

## Novolac Vinyl Ester

**PRODUCT DESCRIPTION** A two-component, chemical and abrasion resistant, glass flake reinforced vinyl ester.

**INTENDED USES** Interline 955 is primarily intended for the internal lining of chemical storage tanks and vessels where acidic chemicals or hot media are to be stored, such as in oil, gas and chemical processing, pulp and paper plants, and for structural steelwork in environments where frequent contact with corrosive chemicals is likely to occur.

### PRACTICAL INFORMATION FOR INTERLINE 955

<b>Colour</b>	White, Buff
<b>Gloss Level</b>	Semi Gloss
<b>Volume Solids</b>	100% reactive
<b>Typical Thickness</b>	400-600 microns (16-24 mils) dry equivalent to 471-706 microns (18.8-28.2 mils) wet
<b>Practical Coverage</b>	2.10 m <sup>2</sup> /litre at 400 microns d.f.t and 85% volume solids 85 sq.ft/US gallon at 16 mils d.f.t and 85% volume solids (see Page 3 Product Characteristics)
<b>Method of Application</b>	Airless Spray, Brush

#### Drying Time

Temperature	Touch Dry	Hard Dry	Overcoating Interval with recommended topcoats	
			Minimum	Maximum
10°C (50°F)	5 hours	6 hours	6 hours	3 days
15°C (59°F)	4 hours	5 hours	5 hours	3 days
25°C (77°F)	4 hours	5 hours	5 hours	2 days
35°C (95°F)	4 hours	5 hours	5 hours	24 hours

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** 1.2 kg/l (10.0 lb/gal)

**VOC** 29 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 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.

#### Steel Substrates

Abrasive blast clean to Sa2½ (ISO 8501-1:2007) or SSPC-SP10. If oxidation has occurred between blasting and application of Interline 955, 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.

Interline 955 may also be applied over Intergard 269 for some cargoes; see page 3. The Intergard 269 may be overcoated up to 90 days after application provided the surface is abraded and fresh water washed. Alternatively, the blast standard can be maintained by the use of dehumidification.

If a holding primer is required for Interline 955 then the use of Interline 949 is advised (see system compatibility). Alternatively, the blast standard can be maintained by the use of dehumidification.

#### Shop Primed Steel

Prior to application of Interline 955, all shop primed steelwork must be re-blasted to a visual standard as outlined above.

#### Concrete Substrates

Concrete should be well cured prior to application of the flooring, lining or coating system. Refer to the Concrete Surface Preparation Guidelines for more information.

### 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.			
	(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.			
<b>Mix Ratio</b>	98 part(s) : 2 part(s) by volume			
<b>Working Pot Life</b>	10°C (50°F) 1 hour	15°C (59°F) 1 hour	25°C (77°F) 40 minutes	35°C (95°F) 40 minutes
<b>Airless Spray</b>	Recommended	Tip Range 0.63-0.89 mm (25-35 thou) Total output fluid pressure at spray tip not less than 211 kg/cm <sup>2</sup> (3000 p.s.i.)		
<b>Air Spray (Pressure Pot)</b>	Not recommended			
<b>Brush</b>	Suitable - small areas only	Typically 75 microns (3.0 mils) can be achieved		
<b>Roller</b>	Not recommended			
<b>Thinner</b>	Not suitable	<b>DO NOT THIN</b>		
<b>Cleaner</b>	International GTA853	<b>N.B Clean all equipment immediately after use.</b>		
<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 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

The detailed Interline 955 Application Guidelines should be consulted prior to use.

Elevated storage temperatures reduce shelf life. Uncatalysed Interline 955 is stable for 6 months from date of manufacture when stored below 20°C (68°F) in its original sealed containers. Interline 955 should never be stored in direct sunlight. It is recommended that material temperatures be kept as low as possible via refrigeration if necessary in order to prolong shelf life and ensure a 1 hour pot life during airless spray application. It is important to take into consideration that material temperatures will increase following mixing. A recommended storage temperature range is 8°C-19°C (46°F-66°F).

Although Interline 955 is 100% reactive, depending upon the application conditions, the practical volume solids may be lower and International Protective Coatings suggest a value of 85% for estimating spreading rate.

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.

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

Surface temperature must always be a minimum of 3°C 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%.

Interline 955 should typically be specified as a minimum of 2 coats at 400 microns (16 mils) per coat to give a total dry film thickness of not less than 800 microns (32 mils) in order to achieve optimum performance. However, for certain end uses, alternative specifications may be permitted.

Interline 955 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

The retarder solution must always be added to the base prior to the addition of the initiator and mixed thoroughly using a power agitator. Where material temperatures are consistently high, i.e. >35°C (95°F), material should be refrigerated, consult International Protective Coatings for specific advice.

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

Maximum continuous dry temperature resistance for Interline 955 is 130°C (266°F).

Maximum temperature in immersed conditions for Interline 955 is 90°C (194°F).

Consult International Protective Coatings for temperature limits for specific cargoes.

Interline 955 is not intended to be used as a cosmetic finish and colour stability will not be achievable.

For storage of inorganic or organic acids, consult International Protective Coatings for specific advice on cargo compatibility, suitable painting schemes and procedures.

Intergard 269 may only be used as a holding primer for storage of crude oil/water mixes and refined hydrocarbon cargoes.

When surface temperatures exceed 35°C (95°F), or when exposed to direct sunlight, Interline 955 should be overcoated as soon as hard dry to avoid intercoat adhesion problems.

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.

### SYSTEMS COMPATIBILITY

Interline 955 should be applied to correctly prepared substrates. However, it is suitable for application to the following primers:

Ceilcote 370HT Primer  
Ceilcote 380 Primer  
Intergard 269

Interline 955 should only be overcoated with itself.

For additional information, consult International Protective Coatings.

Consult International Protective Coatings to confirm that Interline 955 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](http://www.international-pc.com):

- Definitions & Abbreviations
- Surface Preparation
- Paint Application
- Theoretical & Practical Coverage
- Interline 955 Application Guidelines

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. 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 50ml in a 100ml container. For availability of other pack sizes, contact AkzoNobel.					

SHIPPING WEIGHT (TYPICAL)	Unit Size	Part A		Part B
		Part A - 1263	Part B - 5105	
	20 litre	25.3 kg		0.5 kg
	U.N. Shipping No.			

STORAGE	Shelf Life	
		6 months minimum 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 955 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](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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