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## Surface Tolerant Epoxy

### PRODUCT DESCRIPTION

A low VOC, two component internally flexibilised high build surface tolerant epoxy primer. Pigmented with aluminium and lamellar micaceous iron oxide for improved corrosion resistance.

This formulation represents second generation surface tolerant technology. The product has both application and performance characteristics optimised for use over a wider temperature range.

### INTENDED USES

A high performance industrial maintenance coating for use on a wide variety of surfaces including hand or power tool cleaned rusty steel.

Interplus 256 is particularly useful in the maintenance of offshore structures and other aggressive environments such as oil refineries, coastal structures, pulp and paper mills and bridges where dry abrasive blasting is not possible.

Ideal for use in conjunction with wet abrasive blasting or ultra high pressure water blasting, or as a patch primer for rusty surfaces in maintenance situations.

For use on hot surfaces continuously running at up to 150°C (302°F) and for corrosion protection under thermal insulation of carbon steel and stainless steel.

### PRACTICAL INFORMATION FOR INTERPLUS 256

<b>Colour</b>	Aluminium
<b>Gloss Level</b>	Eggshell
<b>Volume Solids</b>	80%
<b>Typical Thickness</b>	75-150 microns (3-6 mils) dry equivalent to 94-188 microns (3.8-7.5 mils) wet
<b>Theoretical Coverage</b>	6.40 m <sup>2</sup> /litre at 125 microns d.f.t and stated volume solids 257 sq.ft/US gallon at 5 mils d.f.t and stated volume solids
<b>Practical Coverage</b>	Allow appropriate loss factors
<b>Method of Application</b>	Airless Spray, Air Spray, Brush, Roller
<b>Drying Time</b>	

Temperature	Touch Dry	Hard Dry	Overcoating Interval with recommended topcoats	
			Minimum	Maximum
10°C (50°F)	12 hours	22 hours	22 hours	Extended <sup>1</sup>
15°C (59°F)	9 hours	16 hours	16 hours	Extended <sup>1</sup>
25°C (77°F)	5 hours	9 hours	9 hours	Extended <sup>1</sup>
40°C (104°F)	2 hours	6 hours	6 hours	Extended <sup>1</sup>

<sup>1</sup> See International Protective Coatings Definitions and Abbreviations

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

### REGULATORY DATA

<b>Flash Point (Typical)</b>	Part A 34°C (93°F); Part B 69°C (156°F); Mixed 39°C (102°F)		
<b>Product Weight</b>	1.39 kg/l (11.6 lb/gal)		
<b>VOC</b>	2.21 lb/gal (265 g/l)	USA - EPA Method 24	
	188 g/kg	EU Solvent Emissions Directive (Council Directive 1999/13/EC)	

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

Interplus 256 may be applied to a surface abrasive blast cleaned to a minimum Sa1 (ISO 8501-1:2007) C or D grade rusting, or SSPC SP7.

#### 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.

On hot steel surfaces, cleaning to a minimum St3 (ISO 8501-1:2007) or SSPC SP3 is required. Optimum performance will be achieved from SPPC-SP11 for hand preparation, or blasting to Sa2 (ISO 8501-1:2007) or SSPC-SP6.

#### 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

Interplus 256 is suitable for overlap onto most aged coating systems. Loose or flaking coatings should be removed back to a firm edge. Glossy epoxies and polyurethanes may require abrasion..

