

Epoxy

PRODUCT DESCRIPTION

A two component solvent based thin film epoxy tank lining.

INTENDED USES

As an economical coating for the corrosion protection of the internals of steel storage tanks and vessels.

Suitable for the storage of an extensive range of products including solvents, crude oils, white oil refined products, aviation fuels, aqueous solutions, brackish water and caustic soda.

PRACTICAL INFORMATION FOR INTERLINE 944

Colour	Pink, White
Gloss Level	Not applicable
Volume Solids	58%
Typical Thickness	100-150 microns (4-6 mils) dry equivalent to 172-259 microns (6.9-10.4 mils) wet
Theoretical Coverage	4.64 m ² /litre at 125 microns d.f.t and stated volume solids 186 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, Air Spray, Brush, Roller

Drying Time

Temperature	Touch Dry	Hard Dry	Overcoating interval with self	
			Minimum	Maximum
10°C (50°F)	10 hours	24 hours	48 hours	28 days
15°C (59°F)	7 hours	16 hours	36 hours	28 days
25°C (77°F)	3 hours	8 hours	24 hours	28 days
40°C (104°F)	1 hour	3 hours	12 hours	14 days

REGULATORY DATA

Flash Point (Typical)	Part A 25°C (77°F); Part B 23°C (73°F); Mixed 24°C (75°F)	
Product Weight	1.50 kg/l (12.5 lb/gal)	
VOC	3.42 lb/gal (410 g/l) 440 g/l	EPA Method 24 UK - PG6/23(04), Appendix 3

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.

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 a minimum Sa2½ (ISO 8501-1:2007) or SSPC-SP10.

A sharp, angular surface profile of 50-75 microns (2-3 mils) is recommended.

Interline 944 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 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.

Shop Primed Steel

Weld seams and damaged areas should be blast cleaned to Sa2½ (ISO 8501-1:2007) or SSPC-SP10. If the shop primer shows extensive or widely scattered breakdown overall sweep blasting may be necessary.

APPLICATION

Mixing	Interline 944 must be applied in accordance with the Interline 944 system sheet and the detailed International Protective Coatings Recommended Working Procedures for 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) Combine entire contents of Curing Agent (Part B) with Base (Part A) and mix thoroughly with power agitator.		
Mix Ratio	5.67 part(s) : 1.00 part(s) by volume		
Working Pot Life	10°C (50°F)	15°C (59°F)	25°C (77°F) 40°C (104°F)
	10 hours	8 hours	6 hours 3 hours
Airless Spray	Recommended	Tip Range 0.53-0.68 mm (21-27 thou) Total output fluid pressure at spray tip not less than 176 kg/cm ² (2503 p.s.i.)	
Air Spray (Pressure Pot)	Recommended	Gun	DeVilbiss MBC or JGA
		Air Cap	704 or 765
		Fluid Tip	E
Brush	Suitable - Small areas	Typically 2.0-3.0 mils (50-75 microns) can be achieved	
Roller	Suitable - Small areas	Typically 50-75 microns (2.0-3.0 mils) can be achieved	
Thinner	International GTA220 (or International GTA415)		
Cleaner	International GTA853 (or International GTA415)		
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.		

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PRODUCT CHARACTERISTICS

The detailed Tank Lining Recommended Working Procedures should be consulted prior to use.

Interline 944 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.

Maximum film build in one coat is best attained by airless spray. When applying by methods other than airless spray, the required film build is unlikely to be achieved. Application by air spray may require a multiple cross spray pattern to attain optimum film build. The use of other methods, e.g. brush or roller, may require more than one coat and are suggested only for small areas and initial stripe coating.

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 relative humidity during application and curing should not exceed 80%.

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.

Maximum resistance is not attainable until the film has completely cured. Cure is a function of temperature, humidity and film thickness. Normally films at 250 microns (10 mils) 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.

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

Interline 982

Interline 944 should only be topcoated with itself, and should never be overcoated with another product.

Consult International Protective Coatings to confirm that Interline 944 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

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	17 litre	20 litre	3 litre	5 litre
	5 US gal	4.25 US gal	5 US gal	0.75 US gal	1 US gal
For availability of other pack sizes, contact International Protective Coatings.					
SHIPPING WEIGHT (TYPICAL)	Unit Size	Part A		Part B	
	20 litre	29.4 kg		3.4 kg	
	5 US gal	57.3 lb		6.2 lb	
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.

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