.

A surface profile of 50-75 microns (2-3 mils) is recommended.

Hand or Power Tool Preparation
Hand or power tool clean to a minimum of St2 (ISO 8501-1:2007) or SSPC-SP2.

Note, all scale must be removed and areas which cannot be prepared adequately by chipping or needle gun should be spot blasted to a minimum standard of Sa2 (ISO 8501-1:2007) or SSPC-SP6. Typically this would apply to C or D grade rusting in this standard.

Ultra High Pressure Hydroblasting / Abrasive Wet Blasting
May be applied to surfaces prepared to Sa2 (ISO 8501-1:2007) or SSPC-SP6 which have flash rusted to no worse than Grade HB2M (refer to International Hydroblasting Standards). It is also possible to apply to damp surfaces in some circumstances. Further information is available from International Protective Coatings.

Aged Coatings
Intertuf 262 is suitable for overcoating a limited range of intact, tightly adherent aged coatings. Loose or flaking coatings should be removed back to a firm edge. Glossy finishes may require light abrasion to provide a physical 'key'. See Product Characteristics section for further information.

Intertuf 262 is suitable for application to steelwork freshly coated with zinc silicate shop primers. If the zinc shop primer shows extensive or widely scattered breakdown, or excessive zinc corrosion products, overall sweep blasting will be necessary. Other types of shop primer are not suitable for overcoating and will require complete removal by abrasive blast cleaning.
Weld seams and damaged areas should be blast cleaned to Sa2 (ISO 8501-1:2007) or SSPC-SP6.

In the case of zinc primers, where necessary, remove weld spatter, smooth weld seams and sharp edges and blast clean welds and damaged primer to Sa2 (ISO 8501-1:2007) or SSPC-SP6. The shop primer or other primer surface should be dry and free of all contamination (oil, grease, salt etc) and overcoated with Intertuf 262 within the overcoating intervals specified for the primer (consult the relevant product data sheet).

Ensure that the zinc primer has fully cured and is clean, dry and free from zinc salts prior to overcoating.

APPLICATION

Mixing

Material is supplied in two containers as a unit. Always mix a complete unit in the proportions supplied. Once the unit has been mixed it must be used within the working pot life specified.

(1) Agitate Base (Part A) with a power agitator.
(2) Combine entire contents of Curing Agent (Part B) with Base (Part A) and mix thoroughly with power agitator.

Mix Ratio

4.0 part(s) : 1.0 part(s) by volume

Working Pot Life

10°C (50°F)	15°C (59°F)	25°C (77°F)	35°C (95°F)
7 hours	6 hours	4 hours	2 hours

Airless Spray	Recommended	Tip Range 0.48-0.58 mm (19-23 thou) Total output fluid pressure at spray tip not less than 176 kg/cm² (2503 p.s.i.)	
Air Spray (Pressure Pot)	Recommended	Gun Air Cap Fluid Tip	DeVilbiss MBC or JGA 704 or 765 E
Brush	Suitable	Typically 3.0-4.0 mils (75-100 microns) can be achieved	
Roller	Suitable	Typically 3.0-4.0 mils (75-100 microns) can be achieved	
Thinner	International GTA220 (or GTA415)		
Cleaner	International GTA822 (or GTA415)	Choice of cleaner maybe subject to local legislation. Please consult your local representative for specific advice.	

Work Stoppages

Do not allow material to remain in hoses, gun or spray equipment. Thoroughly flush all equipment with International GTA220/GTA822 or GTA415. Once units of paint have been mixed they should not be resealed and it is advised that after prolonged stoppages work recommences with freshly mixed units.

Clean Up

Clean all equipment immediately after use with International GTA822 or International GTA415. It is good working practice to periodically flush out spray equipment during the course of the working day. Frequency should depend upon amount sprayed, temperature and elapsed time, including any delays.

PRODUCT CHARACTERISTICS

When applying Intertuf 262 by brush or roller, it may be necessary to apply multiple coats to achieve the total specified system dry film thickness.

Maximum film build in one coat is best attained by airless spray. When applying by methods other than airless spray, the required film build is unlikely to be achieved. Application by air spray may require a multiple cross spray pattern to attain maximum film build. Low or high temperatures may require specific application techniques to achieve maximum film build.

Surface temperature must always be a minimum of 3°C (5°F) above dew point. If applying Intertuf 262 in enclosed maintenance conditions ensure adequate ventilation.

In common with all epoxies Intertuf 262 will chalk and discolour on exterior exposure. However, these phenomena are not detrimental to anti-corrosive performance.

For water immersion service, surface preparation to a minimum of Sa2½ (ISO 8501-1:2007) or SSPC-SP10 followed by application of multi-coats of Intertuf 262 to a total minimum dry film thickness of 250 microns (10 mils) is required.

