

Vinyl Ester

PRODUCT DESCRIPTION

A vinyl ester based coating, used as a holding primer.

INTENDED USES

As a blast holding primer, for the temporary protection of freshly blasted steel prior to the application of Interline 955 tank lining.

PRACTICAL INFORMATION FOR INTERLINE 949

Colour	Clear
Gloss Level	Not applicable
Volume Solids	100% reactive
Typical Thickness	50 microns (2 mils) dry equivalent to 59 microns (2.4 mils) wet
Practical Coverage	17 m ² /litre at 50 microns d.f.t and 85% volume solids 682 sq.ft/US gallon at 2 mils d.f.t and 85% volume solids (see Page 3 Product Characteristics)
Method of Application	Airless Spray, Brush

Drying Time

Temperature	Touch Dry	Hard Dry	Overcoating Interval with recommended topcoats	
			Minimum	Maximum
10°C (50°F)	60 minutes	2 hours	2 hours	7 days
15°C (59°F)	60 minutes	2 hours	2 hours	7 days
25°C (77°F)	45 minutes	2 hours	2 hours	7 days
35°C (95°F)	45 minutes	2 hours	2 hours	5 days

These dry times have been obtained using the recommended amount of retarder for each temperature (see Product Characteristics).

REGULATORY DATA

Flash Point (Typical)	Part A 32°C (90°F); Part B 100°C (212°F); Mixed 32°C (90°F)		
Product Weight	1.10 kg/l (9.2 lb/gal)		
VOC	1.76 lb/gal (212 g/lt) 255 g/kg	EPA Method 24 EU Solvent Emissions Directive (Council Directive 1999/13/EC)	

See Product Characteristics section for further details

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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.

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

Abrasive Blast Cleaning

Abrasive blast clean to Sa2½ (ISO 8501-1:2007) or SSPC-SP10. If oxidation has occurred between blasting and application of Interline 949, 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.

A sharp, angular surface profile of 75-100 microns (3-4 mils) is recommended.

APPLICATION

Mixing	Interline 949 MUST be applied in accordance with the Interline 955 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.	
	An optional retarder solution is available for this material. See Product Characteristics for details.	
Mix Ratio	49 part(s) : 1 part(s) by volume	
Working Pot Life	10°C (50°F) 1 hour ¹	15°C (59°F) 1 hour ¹
	25°C (77°F) 40 minutes ¹	35°C (95°F) 40 minutes ¹
	¹ See Product Characteristics for details of quantity of retarder to be used	
Airless Spray	Recommended	Tip Range 0.43-0.53 mm (17-21 thou) Total output fluid pressure at spray tip not less than 155 kg/cm ² (2204 p.s.i.)
Air Spray (Pressure Pot)	Not recommended	
Brush	Suitable - Small areas and stripe coating only	Typically 25 microns (1.0 mils) can be achieved
Roller	Not recommended	
Thinner	Not suitable	DO NOT THIN
Cleaner	International GTA853	N.B Clean all equipment immediately after use.
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 should be once every hour using GTA853 cooled to <15°C (59°F).	
	All surplus materials and empty containers should be disposed of in accordance with appropriate regional regulations/legislation.	

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PRODUCT CHARACTERISTICS

It is advised that the Interline 955 Recommended Working Procedures are consulted prior to the use of Interline 949.

Interline 949 can be applied in a wide range of climatic conditions, including material temperatures up to 35°C (95°F). However, at material temperatures greater than 25°C (77°F) the use of a retarder solution is required in order to maintain the working pot life, allowing normal airless spray methods to be employed. The recommended level of retarder solution is as follows:-

<25°C (77°F)	No retarder required
25-35°C (77-95°F)	1 unit of retarder required

These volumes of retarder will maintain the pot life at the specified times quoted. The retarder must always be added to the base prior to the addition of the initiator and mixed thoroughly using a power agitator.

Although Interline 949 is theoretically a 100% reactive mix, International Protective Coatings advise a volume solids working figure of 85%. However, this figure may be higher or lower, and the actual figure will depend upon the ambient temperature and ventilation present during application.

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.

Care should be exercised to avoid application in excess of 100 microns (4 mils) dry film thickness otherwise optimum total system performance will not be achieved.

This product must **not** be thinned as the use of thinners may severely inhibit the curing mechanism of the coating.

This product will not cure adequately below 5°C (41°F). For maximum performance ambient curing temperatures should be above 15°C (59°F).

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

Maximum steel temperature at the time of application is 60°C (140°F) and maximum relative humidity during the application and cure period is 80%.

Elevated storage temperatures reduce shelf life. Avoid storage above 35°C (95°F). Uncatalysed Interline 949 is stable for 6 months from date of manufacture when stored below 25°C (77°F) in its original sealed containers. Interline 949 should never be stored in direct sunlight. If necessary, refrigerated storage can be used to prolong shelf life at elevated temperatures and ensure that the working pot can be achieved.

Under direct sunlight exposures or when surface temperatures exceed 35°C (95°F), Interline 949 should be recoated as soon as the coating will support foot traffic in order to prevent the possibility of intercoat disbondment.

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

This product is not recommended to be topcoated other than by:

Interline 955
Interzone 2000

For additional information, consult International Protective Coatings.

Consult International Protective Coatings to confirm that Interline 949 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 955 Working Procedures

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 drying (Refer to product datasheets for typical drying times) to keep solvent concentrations within 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 drying. 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.

PACK SIZE	Unit Size	Part A		Part B	
		Vol	Pack	Vol	Pack
	20 litre	19.6 litre	20 litre	0.4 litre	0.5 litre
The optional retarder solution is available as 40ml in a 100ml container. For availability of other pack sizes, contact International Protective Coatings.					
SHIPPING WEIGHT (TYPICAL)	Unit Size	Part A		Part B	
	20 litre	25.2 kg		0.5 kg	
STORAGE	Shelf Life	6 months at 20°C (68°F).			
		Subject to re-inspection thereafter. Store in dry, shaded conditions away from sources of heat and ignition. During storage and shipment, Interline 949 initiator must not be exposed to temperatures exceeding 30°C (90°F). Refrigeration recommended. Best practice would be to hold Parts A and B in separate stores.			

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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