

## Epoxy Phenolic

**PRODUCT DESCRIPTION** A solvent free, two component epoxy phenolic lining system.

**INTENDED USES** To provide corrosion protection for the internal of steel storage tanks and pipes containing crude oil and a limited range of hydrocarbon products.

Interline 2981 is resistant to crude oil at temperatures up to 60°C (140°F).

**PRACTICAL INFORMATION FOR INTERLINE 2981**

<b>Colour</b>	Grey
<b>Gloss Level</b>	Not applicable
<b>Volume Solids</b>	100%
<b>Typical Thickness</b>	300-600 microns (12-24 mils) when used as an unreinforced system for walls. 400-1,000 microns (16-40 mils) for use as a single coat on tank floors.
<b>Theoretical Coverage</b>	2.50 m <sup>2</sup> /litre at 400 microns d.f.t and stated volume solids 100 sq.ft/US gallon at 16 mils d.f.t and stated volume solids
<b>Practical Coverage</b>	Allow appropriate loss factors
<b>Method of Application</b>	Airless Spray,Plural Component Airless Spray
<b>Drying Time</b>	

Overcoating interval with self

Temperature	Touch Dry	Hard Dry	Minimum	Maximum
5°C (41°F)	40 hours	66 hours	36 hours	6 months <sup>1</sup>
10°C (50°F)	24 hours	31 hours	24 hours	6 months <sup>1</sup>
25°C (77°F)	9 hours	12 hours	6 hours	6 months <sup>1</sup>
40°C (104°F)	3 hours	4.5 hours	2 hours	6 months <sup>1</sup>

<sup>1</sup> Please see page 2 Surface Preparation for further details.

The values quoted relate to use within an enclosed tank. Contact International Protective Coatings for further information.

**REGULATORY DATA** **Flash Point (Typical)** Part A 84°C (183°F); Part B 55°C (131°F)

**Product Weight** 1.57 kg/l (13.1 lb/gal)

**VOC** 112 g/kg EU Solvent Emissions Directive (Council Directive 2010/75/EU)

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 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.

#### Steel Substrates

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 2981 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.

When self-self overcoating, ensure the surface of the existing Interline 2981 has been fresh water washed and allowed to dry, prior to second coat application.

Where local VOC regulations allow, surfaces may be primed with Intergard 269 to 25-40 microns (1.0-1.6 mils) dry film thickness before oxidation occurs. Intergard 269 may hold the blast for up to 6 months in the semi-protected environment of a tank interior. If moisture is present on the surfaces, oxidation will occur and re-blasting will be required.

Intergard 269 may be used as a holding primer for Interline 2981. The Intergard 269 should be clean, dry and intact and within a maximum 6 months from application.

### APPLICATION

<b>Mixing</b>	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.	
	<ul style="list-style-type: none"> <li>(1) Agitate Base (Part A) with a power agitator.</li> <li>(2) Agitate Curing Agent (Part B) with a power agitator.</li> <li>(3) Combine entire contents of Curing Agent (Part B) with Base (Part A) and mix thoroughly with power agitator.</li> </ul>	
<b>Mix Ratio</b>	3 part(s) : 1 part(s) by volume	
<b>Working Pot Life</b>	25°C (77°F) 35 minutes	40°C (104°F) 15 minutes
<b>Plural Component Airless Spray</b>	Suitable	Consult International Protective Coatings regarding specific recommendations.
<b>Airless Spray</b>	Recommended	Tip Range 0.53-0.68 mm (21-27 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 - Stripe coats only	
<b>Roller</b>	Not suitable	
<b>Thinner</b>	- <b>DO NOT THIN</b>	
<b>Cleaner</b>	International GTA853 (or GTA415)	
<b>Work Stoppages</b>	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.	
<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 2981 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.

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

Paint should be brought up to a minimum temperature of 20°C (68°F) prior to application.

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. Do not apply at steel temperatures below 5°C (41°F). 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 coating system has cured hard, the dry film thickness should be measured using a suitable non-destructive magnetic gauge to verify the minimum 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.

#### Return to Service

The following minimum cure times are recommended for Interline 2981

<u>Temperature</u>	<u>Return to Service</u>
5°C (41°F)	21 days
10°C (50°F)	10 days
25°C (77°F)	5 days
40°C (104°F)	3 days

Interline 2981 conforms to the requirements of EI1541 section 2.2.

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.

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### SYSTEMS COMPATIBILITY

Interline 2981 will normally be applied directly to correctly prepared steel, however, the following primers are recommended:

Intergard 269

Interline 2981 should only be topcoated with itself, and should never be overcoated with another product.

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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

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
	18 litre	13.5 litre	20 litre	4.5 litre	5 litre

For availability of other pack sizes, contact AkzoNobel.

SHIPPING WEIGHT (TYPICAL)	Unit Size	Part A	Part B
	18 litre	23.92 kg	4.59 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.*

*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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