Interline 624

Epoxy Phenolic

PRODUCT DESCRIPTION

A light coloured, solvent free, tar free, two pack epoxy phenolic cargo tank coating.

INTENDED USES

A high performance, coating system for use in fuel, compensating fuel, CHT, ballast tank and on well deck overhead areas of Landing Craft Air Cushion capable ships. Optically active pigment (OAP) is present in the buff primer (THA626) to aid in the inspection process during application.
For use at Newbuilding or Maintenance & Repair.

PRODUCT INFORMATION

Colour	THA626-Buff Primer, THA625-Grey Topcoat, THA623-White Topcoat
Finish/Sheen	Gloss
Part B (Curing Agent)	THA627
Volume Solids	95% ±2% (ISO 3233:1998)
Mix Ratio	4 volume(s) Part A to 1 volume(s) Part B
Typical Film Thickness	Primer - 150 microns dry (158 microns wet) Topcoat - 250 microns dry (263 microns wet)
Theoretical Coverage	Primer - 6.3 m²/lt at 150 microns dry Topcoat - 3.8 (m²/lt) at 250 microns dry, allow appropriate loss factors
Method of Application	Plural Feed Airless Spray, Airless Spray, Brush, Roller
Flash Point (Typical)	Part A 83°C; Part B 110°C; Mixed 83°C
Induction Period	Not required

Drying Information	10°C	25°C	35°C
Touch Dry [ISO 9117/3:2010]	18 hrs	5 hrs	3 hrs
Hard Dry [ISO 9117-1:2009]	40 hrs	16 hrs	6 hrs
Pot Life	50 mins	30 mins	15 mins

Note Pot life at a temperature of 10°C is for information only. Recommended mixed paint temperature prior to application is 25°C minimum. See also Mixing information on page 2.

Overcoating Data - see limitations

	Substrate Temperature					
	10°C		25°C		35°C	
Overcoated By	Min	Max	Min	Max	Min	Max
Interline 624	40 hrs	21 days	18 hrs	21 days	8 hrs	21 days
Interline 624 Other	40 hrs	7 days	18 hrs	7 days	8 hrs	7 days

Note The first line of overcoating data above refers to situations where the underlying coat **has not** been subjected to U.V. light during cure, and the second line of data above refers to situations where the underlying coat **has** been subjected to U.V. light during cure.

REGULATORY DATA

VOC 98 g/lt as supplied (EPA Method 24)

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 colour and normal manufacturing tolerances.

MIL SPEC MIL-PRF-23236C, Type VII, Class 5, 7, 13 & 19, Grade C

SYSTEMS AND COMPATIBILITY

Consult your International Paint representative for the system best suited for the surfaces to be protected.
When using in cargo tanks, consult the Interline 624 Cargo Tank Application Guidelines.
When using in ballast tanks, consult the Interline 624 Ballast Tank Coating Application Guidelines.

SURFACE PREPARATIONS

Use in accordance with the standard Worldwide Marine Specifications.
All surfaces to be coated should be clean, dry and free from contamination.
High pressure fresh water wash or fresh water wash, as appropriate, and remove all oil or grease, soluble contaminants and other foreign matter in accordance with SSPC-SP1 solvent cleaning.

NEWBUILDING/MAJOR REFURBISHMENT
Abrasive blast clean to Sa2½ (ISO 8501-1:2007). If oxidation has occurred between blasting and application of Interline 624, 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.
Where necessary, remove weld spatter and smooth weld seams and sharp edges.
Weld seams and damaged areas should be blast cleaned to Sa2½ (ISO 8501-1:2007) or power tooled to Pt3 (JSRA SPSS:1984)
For all shop primers, the surface should be blast cleaned to Sa2½ (ISO 8501-1:2007).
A sharp, angular surface profile of 50-100 microns is recommended.

REPAIR
Consult International Paint.

NOTE
For use in Marine situations in North America, the following surface preparation standards can be used:
SSPC-SP10 in place of Sa2½ (ISO 8501-1:2007)
SSPC-SP11 in place of Pt3 (JSRA SPSS:1984)

MIXING OF PRODUCT PRIOR TO APPLICATION
Single Feed
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) The temperature of Part A and Part B prior to mixing should be 20-25°C. Higher component temperatures will reduce the working pot life of product. If the temperature of the two components exceeds 30°C then it is recommended that plural component airless spray equipment is used.
(2) Agitate Base (Part A) with a power agitator
(3) Agitate Curing Agent (Part B) with a power agitator
(4) Combine entire contents of Curing Agent (Part B) with Base (Part A) and mix thoroughly with a power agitator.
(5) Use promptly and within the pot life specified
Plural Feed
(1) Base (Part A) and Curing Agent (Part B) are not mixed before application
(2) Base (Part A) to be recirculated through the airless spray unit, heating with in-line heaters, until it has reached 30-40°C
(3) Curing Agent (Part B) to be 20°C minimum

WELDING OR FLAME CUTTING ON METAL COATED WITH Interline 624
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. In North America do so in accordance with instruction in ANSI/ASC Z49.1 "Safety in Welding and Cutting."

