

## Epoxy

### PRODUCT DESCRIPTION

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

### INTENDED USES

For application to steel tank internals to provide corrosion resistance to a range of products, especially potable water and crude oil.

### PRACTICAL INFORMATION FOR INTERLINE 925P

<b>Colour</b>	Light Grey, Red, Off White			
<b>Gloss Level</b>	Not applicable			
<b>Volume Solids</b>	100% (practical)			
<b>Typical Thickness</b>	300-600 microns (12-24 mils) dry equivalent to 300-600 microns (12-24 mils) wet 400-1000 microns (16-40 mils) for use as a single coat on tank floors. Thickness is dependent upon application method and specification.			
<b>Theoretical Coverage</b>	2.22 m <sup>2</sup> /litre at 450 microns d.f.t and stated volume solids 89 sq.ft/US gallon at 18 mils d.f.t and stated volume solids (see Page 3 Product Characteristics)			
<b>Practical Coverage</b>	Allow appropriate loss factors			
<b>Method of Application</b>	Airless Spray, Brush, Roller, Plural Component Airless Spray			
<b>Drying Time</b>	Overcoating interval with self			
<b>Temperature</b>	<b>Touch Dry</b>	<b>Hard Dry</b>	<i>Minimum</i>	<i>Maximum</i>
10°C (50°F)	9 hours	16 hours	16 hours	2 weeks
25°C (77°F)	5 hours	9 hours	9 hours	2 weeks
40°C (104°F)	3 hours	7 hours	7 hours	1 week

### REGULATORY DATA

<b>Flash Point (Typical)</b>	Part A 101°C (214°F); Part B 101°C (214°F); Mixed 101°C (214°F)		
<b>Product Weight</b>	1.45 kg/l (12.1 lb/gal)		
<b>VOC</b>	0.52 lb/gal (35 g/l)	EPA Method 24	
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.

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.

### Steel

This product must only be applied to surfaces prepared by abrasive blast cleaning to Sa2½ (ISO 8501-1:2007) or SSPC-SP10. Interline 925P 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.

Interline 925P may also be applied over Intergard 269 for some cargoes; see page 3. The Intergard 269 may be overcoated up to 90 days after application provided the surface is abraded and fresh water washed. Alternatively, the blast standard can be maintained by the use of dehumidification.

### Concrete

Refer to International Protective Coatings' Concrete Surface Preparation Guidelines for further information.

### APPLICATION

<b>Mixing</b>	Material is supplied in two containers as a unit. Complete units should be stored, mixed and applied in accordance with the Interline 925P Application Guidelines.	
<b>Mix Ratio</b>	3 part(s) : 1 part(s) by volume	
<b>Working Pot Life</b>	10°C (50°F) 100 minutes	25°C (77°F) 40°C (104°F) 60 minutes 45 minutes
<b>Plural Component Airless Spray</b>	Recommended	Refer to Interline 925P Application Guidelines for more details.
<b>Airless Spray</b>	Recommended	Tip Range 0.53-0.66 mm (21-26 thou) Total output fluid pressure at spray tip not less than 211 kg/cm <sup>2</sup> (3000 p.s.i.)
<b>Brush</b>	Suitable	Small areas only
<b>Roller</b>	Suitable	Small areas only
<b>Thinner</b>	Do not thin for potable water applications. Thinning for storage of other cargoes may be possible; please contact AkzoNobel.	
<b>Cleaner</b>	International GTA853 (or GTA031)	
<b>Work Stoppages</b>	Do not allow material to remain in hoses, gun or spray equipment. Release pressure from the material hose and flush fluid line and spray gun with International GTA853. Do not re-pressurise equipment until ready to resume spraying operations, and ensure pot life limitations are adhered to.	
<b>Clean Up</b>	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.	

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### PRODUCT CHARACTERISTICS

The detailed Interline 925P 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.

Although Interline 925P is 100% practical conversion wet-to-dry film thickness during normal application conditions, the product does contain a small amount of solvent as supplied which is dissipated during the application process.

Apply by plural component airless spray. 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. Stripe coating is an essential part of good working practice and as such should form part of any lining specification.

Surface temperature must always be a minimum of 3°C (5°F) above dew point. Do not apply at steel temperatures below 10°C (50°F).

The climatic conditions within the tank must be controlled as recommended in the Interline 925P Application Guidelines. 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. The coating system should be free of all pinholes or other holidays and verified using a suitable method as recommended in the Interline 925P Application Guidelines. 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 925P Application Guidelines for detailed repair procedures.

#### Return to Service

The following minimum cure times are recommended for Interline 925P to achieve its full chemical resistance properties.

<u>Temperature</u>	<u>Cure Schedule</u>
25°C (77°F)	7 days

Cure schedule refers to the minimum time at the specified substrate temperature prior to immersion for water service.

Intergard 269 may only be used as a holding primer for storage of crude oil/water mixes and refined hydrocarbon cargoes.

For storage of cargoes above ambient temperatures, consult International Protective Coatings for further details.

Interline 925P meets the requirements of BS6920-1:2000 for contact with potable water and is approved by the Water Regulations Advisory Scheme (WRAS). Please contact International Paint to confirm the specific parameters of the approval.

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

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

Interline 925P can be applied directly to correctly prepared bare steel. However, it is suitable for application over the following primer:

Ceilcote 680M  
Intergard 740  
Interline 982  
Intergard 269

Where the end use is for potable water service, contact International Paint for guidance.

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

Consult International Paint to confirm that Interline 925P 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](http://www.international-pc.com):

- Definitions & Abbreviations
- Surface Preparation
- Paint Application
- Theoretical & Practical Coverage
- Interline 925P 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. 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

For availability of other pack sizes, contact AkzoNobel.

SHIPPING WEIGHT (TYPICAL)	Unit Size	Part A	Part B
		20 litre	25.5 kg

STORAGE	Shelf Life
	12 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.*

*This Technical Data Sheet is available on our website at [www.international-marine.com](http://www.international-marine.com) or [www.international-pc.com](http://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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