

Interline 925

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Product Description

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

Intended Uses

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



Certified to ANSI/NSF Standard 61. NSF Certification is for tanks greater than 10,000 gallons.

Practical Information for Interline 925

Colour	Cream, White
Gloss Level	Not applicable
Volume Solids	100%
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	2.5 m ² /litre at 400 microns d.f.t and stated volume solids 100.3 sq.ft/US gallon at 16 mils d.f.t and stated volume solids
Practical Coverage	Allow appropriate loss factors
Method of Application	Airless spray, Brush, Roller

Drying Time

Temperature	Touch Dry	Hard Dry	Overcoating Interval with Interline 925 with Self	
			<i>Minimum</i>	<i>Maximum</i>
10°C (50°F)	15 hours	36 hours	36 hours	5 days
15°C (59°F)	12 hours	24 hours	24 hours	3 days
25°C (77°F)	8 hours	18 hours	18 hours	36 hours
40°C (104°F)	5 hours	7 hours	7 hours	16 hours

Regulatory Data

Flash Point	Base (Part A) >101°C (>214°F)	C/A (Part B) >101°C (>214°F)	Mixed >101°C (>214°F)
Product Weight	1.52 kg/l (12.68 lb/gal)		
VOC	0.00 g/l (Calculated)	UK - PG6/23(92), Appendix 3	
	0.00 lb/gal (0.00 g/l) (Calculated)	USA - EPA Method 24	



Ecotech is an initiative by International Protective Coatings a world leader in coating technology to promote the use of environmentally sensitive products across the globe.

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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.

Oil or grease should be removed in accordance with SSPC-SP1 solvent cleaning.

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 75-100 microns (3-4 mils) is recommended.

Interline 925 must be applied before oxidation of the steel occurs. If oxidation does occur the entire oxidised areas 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.

Application

Mixing

Interline 925 must be applied in accordance with the Interline 925 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

3 parts : 1 part by volume

Working Pot Life

10°C (50°F)	15°C (59°F)	25°C (77°F)	40°C (104°F)
2 hours	90 minutes	60 minutes	30 minutes

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/cm² (3,000 p.s.i.).

Air Spray (Pressure Pot)

Not recommended

Brush

Suitable - Small areas only

Typically 150-200 microns (6-8 mils) can be achieved.

Roller

Suitable - Small areas only

Typically 150-200 microns (6-8 mils) can be achieved.

Thinner

Not Suitable - **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 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

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.

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

Interline 925 can be applied by standard airless spray equipment when the paint temperature is maintained above 30°C (86°F). At lower temperatures an in-line heater of a suitable pressure rating may be used to assist with pumping and atomisation of the product.

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 to maintain a maximum relative humidity of 50% at temperatures between 10-15°C (50-59°F), and a maximum relative humidity of 60% at temperatures of 16°C (61°F) and above.

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 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 dry film thickness (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.

Consult International Protective Coatings Tank Linings Recommended Working Procedures for detailed repair procedures.

Maximum resistance is not attained until the film has completely cured. Cure is a function of temperature, humidity and film thickness. Normally films at 400 microns (16 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.

Interline 925 is not recommended for storage of aqueous media at temperatures in excess of 50°C (122°F).

Due to the presence of low molecular weight chemicals in the formulation, some VOC may be recorded when this product is tested in accordance with the UK-PG6/23(92), Appendix 3 and USA-EPA Method 24 protocols. This is due to the high temperatures used in the test procedures.

This product has the following specification approvals:

Certified to ANSI/NSF Standard 61. NSF Certification is for tanks greater than 10,000 gallons. BS6920:1988 for Contact with Drinking Water.

Norwegian National Institute of Public Health for Use in Potable Water Tanks on Offshore Installations.

Systems Compatibility

Interline 925 can be applied directly to correctly prepared bare steel. However, it is suitable for application over the following primer:

Interline 982

Interline 925 should only be topcoated with itself, and should never be overcoated with another product.

Consult International Protective Coatings to confirm that Interline 925 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 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.

Warning: This product contains liquid epoxies and modified polyamines and may cause skin sensitisation if not used correctly.

Pack Size	20 litre unit	Interline 925 Base	15 litres in a 20 litre container
		Interline 925 Curing Agent	5 litres in a 5 litre container
	4 gallon unit	Interline 925 Base	3 gallons in a 5 gallon container
		Interline 925 Curing Agent	1 gallon in a 1 gallon container
For availability of other pack sizes contact International Protective Coatings			
Shipping Weight	U.N. Shipping No. Non Hazardous (Base) : 1760 (Curing Agent)		
	20 litre unit	24.3 kg (53.6 lb) Base (Part A)	8.7 kg (19.2 lb) Curing Agent (Part B)
	4 gallon unit	18.5 kg (40.8 lb) Base (Part A)	6.5 kg (14.5 lb) Curing Agent (Part B)
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.	

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: 1st June 1997

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International Protective Coatings

Worldwide Availability

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