

Epoxy

PRODUCT DESCRIPTION

A two component, solvent free, heavy duty epoxy tank and pipe lining.

INTENDED USES

For application to steel tank internals to provide corrosion resistance to a range of products, especially potable water and crude oil.

PRACTICAL INFORMATION FOR INTERLINE 925P

Colour	Grey, Red			
Gloss Level	Not applicable			
Volume Solids	100% (practical)			
Typical Thickness	300-600 microns (12-24 mils) dry equivalent to 300-600 microns (12-24 mils) wet 400-1000 microns (16-40 mils) for use as a single coat on tank floors. Thickness is dependent upon application method and specification.			
Theoretical Coverage	2.22 m ² /litre at 450 microns d.f.t and stated volume solids 89 sq.ft/US gallon at 18 mils d.f.t and stated volume solids (see Page 3 Product Characteristics)			
Practical Coverage	Allow appropriate loss factors			
Method of Application	Plural Component Airless Spray			
Drying Time	Overcoating interval with self			
Temperature	Touch Dry	Hard Dry	<i>Minimum</i>	<i>Maximum</i>
10°C (50°F)	9 hours	16 hours	16 hours	2 weeks
25°C (77°F)	5 hours	9 hours	9 hours	2 weeks
40°C (104°F)	3 hours	7 hours	7 hours	1 week

REGULATORY DATA

Flash Point (Typical)	Part A 101°C (214°F); Part B 101°C (214°F); Mixed 101°C (214°F)		
Product Weight	1.45 kg/l (12.1 lb/gal)		
VOC	0.52 lb/gal (35 g/l)	EPA Method 24	
See Product Characteristics section for further details			

Protective Coatings

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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.

Steel

This product must only be applied to surfaces prepared by abrasive blast cleaning to Sa2½ (ISO 8501-1:2007) or SSPC-SP10. Interline 925P 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.

Concrete

Refer to International Protective Coatings' Concrete Surface Preparation Guidelines for further information.

APPLICATION

Mixing	Material is supplied in two containers as a unit. Complete units should be stored, mixed and applied in accordance with the Interline 925P Application Guidelines.		
Mix Ratio	3 part(s) : 1 part(s) by volume		
Working Pot Life	10°C (50°F)	25°C (77°F)	40°C (104°F)
	100 minutes	60 minutes	45 minutes
Plural Component Airless Spray	Recommended	Refer to Interline 925P Application Guidelines for more details.	
Airless Spray	Recommended	Tip Range 0.53-0.66 mm (21-26 thou) Total output fluid pressure at spray tip not less than 211 kg/cm ² (3000 p.s.i.)	
Brush	Suitable	Small areas only	
Roller	Suitable	Small areas only	
Thinner	DO NOT THIN		
Cleaner	International GTA853 (or GTA031)		
Work Stoppages	Do not allow material to remain in hoses, gun or spray equipment. Release pressure from the material hose and flush fluid line and spray gun with International GTA853. Do not re-pressurise equipment until ready to resume spraying operations, and ensure pot life limitations are adhered to.		
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 Interline 925P 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.

Although Interline 925P is 100% practical conversion wet-to-dry film thickness during normal application conditions, the product does contain a small amount of solvent as supplied which is dissipated during the application process.

Apply by plural component airless spray. 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. Stripe coating is an essential part of good working practice and as such should form part of any lining specification.

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 climatic conditions within the tank must be controlled as recommended in the Interline 925P Application Guidelines. The relative humidity within the confines of the tank should be controlled using dehumidification equipment. Where such equipment is not available, a single coat application technique should be employed to avoid intercoat adhesion problems.

Where multi-coat systems are to be used, optimum intercoat adhesion is best achieved by keeping the overcoating interval as short as possible.

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 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 and verified using a suitable method as recommended in the Interline 925P Application Guidelines. 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 Interline 925P Application Guidelines for detailed repair procedures.

Return to Service

The following minimum cure times are recommended for Interline 925P to achieve its full chemical resistance properties.

<u>Temperature</u>	<u>Cure Schedule</u>
25°C (77°F)	7 days

Cure schedule refers to the minimum time at the specified substrate temperature prior to immersion for water service.

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

Interline 925P meets the requirements of BS6920-1:2000 for contact with potable water and is approved by the Water Regulations Advisory Scheme (WRAS). Please check the approval to ensure the colour chosen complies with the approval.

In common with all epoxies Interline 925P will chalk and discolour on exterior exposure. However, these phenomenon are not detrimental to chemical resistance performance.

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 925P will normally be applied direct to metal and is not normally overcoated with any product other than itself.

However, where the end service use is not for potable water, the following primers are suitable;

Ceilcote 680M Intergard 740
Interline 982

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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
- Interline 925P 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 curing (refer to product datasheets for typical curing times) to ensure 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 curing. 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.

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	15 litre	20 litre	5 litre	5 litre
For availability of other pack sizes, contact International Protective Coatings.					
SHIPPING WEIGHT (TYPICAL)	Unit Size	Part A		Part B	
	20 litre	25.5 kg		5.3 kg	
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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