

Bitumen

PRODUCT DESCRIPTION

A one component, high build cold applied bituminous coating.

INTENDED USES

As an economical coating ideally suited for the protection of interior steel surfaces in enclosed areas such as tanks for storage of sea water, immersed piping and structural steelwork.

Suitable for use at low temperatures and over power tool cleaned steel where performance expectations are consistent with such preparation methods.

PRACTICAL INFORMATION FOR INTERTUF 16

Colour	Black, Brown			
Gloss Level	Not Applicable			
Volume Solids	53%			
Typical Thickness	100-125 microns (4-5 mils) dry equivalent to 189-236 microns (7.6-9.4 mils) wet			
Theoretical Coverage	4.20 m ² /litre at 125 microns d.f.t and stated volume solids 170 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, Brush, Roller			
Drying Time	Overcoating interval with self			
Temperature	Touch Dry	Hard Dry	<i>Minimum</i>	<i>Maximum</i>
5°C (41°F)	24 hours	3 days	24 hours	Extended ¹
15°C (59°F)	12 hours	2 days	16 hours	Extended ¹
25°C (77°F)	8 hours	2 days	8 hours	Extended ¹
40°C (104°F)	6 hours	1 day	8 hours	Extended ¹

¹ See International Protective Coatings Definitions and Abbreviations

REGULATORY DATA

Flash Point (Typical)	35°C (95°F)		
Product Weight	1.00 kg/l (8.3 lb/gal)		
VOC	3.47 lb/gal (416 g/l) 418 g/kg	EPA Method 24 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 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 16, 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.

Ultra High Pressure Hydroblasting / Abrasive Wet Blasting

May be applied to surfaces prepared to Sa2½ (ISO 8501-1:2007) or SSPC-SP6 which have flash rusted to no worse than Grade HB2½M (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.

Power Tool Preparation

Power tool clean to a minimum St3 (ISO 8501-1:2007) or SSPC-SP3.

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.

Primed Surfaces

Intertuf 16 can be applied over approved anti-corrosive primers. The primer surface should be dry and free from all contamination and Intertuf 16 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-SP10 Abrasive Blasting, or SSPC-SP11, Power Tool Cleaning) and patch primed prior to the application of Intertuf 16

APPLICATION

Mixing	This material is a one component coating and should always be mixed thoroughly with a power agitator before application.	
Mix Ratio	Not applicable	
Airless Spray	Recommended	Tip Range 0.45-0.65 mm (18-26 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	Typically 50-75 microns (2.0-3.0 mils) can be achieved
Roller	Suitable	Typically 50-75 microns (2.0-3.0 mils) can be achieved
Thinner	International GTA004	Do not thin more than allowed by local environmental legislation
Cleaner	International GTA004	
Work Stoppages	Thoroughly flush all equipment with International GTA004. All unused material should be stored in tightly closed containers. Partially filled containers may show surface skinning and/or a viscosity increase of the material after storage. Material should be filtered prior to use.	
Clean Up	Clean all equipment immediately after use with GTA004. 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

Apply by airless spray only. 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.

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

At low temperatures it may be necessary to thin Intertuf 16 to enable airless spray application to be performed. Normally 10% thinning (by volume) with International GTA004 will be satisfactory for this purpose.

When applying Intertuf 16 in confined spaces ensure adequate ventilation.

If salt water is used in the wet blast process the resulting surface must be thoroughly washed with fresh water before application of Intertuf 16. 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.

Heavily pitted areas should be stripe coated by brush, to ensure good "wetting" of the surface.

Intertuf 16 is designed for use in enclosed areas only and not for use in situations where it will be exposed to sunlight. Exposure to sunlight will result in severe cracking and crazing of the coating which will destroy anti-corrosive properties.

Although Intertuf 16 can be applied to power tool cleaned steel, extended lifetimes on water immersion will only be achieved when application is performed over correctly blasted substrates, in which case excellent water immersion resistance can be achieved.

Intertuf 16 dries by solvent evaporation and does not chemically cure or crosslink, the dry film is thermoplastic, not resistant to solvents, and is not suitable for immersion in hot water.

Normally a minimum of two coats to give 250 microns (10 mils) is required to give good anti-corrosive performance on water immersion.

Over-application will result in solvent retention and prolonged periods will be required before the film achieves maximum hardness.

This product has the following specification approvals:

- UK Department of Transport Item No. 141

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 16 is normally applied directly to steel, however, it can be applied over the following primers:

Intergard 269
Interplate 398

Intertuf 16 is only suitable for overcoating with itself, and should not be topcoated with any other product.

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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
- Paint Application
- Surface Preparation
- 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		
		Vol	Pack
	20 litre	20 litre	20 litre
5 litre	5 litre	5 litre	
For availability of other pack sizes, contact International Protective Coatings.			
SHIPPING WEIGHT (TYPICAL)	Unit Size		
	20 litre	22 kg	
	5 litre	5.5 kg	
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.

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