

Intertuf® 262

Tar Free Epoxy



PRODUCT DESCRIPTION A low VOC, two component corrosion inhibitive surface tolerant epoxy. Provides flexibility, surface tolerant application and high build formulation. Can be utilized with alternate converter for low temperature. Suitable for permanent immersion services.

INTENDED USES A corrosion and abrasive resistant primer and finish for structural steel. Excellent water resistance. Exhibits excellent performance in industrial and marine environments subject to acids, alkalis, solvents, salts and chemical exposure.

PRACTICAL INFORMATION FOR INTERTUF 262

Color Black
Gloss Level Matt
Volume Solids 73% ±2% (ISO 3233:1998)
Typical Thickness 4.0-6.0 mils (100-150 microns) dry equivalent to 5.6-8.3 mils (139-208 microns) wet
Theoretical Coverage 231 sq.ft./US gallon at 5 mils d.f.t. and stated volume solids 5.8 m²/liter at 125 microns d.f.t. and stated volume solids
Practical Coverage Allow appropriate loss factors
Method of Application Airless spray, Air spray, Brush, Roller

Drying Times*

Temperature	Touch Dry	Hard Dry	Overcoating Intervals with recommended topcoats			
			Self		Interthane 990	
			Minimum	Maximum	Minimum	Maximum
50°F (10°C)	12 hours	28 hours	16 hours	3 months	16 hours	7 days
59°F (15°C)	8 hours	24 hours	11 hours	3 months	11 hours	5 days
77°F (25°C)	6 hours	18 hours	6 hours	2 months	6 hours	3 days
90°F (32°C)	4 hours	10 hours	4 hours	1 month	4 hours	2 days

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

REGULATORY DATA

Flash Point Base (Part A) 110°F (43°C) Curing Agent (Part B) 103°F (39°C) Mixed 103°F (39°C)

Product Weight 11.85 lb/gal (1.42 kg/l)

VOC 2.67 lb/gal (320 g/l) USA - EPA Method 24
 Maximum thinning for VOC compliance is color specific. Contact your International Representative for thinning and VOC information.
 See Product Characteristics section for further details



Ecotech is an initiative by International Protective Coatings, a world leader in coating technology, to promote the use of environmentally sensitive products

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SURFACE PREPARATION

The performance of this product will depend upon the degree of surface preparation. The surface to be coated should be clean, dry 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 SSPC-SP10 or Sa2.5 (ISO 8501-1:1988). However, for atmospheric exposure best performance will be achieved when Intertuf 262 is applied to surfaces prepared to a minimum of SSPC-SP6 or Sa2 (ISO 8501-1:1988). Surface defects revealed by the blast cleaning process should be ground, filled, or treated in the appropriate manner.

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

Hand or Power Tool Preparation

Hand or power tool clean to a minimum SSPC-SP2 or St2 (ISO 8501-1:1988).

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 SSPC-SP6 or Sa2 (ISO 8501-1:1988). 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 SSPC-SP6 or Sa2 (ISO 8501-1:1988) 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 8501-1:1988) 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 8501-1:1988) 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 data sheet).

Ensure 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 parts : 1 part by volume			
Working Pot Life	50°F (10°C) 12 hours	59°F (15°C) 10 hours	77°F (25°C) 8 hours	90°F (32°C) 5 hours
Airless Spray	Recommended	- Tip range 19-23 thou (0.48-0.58 mm) - Total output fluid pressure at spray tip not less than 2,500 p.s.i. (176 kg/cm ²)		
Air Spray (Pressure Pot)	Recommended	Gun Air Cap Fluid Tip	DeVilbiss MBC or JGA 704 or 765 E	
Brush	Recommended	Typically 3-4 mils (75-100 microns) can be achieved.		
Roller	Recommended	Typically 3-4 mils (75-100 microns) can be achieved.		
Thinner	International GTA220	Do not thin more than allowed by local environmental legislation.		
Cleaner	International GTA220 (or GTA822)			
Work Stoppages	Do not allow material to remain in hoses, gun or spray equipment. Thoroughly flush all equipment with International 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 GTA415. It is good working practice to periodically flush out spray equipment during the course of the working day. Frequency of cleaning will depend upon amount sprayed, temperature and elapsed time, including any delays.			
	All surplus materials and empty containers should be disposed of in accordance with appropriate regional regulations/legislation.			

