

Epoxy

PRODUCT DESCRIPTION

A two component, solvent free, heavy duty epoxy tank lining.

INTENDED USES

For application to steel tank internals to provide corrosion resistance to a range of products including crude oil, white oils and potable water. Suitable as a lining for pipes and fittings.

Suitable for application over concrete for lining and secondary containment purposes.

PRACTICAL INFORMATION FOR INTERLINE 925

Colour	Limited colour range available																												
Gloss Level	Not applicable																												
Volume Solids	100%																												
Typical Thickness	300-600 microns (12-24 mils) dry equivalent to 300-600 microns (12-24 mils) wet 400-1,000 microns (16-40 mils) for use as a single coat on tank floors.																												
Theoretical Coverage	2.50 m ² /litre at 400 microns d.f.t and stated volume solids 100 sq.ft/US gallon at 16 mils d.f.t and stated volume solids																												
Practical Coverage	Allow appropriate loss factors																												
Method of Application	Airless Spray, Roller, Brush																												
Drying Time	<div>Overcoating Interval with recommended topcoats</div> <table> <tr> <th>Temperature</th><th>Touch Dry</th><th>Hard Dry</th><th>Minimum</th><th>Maximum</th></tr> <tr> <td>10°C (50°F)</td><td>15 hours</td><td>36 hours</td><td>36 hours</td><td>2 days</td></tr> <tr> <td>15°C (59°F)</td><td>12 hours</td><td>24 hours</td><td>24 hours</td><td>2 days</td></tr> <tr> <td>25°C (77°F)</td><td>8 hours</td><td>18 hours</td><td>18 hours</td><td>1 day</td></tr> <tr> <td>40°C (104°F)</td><td>5 hours</td><td>7 hours</td><td>7 hours</td><td>12 hours</td></tr> </table>				Temperature	Touch Dry	Hard Dry	Minimum	Maximum	10°C (50°F)	15 hours	36 hours	36 hours	2 days	15°C (59°F)	12 hours	24 hours	24 hours	2 days	25°C (77°F)	8 hours	18 hours	18 hours	1 day	40°C (104°F)	5 hours	7 hours	7 hours	12 hours
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REGULATORY DATA

Flash Point (Typical)	Part A >101°C (214°F); Part B >101°C (214°F); Mixed >101°C (214°F)		
Product Weight	1.52 kg/l (12.7 lb/gal)		
VOC	1.04 lb/gal (125 g/l) 23 g/kg	EPA Method 24 EU Solvent Emissions Directive (Council Directive 2010/75/EU)	
See Product Characteristics section for further details			

Protective Coatings

Epoxy

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.

Where necessary, remove weld spatter and smooth weld seams and sharp edges.

Oil or grease should be removed in accordance with SSPC-SP1 solvent cleaning.

Abrasive Blast Cleaning

This product must only be applied to surfaces prepared by abrasive blast cleaning to Sa2½ (ISO 8501-1:2007) or SSPC SP10. A sharp, angular surface profile of 75-100 microns (3-4 mils) is recommended.

Interline 925 must be applied before oxidation of the steel occurs. If oxidation does occur the entire oxidised area should be reblasted to the standard specified above.

Surface defects revealed by the blast cleaning process should be ground, filled, or treated in the appropriate manner.

Where local VOC regulations allow, surfaces may be primed with Interline 982 to 15-25 microns (0.6-1.0 mils) dry film thickness before oxidation occurs. Alternatively, the blast standard can be maintained by use of dehumidification.

Interline 982 can hold a blast for up to 28 days in the semi-protected environment of a tank interior. If moisture is present on the surface, oxidation will occur and reblasting will be required.

Concrete Surfaces

Refer to International Protective Coatings for specific recommendations.

APPLICATION

Mixing	Interline 925 must be applied in accordance with the detailed International Protective Coatings Working Procedures for the application of Tank Linings. 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) Agitate Curing Agent (Part B) with a power agitator. (3) Combine entire contents of Curing Agent (Part B) with Base (Part A) and mix thoroughly with power agitator.			
Mix Ratio	3 part(s) : 1 part(s) by volume			
Working Pot Life	10°C (50°F) 2 hours	15°C (59°F) 90 minutes	25°C (77°F) 60 minutes	40°C (104°F) 30 minutes
Airless Spray	Recommended	Tip Range 0.53-0.66 mm (21-26 thou) Total output fluid pressure at spray tip not less than 211 kg/cm² (3000 p.s.i.)		
Air Spray (Pressure Pot)	Not recommended			
Brush	Suitable - small areas only	Typically 150-200 microns (6.0-8.0 mils) can be achieved		
Roller	Suitable - small areas only	Typically 150-200 microns (6.0-8.0 mils) can be achieved		
Thinner	Not suitable	- DO NOT THIN		
Cleaner	International GTA853 or International GTA415	Choice of cleaner maybe subject to local legislation. Please consult your local representative for specific advice.		
Work Stoppages	Do not allow material to remain in hoses, gun or spray equipment. Thoroughly flush all equipment with International GTA853. 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 GTA853. 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.			

Epoxy

PRODUCT CHARACTERISTICS

The detailed Interline 925 Application Guidelines should be consulted prior to use.

