

Modified Epoxy

PRODUCT DESCRIPTION

A two component, high build, hydrocarbon modified epoxy meeting the requirements of the Swedish anti-corrosive standard SIS 185 205.

INTENDED USES

Designed for use in severely corrosive environments for both atmospheric exposure and water immersion. Typical areas of use are power plants, petrochemical plants, pulp and paper mills, and chemical production areas.

Intertuf 127 can also be used as a general purpose coating to improve appearance when applied on concrete floors.

PRACTICAL INFORMATION FOR INTERTUF 127

Colour	Range available via the Chromascan system
Gloss Level	Semi Gloss
Volume Solids	65% ± 3% (depends on colour)
Typical Thickness	75-125 microns (3-5 mils) dry equivalent to 115-192 microns (4.6-7.7 mils) wet
Theoretical Coverage	6.50 m ² /litre at 100 microns d.f.t and stated volume solids 261 sq.ft/US gallon at 4 mils d.f.t and stated volume solids
Practical Coverage	Allow appropriate loss factors
Method of Application	Airless Spray, Brush, Roller

Drying Time

Temperature	Touch Dry	Hard Dry	Overcoating Interval with recommended topcoats	
			Minimum	Maximum
10°C (50°F)	7 hours	12 hours	12 hours	Extended ¹
15°C (59°F)	6 hours	8 hours	8 hours	Extended ¹
25°C (77°F)	4 hours	6 hours	6 hours	Extended ¹
40°C (104°F)	2 hours	4 hours	4 hours	Extended ¹

¹ See International Protective Coatings Definitions and Abbreviations

REGULATORY DATA

Flash Point (Typical)	Part A 30°C (86°F); Part B 28°C (82°F); Mixed 29°C (84°F)		
Product Weight	1.30 kg/l (10.8 lb/gal)		
VOC	213 g/kg	EU Solvent Emissions Directive (Council Directive 1999/13/EC)	
See Product Characteristics section for further details			

Protective Coatings

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SURFACE PREPARATION

All surfaces to be coated should be clean, dry and free from contamination. Prior to paint application, all steel surfaces should be assessed and treated in accordance with ISO 8504:2000.

Oil or grease should be removed in accordance with SSPC-SP1 Solvent Cleaning.

Abrasive Blast Cleaning

Abrasive blast clean to Sa2½ (ISO 8501-1:2007) or SSPC-SP10. If oxidation has occurred between blasting and application of Intertuf 127, the surface should be reblasted to the specified visual standard. Surface defects revealed by the blast cleaning process should be ground, filled, or treated in the appropriate manner.

Primed Steelwork

Intertuf 127 can be applied over approved anti-corrosive primers. The primer surface should be dry and free from all contamination and Intertuf 127 must be applied within the overcoating intervals specified (consult the relevant product data sheet).

Areas of breakdown, damage etc., should be prepared to the specified standard (e.g. Sa2½ (ISO 8501-1:2007) or SSPC-SP6 Abrasive Blasting, or SSPC-SP11, Power Tool Cleaning) and patch primed prior to the application of Intertuf 127.

This product is NOT recommended over hand prepared steel.

Concrete Surfaces

Concrete should be cured for a minimum of 28 days prior to coating. The moisture content of the concrete should be below 6%. All surfaces should be clean, dry and free from curing compounds, release agents, trowelling compounds, surface hardeners, efflorescence, grease, oil, dirt, old coatings and loose or disintegrating concrete. All poured and precast concrete must also be sweep blasted (preferred) or acid etched to remove laitence.

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)	40°C (104°F)
	4 hours	3 hours	2 hours	1 hour
Airless Spray	Recommended	Tip Range 0.45-0.53 mm (18-21 thou) Total output fluid pressure at spray tip not less than 176 kg/cm ² (2503 p.s.i.)		
Air Spray (Pressure Pot)	Not recommended			
Brush	Suitable - small areas only	Typically 50-75 microns (2.0-3.0 mils) can be achieved		
Roller	Suitable - small areas only	Typically 50-75 microns (2.0-3.0 mils) can be achieved		
Thinner	International GTA220	Do not thin more than allowed by local environmental legislation		
Cleaner	International GTA220			
Work Stoppages	Do not allow material to remain in hoses, gun or spray equipment. Thoroughly flush all equipment with International GTA220. 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	Do not allow material to remain in hoses, gun or spray equipment. Release pressure from the material hose and flush fluid line and spray gun with International GTA220. Do not re-pressurise equipment until ready to resume spraying operations, and ensure pot life limitations are adhered to.			

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PRODUCT CHARACTERISTICS

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 127 to a total minimum dry film thickness of 250 microns (10 mils) is required.

This product is designed for application by airless spray. Application by other methods, e.g. brush, roller, may require more than one coat and should only be used for small areas or touch-up work.

Level of sheen and surface finish are dependent on application method. Avoid using a mixture of application methods whenever possible.

This product will not cure adequately below 5°C (41°F). For maximum performance ambient curing temperatures should be above 10°C (50°F).

In common with all epoxies Intertuf 127 will chalk and discolour on exterior exposure. However, these phenomena are not detrimental to anti-corrosive performance.

It should be noted that due to the polymer blend utilised in this product to give high anti-corrosive performance, it may not always be possible to produce accurate colour matches for all colour shades available from Chromascan. This is especially the case for pale and pastel shades.

This product has the following specification approvals:

- Swedish anti-corrosive standard SIS 185 205 for two pack modified epoxies

Note: VOC values are typical and are provided for guidance purpose only. These may be subject to variation depending on factors such as differences in colour and normal manufacturing tolerances.

SYSTEMS COMPATIBILITY

Intertuf 127 can be applied directly to blasted steel. However, it can also be applied over the following priming systems:

Intergard 242
Intergard 251
Intergard 269
Interplate 11
Interplate 398
Interzinc 42
Interzinc 52
Interzinc 72

The following topcoats are recommended for Intertuf 127:

Interfine 629HS
Intergard 400
Intergard 410
Intergard 740
Interthane 870
Interthane 990

For other suitable primers/topcoats consult International Protective Coatings.

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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 Material Safety Data Sheet and the container(s), and should not be used without reference to the Material Safety Data Sheet (MSDS) which International Protective Coatings has provided to its customers.

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 International Protective Coatings for further advice.

PACK SIZE	Unit Size	Part A		Part B	
		Vol	Pack	Vol	Pack
	20 litre	16 litre	20 litre	4 litre	5 litre
For availability of other pack sizes, contact International Protective Coatings.					
SHIPPING WEIGHT (TYPICAL)	Unit Size	Part A		Part B	
		24.3 kg		4.2 kg	
	20 litre				
STORAGE	Shelf Life	18 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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www.international-pc.com

SKE Beschichtungssysteme GmbH, Buchenring 11, D-21272 Egestorf,

Phone: +49 (0) 4175 / 808 99 31, Fax: +49 (0) 4175 / 808 99 32

Email: info@ske-beschichtungen.de, Website: www.ske-beschichtungen.de