

Interline 961

E p o x y P h e n o l i c

Product Description A two component, solvent based epoxy phenolic tank lining for application to both new steel, or lightly pitted surfaces.

Intended Uses Particularly suitable for the storage of hot water up to 95°C (203°F), and is also suitable for an extensive range of products including aliphatic and aromatic solvents, aviation fuel, unleaded gasolines and salt solutions.

Interline 961 is suitable for atmospheric exposure service in acidic and corrosive environments including hot steel pipes beneath insulation, buried or immersed pipework operating at temperatures up to 95°C (203°F).

Practical Information for Interline 961

Colour	Buff, Grey, White
Gloss Level	Eggshell
Volume Solids	50%
Typical Thickness	100-125 microns (4-5 mils) dry equivalent to 200-250 microns (8-10 mils) wet
Theoretical Coverage	4.00 m ² /litre at 125 microns d.f.t and stated volume solids 160 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 Interline 961 by Self	
			<i>Minimum</i>	<i>Maximum</i>
10°C (50°F)	90 minutes	8 hours	24 hours	7 days
15°C (59°F)	60 minutes	6 hours	24 hours	6 days
25°C (77°F)	30 minutes	4 hours	20 hours	5 days
40°C (104°F)	20 minutes	2 hours	16 hours	3 days

Regulatory Data

Flash Point	Base (Part A) 23°C (73°F)	C/A (Part B) 23°C (73°F)	Mixed 23°C (73°F)
Product Weight	1.5 kg/l (12.4 lb/gal)		
VOC	460 g/l (3.84 lb/gal) UK - PG6/23(92), Appendix 3		

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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 8504:1992.

Where necessary, remove weld spatter, and where required smooth weld seams and sharp edges.

Abrasive Blast Cleaning

This product must only be applied to surfaces prepared by abrasive blast cleaning to Sa2½ (ISO 8501-1:1988) or SSPC-SP10.

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

Interline 961 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 961 (thinned 30% GTA420) to 40 microns (1.5 mils) dry film thickness before oxidation occurs. Alternatively, the blast standard can be maintained by use of dehumidification.

Hot Product Tanks

When refurbishing hot product tanks, the substrate should be abrasive brush blast cleaned to Sa2 (ISO 8501-1:1988) or SSPC-SP7 and thoroughly fresh water washed to remove salt contamination. After drying abrasive blast clean to Sa2½ (ISO 8501-1:1988) or SSPC-SP10.

Application

Mixing

Interline 961 must be applied in accordance with the Interline 961 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) 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

1.85 parts : 1 part by volume.

Working Pot Life

10°C (50°F)	15°C (59°F)	25°C (77°F)	40°C (104°F)
5 hours	4 hours	2 hours	45 minutes

Airless Spray

Recommended

- Tip range 0.53-0.68 mm (21-27 thou)
- Total output fluid pressure at spray tip not less than 141 kg/cm² (2,500 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 only

Typically 40-50 microns (1.5-2.0 mils) can be achieved

Roller

Suitable - Small areas only

Typically 40-50 microns (1.5-2.0 mils) can be achieved

Thinner

International GTA420

Do not thin more than allowed by local environmental legislation.

Cleaner

International GTA853

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 Working Procedures should be consulted prior to use.

Interline 961 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, or initial stripe coating.

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 10°C (50°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.

When applying Interline 961 in confined spaces ensure adequate ventilation.

Over-application of Interline 961 will result in cracking. Ensure film thickness of individually applied coats is controlled to recommended limits. Total system dry film thickness should not exceed 350 microns, applied in multiple coats.

Maximum chemical resistance is not attained 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). 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.

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. 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. Consult International Protective Coatings Tank Lining Recommended Working Procedures for proper repair procedures.

At cargo temperatures in excess of 60°C (140°F), it is essential that the storage vessel is insulated. This is necessary to avoid premature coating failure due to a temperature gradient within the coating film and substrate which can induce blistering (this is known as the "cold wall" effect).

This product has the following specification approvals:

Air BP F₂D₂ Specification - Lining for Aviation Fuel Storage

Systems Compatibility

This system is self priming and should not be used over other primer coats.

This product should only be topcoated with itself, and should never be topcoated with another product.

Consult International Protective Coatings to confirm that Interline 961 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 sections of the International Protective Coatings data manual:

- Definitions & Abbreviations
- Surface Preparation
- Paint Application
- Theoretical & Practical Coverage

Individual copies of the following information section are available upon request.

- Tank Linings Recommended Working Procedures

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	20 litre unit	Interline 961 Base	13 litres in a 20 litre container
		Interline 961 Curing Agent	7 litres in a 10 litre container
	For availability of other pack sizes contact International Protective Coatings		
Shipping Weight	U.N. Shipping No. 1263		
	20 litre unit	24.9 kg (54.9 lb) Base (Part A)	8.3 kg (18.3 lb) Curing Agent (Part B)
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.	

Disclaimer

The information given in this sheet is not intended to be exhaustive and any person using the product for any purpose other than that specifically recommended in this sheet without first obtaining written confirmation from us as to the suitability of the product for the intended purpose does so at his own risk. Any warranty, if given, or specific Terms & Conditions of Sale are contained in International's Terms & Conditions of Sale, a copy of which can be obtained on request. Whilst we endeavour to ensure that all advice we give about the product (whether in this sheet or otherwise) is correct we have no control over either the quality or 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 whatsoever or howsoever arising for the performance of the product or for any loss or damage (other than death or personal injury resulting from our negligence) arising out of the use of the product. The information contained in this sheet is liable to modification from time to time in the light of experience and our policy of continuous product development.

It is the user's responsibility to check that this sheet is current prior to using the product. Issue date: 19/06/2002

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International Protective Coatings

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