If salt water is used in the wet blast process the resulting surface must be thoroughly washed with fresh water before application of Intertuf 262. With freshly blasted surfaces a slight degree of flash rusting is allowable, and is preferable to the surface being too wet. Puddles, ponding and accumulations of water must be removed.

Intertuf 262 is suitable for overcoating intact, aged epoxy and polyurethane systems. However, this product is not recommended where thermoplastic coatings such as chlorinated rubbers and vinyls have previously been used. Please consult International Protective Coatings for alternative recommendations.

Level of sheen and surface finish are dependent on application method. Avoid using a mixture of application methods whenever possible. Premature exposure to ponding water will cause a colour change, especially in dark colours.

When used as part of an approved scheme, this material has the following certification:

- USDA approval for incidental food contact surface in federally inspected meat and poultry plants. Subject to Inspector-In-Charge approval.

Intertuf 262 meets Petrobras Standard N-2851.

Low molecular weight reactive additives, which will form part of the film during normal ambient cure conditions, will also affect VOC values determined using EPA Method 24.

Low Temperature Properties
When low temperature cure is required, use KHA414 Low Temperature Converter. Follow dry time and recoat parameters shown below.

Pot Life	-7°C (20°F)	5°C (41°F)	25°C (77°F)
	12 hours	8 hours	4 hours

Temperature	Touch Dry	Hard Dry	Overcoating Interval with self *Minimum*	*Maximum*
-7°C (20°F)	24 hours	96 hours	58 hours	3 months[1]
5°C (41°F)	10 hours	16 hours	20 hours	2 months[1]
25°C (77°F)	2 hours	8 hours	20 hours	28 days[1]

[1] Intervals given are for overcoating with self; for overcoating with epoxy / urethane finishes, consult International Protective Coatings for further details.

SYSTEMS COMPATIBILITY

Intertuf 262 will normally be applied to correctly prepared steel substrates.

Suitable primers are:

Intergard 251	Intergard 269
Interplus 256	Interplus 356

Where a cosmetically acceptable topcoat is required the following products are recommended:

Intergard 740	Interfine 629HS
Interthane 990	Interthane 990E

Other suitable primers/topcoats are available. Consult International Protective Coatings.

ADDITIONAL INFORMATION

Further information regarding industry standards, terms and abbreviations used in this data sheet can be found in the following documents available at www.international-pc.com:

- Definitions & Abbreviations
- Surface Preparation
- Paint Application
- Theoretical & Practical Coverage

Individual copies of these information sections are available upon request.

SAFETY PRECAUTIONS

This product is intended for use only by professional applicators in industrial situations in accordance with the advice given on this sheet, the Safety Data Sheet and the container(s), and should not be used without reference to the Safety Data Sheet (SDS).

All work involving the application and use of this product should be performed in compliance with all relevant national, Health, Safety & Environmental standards and regulations.

In the event welding or flame cutting is performed on metal coated with this product, dust and fumes will be emitted which will require the use of appropriate personal protective equipment and adequate local exhaust ventilation.

If in doubt regarding the suitability of use of this product, consult AkzoNobel for further advice.

PACK SIZE

Unit Size	Part A		Part B	
	Vol	Pack	Vol	Pack
1 US gal	0.8 US gal	1 US gal	0.2 US gal	1 US quart
5 US gal	4 US gal	5 US gal	1 US gal	1 US gal

For availability of other pack sizes, contact AkzoNobel.

SHIPPING WEIGHT (TYPICAL)

Unit Size	
1 US gal	12.5 lb
5 US gal	61 lb

STORAGE

Shelf Life	24 months minimum at 25°C (77°F). Subject to re-inspection thereafter. Store in dry, shaded conditions away from sources of heat and ignition.

Important Note

The information in this data sheet is not intended to be exhaustive; any person using the product for any purpose other than that specifically recommended in this data sheet without first obtaining written confirmation from us as to the suitability of the product for the intended purpose does so at their own risk. All advice given or statements made about the product (whether in this data sheet or otherwise) is correct to the best of our knowledge but we have no control over the quality or the condition of the substrate or the many factors affecting the use and application of the product. Therefore, unless we specifically agree in writing to do so, we do not accept any liability at all for the performance of the product or for (subject to the maximum extent permitted by law) any loss or damage arising out of the use of the product. We hereby disclaim any warranties or representations, express or implied, by operation of law or otherwise, including, without limitation, any implied warranty of merchantability or fitness for a particular purpose. All products supplied and technical advice given are subject to our Conditions of Sale. You should request a copy of this document and review it carefully. The information contained in this data sheet is liable to modification from time to time in the light of experience and our policy of continuous development. It is the user's responsibility to check with their local representative that this data sheet is current prior to using the product.

This Technical Data Sheet is available on our website at www.international-marine.com or www.international-pc.com, and should be the same as this document. Should there be any discrepancies between this document and the version of the Technical Data Sheet that appears on the website, then the version on the website will take precedence.

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