Exact specification for total dry film thickness and number of coats will be dependent upon service end use requirements. Consult International Protective Coatings for specific advice regarding tank lining applications.

Apply by airless spray only. Application by other methods, e.g. brush or roller, may require more than one coat and is suggested for small areas only or initial stripe coating.

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

Interline 925 can be applied by standard airless spray equipment when the paint temperature is maintained above 30°C (86°F). At lower temperatures an in-line heater of a suitable pressure rating may be used to assist with pumping and atomisation of the product.

Surface temperature must always be a minimum of 3°C above dew point.

Do not apply at steel temperatures below 10°C (50°F).

The climatic conditions within the tank must be controlled to maintain a maximum relative humidity of 50% at temperatures between 10-15°C (50-59°F), and a relative humidity of maximum 60% at temperatures of 16°C (61°F) and above.

The relative humidity within the confines of the tank should be controlled using dehumidification equipment. Where such equipment is not available, a single coat application technique should be employed to avoid intercoat adhesion problems.

Where multi-coat systems are to be used, optimum intercoat adhesion is best achieved by keeping the overcoating interval as short as possible.

Exposure to unacceptably low temperatures and/or high humidities during or immediately after application may result in incomplete cure and surface contamination that could jeopardise subsequent intercoat adhesion.

After the last coat has cured hard, the coating system dry film thickness should be measured using a suitable non-destructive magnetic gauge to verify the average total applied system thickness and the coating system should be free of all pinholes or other holidays. Dry film thicknesses in excess of 500 microns (20 mils), can be checked using a suitable high voltage pulsating type holiday detector, set at 100 volts per 25 microns d.f.t. (100 volts per mil). Excessive voltage may produce a holiday in the coating film. The cured film should be essentially free of runs, sags, drips, inclusions or other defects. All deficiencies and defects should be corrected. The repaired areas shall be retested and allowed to cure as specified before placing the finished lining into service. Consult International Protective Coatings Interline 925 Application Guidelines for detailed repair procedures.

Maximum chemical resistance is not attained until the film has completely cured. Cure is a function of temperature, humidity and film thickness. Normally films at 400 microns (16 mils) dry film thickness will exhibit full and complete cure for optimal chemical resistance in 7-10 days at 25°C (77°F). Curing times are proportionately shorter at elevated temperatures and longer at lower temperatures.

Interline 925 is not recommended for storage of aqueous media at temperatures in excess of 60°C (140°F).

Due to the presence of low molecular weight chemicals in the formulation, some VOC may be recorded when this product is tested in accordance with the UK-PG6/23(92), Appendix 3 and USA-EPA Method 24 protocols. This is due to the high temperatures used in the test procedures.

In common with all epoxies Interline 925 will chalk and discolour on exterior exposure. However, these phenomenon are not detrimental to chemical resistance performance.

This product has the following specification approvals:

BS6920:1988 for Contact with Drinking Water.

Norwegian National Institute of Public Health for Use in Potable Water Tanks on Offshore Installations.

Meets permissible levels of extractable materials as stated in CFR21-175.300 (Micro Materials Report).

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

Interline 925 can be applied directly to correctly prepared bare steel. However, where the end service is not for potable water, the following primers are suitable:

Interline 982

Ceilecote 680M (to be used as a sealer for concrete application)

Interline 925 should only be topcoated with itself, and should never be overcoated with another product.

Consult International Protective Coatings to confirm that Interline 925 is suitable for contact with the product to be stored.

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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
- Interline 925 Application Guidelines

SAFETY
PRECAUTIONS

This product is intended for use only by professional applicators in industrial situations. All work involving the application and use of this product should be performed in compliance with all relevant national Health, Safety and Environmental standards, regulations and legislation.

Proper ventilation must be provided during application and afterwards during curing (refer to product datasheets for typical curing times) to ensure safe limits and prevent fires and explosions. Forced extraction will be required in confined spaces. Ventilation and/or respiratory personal protective equipment (airfed hoods or appropriate cartridge masks) must be provided during application and curing. Take precautions to avoid skin and eye contact (overalls, gloves, goggles, masks, barrier cream, etc).

Before use, obtain, read and then follow the advice given on the Material Safety Data Sheets (Parts A and B if two-pack) and the Health and Safety section of the Coatings Applications Procedures for this product.

In the event that 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.

The detailed safety measures are dependent on application methods and the work environment. If you do not fully understand these warnings and instructions or if you cannot strictly comply with them, do not use the product and consult International Protective Coatings.

Warning: This product contains liquid epoxies and modified polyamines and may cause skin sensitisation if not used correctly.

PACK SIZE	Unit Size	Part A		Part B	
		Vol	Pack	Vol	Pack
	20 litre	15 litre	20 litre	5 litre	5 litre
	4 US gal	3 US gal	5 US gal	1 US gal	1 US gal

SHIPPING WEIGHT (TYPICAL)	Unit Size	Part A	Part B
	20 litre	24.3 kg	8.7 kg
	4 US gal	40.8 lb	14.3 lb
U.N. Shipping No. Non Hazardous (Base) : 1760 (Curing Agent)			

STORAGE	Shelf Life	18 months minimum at 25°C (77°F). Subject to re-inspection thereafter. Store in dry, shaded conditions away from sources of heat and ignition.
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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 or 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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