### 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	3.0 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)
	2 hours	90 minutes	60 minutes	30 minutes
For curing at elevated temperatures an alternative curing agent is available. See Product Characteristics for details.				
Airless Spray	Suitable	Tip Range 0.45-0.58 mm (18-23 thou) Total output fluid pressure at spray tip not less than 176 kg/cm² (2503 p.s.i.)		
Air Spray (Pressure Pot)	Suitable	Gun Air Cap Fluid Tip	DeVilbiss MBC or JGA 704 or 765 E	
Brush	Recommended	Typically 75-125 microns (3.0-5.0 mils) can be achieved		
Roller	Recommended	Typically 75-100 microns (3.0-4.0 mils) can be achieved		
Thinner	International GTA220	Do not thin more than allowed by local environmental legislation		
Cleaner	International GTA822 or International GTA415			
Work Stoppages	Do not allow material to remain in hoses, gun or spray equipment. Thoroughly flush all equipment with International GTA822. 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. 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

Interplus 256 is the preferred product for application to hand prepared rusty steel, and is particularly suitable as a patch primer. In these circumstances, application should be performed by brush to ensure good wetting of the hand prepared substrate. For larger areas which have been prepared by power tool cleaning, or brush blast, other products may be suitable. Please consult International Protective Coatings for details.

In order to ensure good anti-corrosive performance, it is important to achieve a minimum system dry film thickness of 200 microns (8 mils) by application of multi-coats over hand prepared steel.

When applying Interplus 256 by brush, it may be necessary to apply multiple coats to achieve the total specified system dry film thickness.

To ensure good aged overcoating of Interplus 256 by other materials the surface must be clean, dry and free from contamination, particularly if the surface profile is rough due to the presence of micaceous iron oxide.

Application and curing at temperatures below 10°C (50°F) will result in significantly prolonged curing times, and in these circumstances it is recommended that Interplus 356 should be used.

Interplus 256 can be applied to substrates with surface temperatures at time of application up to 100°C (212°F). In these circumstances, rapid application of multiple coats is necessary to achieve the correct film thickness, and suitable personal protection equipment is essential during application due to the rapid release of volatiles from the applied film.

Interplus 256 is suitable for protection of steel operating at continuous dry temperatures of up to 150°C (302°F), with intermittent surges up to 200°C (392°F).

Interplus 256 is not designed for continuous water immersion.

### Elevated Temperature Curing

An alternative curing agent is available for applications at temperatures greater than 25°C (77°F).

<u>Temperature</u>	<u>Touch Dry</u>	<u>Hard Dry</u>	<u>Overcoating Interval with recommended topcoats</u>	
			<u>Minimum</u>	<u>Maximum</u>
25°C (77°F)	6 hours	11 hours	11 hours	Extended*
40°C (104°F)	3 hours	7 hours	7 hours	Extended*

\* See International Protective Coatings Definitions & Abbreviations

Working pot life time at 25°C (77°F) is 1½ hours, and at 40°C (104°F) is 1 hour

Note: VOC values quoted are based on maximum possible for the product taking into account variations due to colour differences and normal manufacturing tolerances.

### SYSTEMS COMPATIBILITY

Interplus 256 will generally be applied to bare steel but is fully compatible for overlap onto most aged coatings, in addition to touch up repair of the following primers:

Intercure 200	Interzinc 12
Intergard 251	Interzinc 22
Intergard 269	Interzinc 42
InterH2O 280	Interzinc 52
Interseal 670HS	Interzinc 315

Recommended topcoats/intermediates are:

Intercure 420	Interplus 880
Interfine 629HS	Interseal 670HS
Intergard 475HS	Interthane 990
Intergard 740	Interzone 505
Interplus 256	Interzone 954
Interplus 770	

It should be noted that Interplus 256 is not suitable for overcoating with thin films of alkyd, chlorinated rubber, vinyl or acrylic finishes.

For other suitable topcoats/intermediates 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](http://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
	5 litre	3.75 litre	5 litre
	4 US gal	3 US gal	5 US gal
1 US gal			
For availability of other pack sizes, contact International Protective Coatings.			
SHIPPING WEIGHT (TYPICAL)	Unit Size	Part A	Part B
	5 litre	6.2 kg	1.73 kg
	4 US gal	41.4 lb	9.2 lb
	U.N. Shipping No. UN 1263 (Part A) : UN 1760 (Part B)		
STORAGE	Shelf Life	12 months (Part A) & 24 months (Part B) 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](http://www.international-marine.com) or [www.international-pc.com](http://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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