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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 conventional air spray may require a multiple cross spray pattern to attain maximum film build. Lower or high temperatures may require specific application techniques to achieve maximum film build.

Surface temperature must always be a minimum of 5°F (3°C) above dew point.

If applying Intertuf 262 in enclosed maintenance conditions ensure adequate ventilation.

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

For water immersion service, surface preparation to a minimum of SSPC-SP10 or Sa2.5 (ISO 8501-1:1988) followed by application of multi-coats of Intertuf 262 to a total minimum dry film thickness of 10 mils (250 microns) 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 alkyd, epoxy and polyurethane systems. However, this product is not recommended where thermoplastic coatings such as chlorinated rubbers and vinyls have previously been used.

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

Premature exposure to ponding water will cause a color change, especially in dark colors.

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

- **USDA** - Accepted for incidental food contact surfaces in federally inspected meat and poultry plants. Subject to Inspector-in-charge approval.

Low Temperature Properties

When low temperature cure is required, use KHA414 Low Temperature Converter.

Follow dry time and recoat parameters shown below.

Pot Life	20°F (-7°C) 12 hours	41°F (5°C) 8 hours	77°F (25°C) 4 hours			
				Overcoating Interval with		
	Touch Dry	Hard Dry	Self Minimum	Maximum	Epoxy/Urethane Finishes Minimum Maximum	
Temperature						
20°F (-7°C)	24 hours	96 hours	58 hours	3 months	58 hours	---
41°F (5°C)	10 hours	16 hours	20 hours	2 months	20 hours	7 days
77°F (25°C)	2 hours	8 hours	20 hours	1 month	20 hours	3 days

MILSPEC

MIL-PRF-24647B, Type 1, C11A, GR A & B, Applications 1 & 2
MIL-PRF-23236B, Type IV, CL2, GR A & B

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

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.

SYSTEMS COMPATIBILITY

Intertuf 262 will normally be applied to correctly prepared steel substrates. However, it can be used over suitably primed surfaces. Suitable primers are:

Interplus 256	Interplus 356
Intergard 269	Intergard 251

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

Interthane 990	Intergard 740
Interfine 629HS	

Other suitable primers/topcoats are available. 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	1 gallon unit	Intertuf 262 Base	0.8 US gallon in a 1 gallon container
		Intertuf 262 Curing Agent	0.2 US gallon in a quart container
	5 gallon unit	Intertuf 262 Base	4 gallons in a 5 gallon container
		Intertuf 262 Curing Agent	1 gallon in a 1 gallon container
	For availability of other pack sizes contact International Protective Coatings		
SHIPPING WEIGHT	U.N. Shipping No. 1263		
	1 gallon unit	11.01 lbs (5 Kg) Base (Part A)	2.49 lbs (1.13 Kg) Curing Agent (Part B)
	5 gallon unit	61.0 lb (27.7 kg) Base (Part A)	12.5 lb (5.7 kg) Curing Agent (Part B)
STORAGE	Shelf Life	24 months minimum at 77°F (25°C). Subject to re-inspection thereafter. Store in dry, shaded conditions away from sources of heat and ignition.	

Important Note

The information given in this sheet is not intended to be exhaustive and any person using the product for any purpose other than that specifically recommended in this sheet without first obtaining written confirmation from us as to the suitability of the product for the intended purpose does so at his own risk. Any warranty, if given, or specific Terms & Conditions of Sale are contained in International's Terms & Conditions of Sale, a copy of which can be obtained on request. While we endeavor to ensure that all advice we give about the product (whether in this sheet or otherwise) is correct we have no control over either the quality or 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 whatsoever or howsoever arising for the performance of the product or for any loss or damage (other than death or personal injury resulting from our negligence) arising out of the use of the product. The information contained in this sheet is liable to modification from time to time in the light of experience and our policy of continuous product development.

It is the user's responsibility to check that this sheet is current prior to using the product. Issue date: 07/17/2006

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