Interplus 256

Surface Tolerant Epoxy

International Protective Coatings

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

Colour	Aluminium
Gloss Level	Eggshell
Volume Solids	80%
Typical Thickness	75-150 microns (3.0-6.0 mils) dry equivalent to 94-188 microns (3.8-7.5 mils) wet
Theoretical Coverage	6.4 m^2/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
Practical Coverage	Allow appropriate loss factors
Method of Application	Airless spray, Air spray, Brush, Roller

Drying Time▲

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

* See International Protective Coatings Definitions & Abbreviations

▲ For curing at elevated temperatures an alternative curing agent is avialable. See product Characteristics for details.

Regulatory Data

Flash Point	Base (Part A) 34°C (93°F)	C/A (Part B) 69°C (156°F)	Mixed 39°C (102°F)
Product Weight	1.39 kg/l (11.6 lb/gal)		
VOC	162 g/l (1.35 lb/gal)	UK - PG6/23(92), Appendix 3	
	2.08 lb/gal (250 g/l)	USA - EPA Method 24	

ECOTECH

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

ENG0602

Interplus 256

Surface Tolerant Epoxy

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 8504:1992.

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 8501-1:1988) C or D grade rusting, or SSPC-SP7.

Hand or Power Tool Preparation

Hand or power tool clean to a minimum St2 (ISO 8501-1:1988) 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 8501-1:1988) 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 8501:1988) or SSPC-SP3 is required. Optimum performance will be achieved from SSPC-SP11 for hand preparation, or blasting to Sa2 (ISO 8501-1:1988) or SSPC-SP6.

Ultra High Pressure Hydroblasting/Abrasive Wet Blasting

May be applied to surfaces prepared to Sa2½ (ISO 8501-1:1988) or SSPC-SP6 which have flash rusted to no worse than Grade HB2½M (refer to International Hydroblasting Standards) or Grade SB2½M (refer to International Slurry Blasting Standards). It is also possible to apply to damp surfaces in some circumstances. Further information is available from International Protective Coatings.

Aged Coating

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 parts : 1 part 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 avialable. 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 (2,500 p.s.i.)

Air Spray (Pressure Pot)

Suitable

Gun	DeVilbiss MBC or JGA
Air Cap	704 or 765
Fluid Tip	E

Brush

Recommended

Typically 75-125 microns (3-5 mils) can be achieved

Roller

Recommended

Typically 75-100 microns (3-4 mils) can be achieved

Thinner

International GTA220 (or GTA415)

Do not thin more than allowed by local environmental legislation.

Cleaner

International GTA822 (or 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.

Interplus 256

Surface Tolerant Epoxy

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 or roller, 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 (PPE) 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 greater than 24°C (75°F)

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

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

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 22
Intergard 251	Interzinc 42
Intergard 269	Interzinc 52
Intergard 270	Interzinc 315
Interseal 670 HS	Interzinc 280
Interzinc 12	

Recommended topcoats and intermediates are:

Intercure 420	Interplus 880
Interfine 629 HS	Interseal 670 HS
Intergard 475 HS	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.

ENG0602

Interplus 256

Surface Tolerant Epoxy

Additional Information

Further information regarding industry standards, terms and abbreviations used in this data sheet can be found in the following sections of the International Protective Coatings data manual:

- 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	5 litre unit	Interplus 256 Base Interplus 256 Curing Agent	3.75 litres in 5 litre containter 1.25 litres in 3.5 litre container
	4 gallon unit	Interplus 256 Base Interplus 256 Curing Agent	3 gallons in a 5 gallon container 1 gallon in a 1 gallon container
	For availability of other pack sizes contact International Protective Coatings		
Shipping Weight	U.N. Shipping No.	UN 1263 (Base) : UN 2924 (Curing Agent)	
	5 litre unit	6.2 kg (13.7 lb) Base (Part A) 1.73 kg (3.81 lb) Curing Agent (Part B)	
	4 gallon unit	18.8 kg (41.4 lb) Base (Part A) 4.16 kg (9.2 lb) Curing Agent (Part B)	
Storage	Shelf Life	12 months (Base) & 24 months (Curing Agent) minimum at 25°C (77°F). Subject to re-inspection thereafter. Store in dry, shaded conditions away from sources of heat and ignition.	

Disclaimer

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. Whilst we endeavour 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: 19/06/2002

Copyright © International Paint Ltd. ■ *and International are trademarks.*

International Protective Coatings

World Centre	Asia Region	Australasia Region	Europe Region	Middle East Region	North America Region	South America Region
P.O Box 20980 Oriel House 16 Connaught Place London, W2 2ZB England	3 Neythal Road Jurong Town Singapore 628570	115 Hyde Road Yeronga Brisbane Queensland Australia	P.O Box 20980 Oriel House 16 Connaught Place London, W2 2ZB England	PO Box 37 Dammam 31411 Saudi Arabia	6001 Antoine Drive Houston Texas 77091	Av Paiva 999, Neves, Sao Gonçalo, Rio de Janeiro Brazil
Tel: (44) 20 7479 6000 Fax: (44) 20 7479 6500	Tel: (65) 663 3066 Fax: (65) 266 5287	Tel: (61) 7 3892 8888 Fax: (61) 7 3892 4287 H&S (61) 1800 807 001	Tel: (44) 20 7479 6000 Fax: (44) 20 7479 6500	Tel: (966) 3 812 1044 Fax: (966) 3 812 1169	Tel: (1) 713 682 1711 Fax: (1) 713 684 1514	Tel: (55) 21 624 7100 Fax: (55) 21 624 7123

Local Office:
Tel: 0191 469 6111 Fax: 0191 495 0676