

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

PRACTICAL INFORMATION FOR INTERLINE 967

Colour	Clear, Buff			
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: 250-500 microns (10-20 mils) dry, equivalent to 250-500 microns (10-20 mils) wet, according to specification.			
Theoretical Coverage	Laminate (glass fibre reinforced): Thickness is dependent upon the configuration of the surface to be coated. Gel Coat: 2.86 m ² /litre at 350 microns d.f.t. and stated volume solids 114 sq.ft/US gallon at 14 mils d.f.t. and stated volume solids			
Practical Coverage	Allow appropriate loss factors			
Method of Application	Airless Spray, Roller			
Drying Time	Overcoating interval with self			
Temperature	Touch Dry	Hard Dry	<i>Minimum</i>	<i>Maximum</i>
10°C (50°F)	18 hours	36 hours	36 hours	72 hours
15°C (59°F)	14 hours	24 hours	24 hours	60 hours
25°C (77°F)	8 hours	18 hours	18 hours	36 hours
40°C (104°F)	4 hours	8 hours	8 hours	24 hours

REGULATORY DATA

Flash Point (Typical)	Part A >101°C (>214°F); Part B >101°C (>214°F); Mixed >101°C (>214°F)	
Product Weight	1.27 kg/l (10.6 lb/gal)	
VOC	0.00 lb/gal (0 g/lit) EPA Method 24	
	139 g/kg	EU Solvent Emissions Directive (Council Directive 1999/13/EC)

See Product Characteristics section for further details

Protective Coatings

Epoxy

SURFACE PREPARATION

All surfaces to be coated should be clean 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 smooth weld seams and sharp edges.

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 967 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 before oxidation occurs. 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. For further advice, please consult your local representative.

APPLICATION

Mixing	Interline 967 must be applied in accordance with the detailed International Protective Coatings Working Procedures for the 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)	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	2 part(s) : 1 part(s) by volume			
Working Pot Life	10°C (50°F)	15°C (59°F)	25°C (77°F)	40°C (104°F)
	60 minutes	45 minutes	30 minutes	15 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 areas and stripe coating only			
Roller	Recommended	See Product Characteristics		
Thinner	DO NOT THIN			
Cleaner	International GTA822 (or GTA415)			
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.

Epoxy

PRODUCT CHARACTERISTICS

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

For hand lay application, Interline 967 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 967 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 967 at 250 - 500 microns (10 - 20 mils) wet film thickness by spray or roller.

Do not apply at steel temperatures below 10°C (50°F).

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

The climatic conditions within the tank must be controlled to maintain a maximum relative humidity of 50% at temperatures between 10-15°C (50-59°F), and a relative humidity of maximum 60% at temperatures of 16°C (61°F) and above.

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 and the coating system should be free of all pinholes or other holidays. Dry film thicknesses in excess of 500 microns (20 mils), can be checked using a suitable high voltage pulsating type holiday detector, set at 100 volts per 25 microns d.f.t. (100 volts per mil). Excessive voltage may produce a holiday in the coating film. 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.

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) and 50% relative humidity. 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.

Consult your local representative to confirm Interline 967 is suitable for contact with the product to be stored.

This product is recommended for the storage of crude oil and white oil products.

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

The following primers are suitable for Interline 967:

Interline 921 (caulk)
Interline 982

For other suitable primers/topcoats consult International Protective Coatings.

Epoxy

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.

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	13.33 litre	20 litre	6.67 litre	10 litre
For availability of other pack sizes, contact International Protective Coatings.					
SHIPPING WEIGHT (TYPICAL)	Unit Size	Part A		Part B	
		19.2 kg		10.1 kg	
STORAGE	Shelf Life	18 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 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.

Copyright © AkzoNobel, 18/09/2017.

All trademarks mentioned in this publication are owned by, or licensed to, the AkzoNobel group of companies.

www.international-pc.com