Interline® 704

Epoxy

PRODUCT DESCRIPTION

A two component, chemically resistant epoxy tank lining

INTENDED USES

To provide corrosion protection to the internals of steel storage tanks containing a range of products, including crude oil, gasolines, MTBE, caustic solutions and a selected range of aromatic and aliphatic solvents.

PRACTICAL INFORMATION FOR INTERLINE 704

Colour	Pink, White, Grey
Gloss Level	Semi Gloss
Volume Solids	53%
Typical Thickness	80-125 microns (3.2-5 mils) dry equivalent to 151-236 microns (6-9.4 mils) wet
Theoretical Coverage	4.20 m²/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 recommended topcoats	
Temperature	**Touch Dry**	**Hard Dry**	*Minimum*	*Maximum*
5°C (41°F)	6 hours	24 hours	36 hours	35 days
15°C (59°F)	4.5 hours	15 hours	28 hours	26 days
25°C (77°F)	3 hours	8 hours	9 hours	21 days
40°C (104°F)	45 minutes	5 hours	6 hours	10 days

REGULATORY DATA

Flash Point (Typical)	Part A 24°C (75°F); Part B 23°C (73°F); Mixed 26°C (79°F)	
Product Weight	1.42 kg/l (11.8 lb/gal)	
VOC	3.54 lb/gal (425 g/lt) 333 g/kg	EPA Method 24 EU Solvent Emissions Directive (Council Directive 1999/13/EC)

See Product Characteristics section for further details

SURFACE PREPARATION

All surfaces to be coated should be clean, dry and free from contamination. Prior to application all surfaces should be assessed and treated in accordance with ISO 8504:2000

Where necessary, remove weld spatter and where required 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 50 - 100 microns (2-3.9 mils) is recommended.

Interline 704 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.

Surfaces may be primed with Interline 982 to 40 microns (1.5 mils) dry film thickness before oxidation occurs. Alternatively, the blast standard can be maintained by use of dehumidification.

Areas of breakdown, damage, weld seams etc., should be prepared to the specified standard (e.g. Sa2½ (ISO 8501-1:2007) or SSPC-SP10 or power tool cleaned to Pt3 (JSRA SPSS:1984) or SSPC -SP11).

APPLICATION

Mixing

Interline 704 must be applied in accordance with the Interline 704 detailed International Protective Coatings Recommended Working Procedures.

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

3.5 part(s) : 1 part(s) by volume

Working Pot Life

5°C (41°F)	15°C (59°F)	25°C (77°F)	40°C (104°F)
9 hours	7.5 hours	5 hours	2 hours

Airless Spray	Recommended	Tip Range 0.53-0.68 mm (21-27 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	Recommended - Small areas only	Typically 50-75 microns (2.0-3.0 mils) can be achieved
Roller	Recommended - Small areas only	Typically 50-75 microns (2.0-3.0 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.

PRODUCT CHARACTERISTICS

The detailed Interline 704 Application Guidelines should be consulted prior to use.

Interline 704 is typically specified as a two coat system at 125 microns (5 mils) per coat to give a total coating system dry film thickness of 250 microns (10 mils). Exact specification for total dry film thickness 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, roller, may require more than one coat and should only be used for small areas or touch-up work.

When applying Interline 704 by brush or roller, it may be necessary to apply multiple coats to achieve the total specified system dry film thickness.

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

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

This product will not cure adequately below 5ºC (41ºF).

The relative humidity within the confines of the tank should not exceed 85%.

When applying Interline 704 in confined spaces ensure adequate ventilation.

For multi-coat application, exposure to temperatures below 5ºC (41ºF) 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. The coating system should be free of all pinholes or other holidays. 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 704 Application Guidelines for proper 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 250 microns (10 mils) total system dry film thickness will exhibit full and complete cure for optimal chemical resistance in 7-10 days at 25° C (77°F) and 50% relative humidity. Curing times are proportionately shorter at elevated temperatures and longer at lower temperatures.

This product has the following specification approvals:

- Food Contact - FDA Compliant : Liquid & Dry Foodstuffs
- Food Contact - Carriage of Grain (NOHA)
- Tank Coating - Recognised Corrosion Control Coating (Lloyd's Register)

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.

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

Interline 982 can be used as a suitable holding primer.

Consult International Protective Coatings to confirm that Interline 704 is suitable for contact with the product to be stored.

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 704 Application Guidelines

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	Vol	Pack
	20 litre	15.56 litre	20 litre	4.44 litre	5 litre
	For availability of other pack sizes, contact International Protective Coatings.				
SHIPPING WEIGHT (TYPICAL)	Unit Size	Part A		Part B	
	20 litre	26 kg		4.6 kg	
STORAGE	Shelf Life	12 months minimum at 25°C (77°F). 6 months minimum at temperatures greater than 25°C. Subject to re-inspection thereafter. Store in dry, shaded conditions away from sources of heat and ignition.			

Important Note

Issue date: 05/02/2015

www.international-pc.com