

Epoxy

PRODUCT DESCRIPTION

A two component, solvent free glass reinforced epoxy laminate system.

INTENDED USES

For use in conjunction with glass fibre mat as a reinforced laminate, and as an unreinforced gel coat to provide a coating system for the refurbishment of corroded storage tank floors.

Also suitable for the extended protection of new tanks as a proven alternative to glass reinforced polyester laminate systems.

Interline 9670 is designed for the protection of bulk storage tanks containing crude oils or white oil products.

PRACTICAL INFORMATION FOR INTERLINE 9670

Colour	Clear
Gloss Level	Not applicable
Volume Solids	100%
Typical Thickness	Laminate (glass fibre reinforced): 1250-1500 microns (50-60 mils) dry, equivalent to 1250-1500 microns (50-60 mils) wet, according to specification. Gel Coat: 200-300 microns (8-12 mils) dry, equivalent to 200-300 microns (8-12 mils) wet, according to specification.
Theoretical Coverage	Laminate: Thickness and coverage are dependent upon the configuration of the surface to be coated. Gel Coat: 4.00 m ² /litre at 250 microns d.f.t. and stated volume solids 160 sq.ft/US gallon at 10 mils d.f.t. and stated volume solids
Practical Coverage	Allow appropriate loss factors
Method of Application	Airless Spray, Roller

Drying Time

Temperature	Touch Dry	Hard Dry	Overcoating Interval with recommended topcoats	
			Minimum	Maximum
10°C (50°F)	18 hours	24 hours	36 hours	14 days
15°C (59°F)	10 hours	14 hours	24 hours	10 days
25°C (77°F)	6 hours	10 hours	18 hours	7 days
40°C (104°F)	4 hours	6 hours	8 hours	6 days

REGULATORY DATA

Flash Point (Typical)	Part A >101°C (214°F); Part B >101°C (214°F); Mixed >101°C (214°F)		
Product Weight	1.21 kg/l (10.1 lb/gal)		
VOC	0.00 lb/gal (0 g/l) 8 g/kg	EPA Method 24 EU Solvent Emissions Directive (Council Directive 2010/75/EU)	

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.

Steel

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 9670 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 15-25 microns (0.6-1.0 mils) dry film thickness. Interline 9670 may also be applied over Intergard 269, applied at a maximum dry film thickness of 40 microns (1.6 mils), with a maximum overcoating interval of 30 days. For extended overcoating intervals, please contact International Protective Coatings. 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.

Caulk Application

Prior to the application of the laminate all weld seams, lap joints, plate edges should be caulked; alternatively, Interline 9670 filled with a suitable aggregate may be used. For further advice, please consult your local representative.

APPLICATION

Mixing	The detailed Interline 9670 Application Guidelines should be consulted prior to use.			
	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.			
	<ol style="list-style-type: none"> (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	2part(s):1part(s)by volume			
Working Pot Life	10°C (50°F) 60 minutes	15°C (59°F) 50 minutes	25°C (77°F) 40 minutes	40°C (104°F) 20 minutes
Airless Spray	Recommended	Tip Range 0.53-0.66 mm (21-26 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 - Small touch-up areas only			
Roller	Recommended			
Thinner	DO NOT THIN			
Cleaner	International GTA822			
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 clean equipment during the course of the working day. Frequency of cleaning will depend upon amount used, 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

Always consult the Interline 9670 Application Guidelines prior to use.

This product is recommended for the storage of crude oil and white oil products. Material is not suitable for storage of refined materials such as unleaded gasoline. It is also not suitable for the storage of aqueous media at temperatures in excess of 40°C (104°F).

Apply in good climatic conditions. The temperature of the surface to be coated must be at least 3°C (5°F) above the dew point. Do not apply at steel temperatures below 10°C (50°F) and the relative humidity should not exceed 80% during application and curing.

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

For hand lay application, Interline 9670 should be mixed immediately before use and should be limited to a quantity that can be used within the working pot life. Apply a coat of Interline 9670 at 600 - 800 microns (24 -32 mils) wet film thickness, by spray or roller to the primed / caulked surface. Lay International glass fibre mat into the resin, and use a ribbed roller to force the glass mat into the wet resin. Apply additional resin and roll until the fibre glass mat is completely saturated and free of entrapped air. Once the laminate has cured, apply an unreinforced gel coat of Interline 9670 or Interline 925 at 200 - 300 microns (8 - 12 mils) wet film thickness by spray or roller.

Maximum resistance is not attainable until the film has completely cured. Cure is a function of temperature humidity and film thickness. Normally films at 1500 microns (60 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.

The curing times will vary depending upon dry film thickness and conditions that exist during application and throughout curing periods.

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 9670 can be applied directly to correctly prepared bare steel. However, it is suitable for application over the following primer:

Intergard 269
Interline 982

The following topcoats are recommended for Interline 9670:

Interline 9670
Interline 925
Interline 925P

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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

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 Safety Data Sheet and the container(s), and should not be used without reference to the Safety Data Sheet (SDS).

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 AkzoNobel for further advice.

PACK SIZE	Unit Size	Part A		Part B	
		Vol	Pack	Vol	Pack
	20 litre	13.33 litre	20 litre	6.67 litre	10 litre

For availability of other pack sizes, contact AkzoNobel.

SHIPPING WEIGHT (TYPICAL)	Unit Size	Part A	Part B
		20 litre	18.23 kg

STORAGE	Shelf Life
	12 months 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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