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APPLICATION

Mixing	For information on mixing please see page 2.
Thinner	Do not thin.
Airless Spray	Ensure spray gun is rated beyond the maximum fluid outlet pressure of the pump to be used. **Single Feed** -Tip range 0.013"-0.019" (330-483 microns). Smaller tip gives better film thickness control of primer -Total output fluid pressure at spray tip not less than 5000 p.s.i. (352 kg/cm²) - Pump Ratio 70:1 minimum It is recommended that an in-line heater is installed as close to the pump fluid outlet as possible. This will allow the operator to use heat to improve flow of material through long paint hoses. The heater should be set to achieve a paint temperature at the gun of 28-32°C. Do not have the in-line heater set too high. It is recommended that the hose length is kept to a minimum and should not exceed 150ft (46m). Best results are obtained with 3/8" (9.5 mm) ID paint hose and ¼" (6.4 mm) ID whip end. **Plural Feed** -Total output fluid pressure at spray tip not less than 3500 p.s.i. (246 kg/cm²) - Base (Part A) to be recirculated through the spray unit, using in-line heater, to heat to 30-40°C - Curing Agent to be 20°C minimum -Tip range 0.013"-0.019" (330-483 microns). Smaller tip gives better film thickness control of primer - Mixed paint line to be kept as short as possible When using plural component spray equipment it is important to ensure an adequate supply of both components to the main proportioning unit. If feeder pumps are employed, they should be carefully set in order to maintain the supply of Part A and Part B and to prevent cavitation in the feeder hoses. Failure to do this will result in an incorrect mix ratio that may cause slow cure, cracking, checking and have an adverse effect on mechanical properties.
Conventional Spray	Application by conventional spray is not recommended.
Brush	Application by brush is recommended for small areas only.
Roller	Application by roller is recommended for small areas only.
Cleaner	International GTA822/GTA415
Work Stoppages and Cleanup	Do not allow material to remain in hoses, gun or spray equipment. Thoroughly flush all equipment with International GTA822/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 all equipment immediately after use with International GTA822/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. Do not exceed pot life limitations. All surplus materials and empty containers should be disposed of in accordance with appropriate regional regulations/legislation. For plural component application it is important to flush out the in-line static mixer, mixed paint hose and gun during stoppages greater than 10 minutes.
Welding	For information on welding please see page 2.

SAFETY

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.

Prior to use, obtain, consult and follow the Material Safety Data Sheet for this product concerning health and safety information. Read and follow all precautionary notices on the Material Safety Data Sheet and container labels. If you do not fully understand these warnings and instructions or if you can not strictly comply with them, do not use this product. Proper ventilation and protective measures must be provided during application and drying to keep solvent vapour concentrations within safe limits and to protect against toxic or oxygen deficient hazards. Take precautions to avoid skin and eye contact (ie. gloves, goggles, face masks, barrier creams etc.) Actual safety measures are dependant on application methods and work environment.
EMERGENCY CONTACT NUMBERS:
USA/Canada - Medical Advisory Number 1-800-854-6813
Europe - Contact (44) 191 4696111. For advice to Doctors & Hospitals only contact (44) 207 6359191
R.O.W. - Contact Regional Office

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LIMITATIONS

At ambient temperatures below 25°C paint lines must be lagged.
This product will not cure adequately below 10°C.
The drying times and overcoating intervals may alter due to various on-site factors such as tank configuration and ventilation rates.
Consult your International Paint representative for the time interval required between coating completion and ballast loading.
Overcoating information is given for guidance only and is subject to regional variation depending upon local climate and environmental conditions. Consult your local International Paint representative for specific recommendations.
Apply in good weather. Temperature of the surface to be coated must be at least 3°C above the dew point. For optimum application properties bring the material to 20-25°C, unless specifically instructed otherwise, prior to mixing and application. Unmixed material (in closed containers) should be maintained in protected storage in accordance with information given in the STORAGE Section of this data sheet. Technical and application data herein is for the purpose of establishing a general guideline of the coating application procedures. Test performance results were obtained in a controlled laboratory environment and International Paint makes no claim that the exhibited published test results, or any other tests, accurately represent results found in all field environments. As application, environmental and design factors can vary significantly, due care should be exercised in the selection, verification of performance and use of the coating.

UNIT SIZE

Unit Size	Part A		Part B	
	Vol	Pack	Vol	Pack
5 US gal	4 US gal	5 US gal	1 US gal	1 US gal

For availability of other unit sizes consult International Paint

UNIT SHIPPING WEIGHT (TYPICAL)

Unit Size	Unit Weight
5 US gal	60 lb

STORAGE

Shelf Life: Part A - 18 months minimum at temperatures up to 25°C. Storage for long periods at temperatures greater than 25°C may result in poor spray properties.
Part B - 18 months minimum at 25°C

WORLDWIDE AVAILABILITY

Consult International Paint.

IMPORTANT NOTE

www.international-marine.com