

PRODUCT DESCRIPTION	A light colored, solvent free, pure epoxy coating.																																																																																								
INTENDED USES	A high performance potable water tank coating which can also be used in ballast tanks, void spaces, cofferdams and wet spaces. For use at Newbuilding or Maintenance & Repair.																																																																																								
PRODUCT INFORMATION	<table><tr><td>Color</td><td colspan="7">THA125/THA127-White, THA125/THA126-Cream</td></tr><tr><td>Finish/Sheen</td><td colspan="7">Gloss</td></tr><tr><td>Part B (Curing Agent)</td><td colspan="7">THA126, THA127</td></tr><tr><td>Volume Solids</td><td colspan="7">100% ±2% (ISO 3233:1998)</td></tr><tr><td>Mix Ratio</td><td colspan="7">3 volume(s) Part A to 1 volume(s) Part B</td></tr><tr><td>Typical Film Thickness</td><td colspan="7">12 mils dry (12 mils wet). NSF approval is based on 18 mils dry in a single coat.</td></tr><tr><td>Theoretical Coverage</td><td colspan="7">134 ft²/US gal at 12 mils dft, allow appropriate loss factors</td></tr><tr><td>Method of Application</td><td colspan="7">Airless Spray, Brush, Roller</td></tr><tr><td>Flash Point</td><td colspan="7">Part A >214°F; Part B >214°F; Mixed >214°F</td></tr></table>								Color	THA125/THA127-White, THA125/THA126-Cream							Finish/Sheen	Gloss							Part B (Curing Agent)	THA126, THA127							Volume Solids	100% ±2% (ISO 3233:1998)							Mix Ratio	3 volume(s) Part A to 1 volume(s) Part B							Typical Film Thickness	12 mils dry (12 mils wet). NSF approval is based on 18 mils dry in a single coat.							Theoretical Coverage	134 ft²/US gal at 12 mils dft, allow appropriate loss factors							Method of Application	Airless Spray, Brush, Roller							Flash Point	Part A >214°F; Part B >214°F; Mixed >214°F															
Color	THA125/THA127-White, THA125/THA126-Cream																																																																																								
Finish/Sheen	Gloss																																																																																								
Part B (Curing Agent)	THA126, THA127																																																																																								
Volume Solids	100% ±2% (ISO 3233:1998)																																																																																								
Mix Ratio	3 volume(s) Part A to 1 volume(s) Part B																																																																																								
Typical Film Thickness	12 mils dry (12 mils wet). NSF approval is based on 18 mils dry in a single coat.																																																																																								
Theoretical Coverage	134 ft²/US gal at 12 mils dft, allow appropriate loss factors																																																																																								
Method of Application	Airless Spray, Brush, Roller																																																																																								
Flash Point	Part A >214°F; Part B >214°F; Mixed >214°F																																																																																								
	<table><tr><td>Drying Information</td><td colspan="2">50°F</td><td colspan="2">59°F</td><td colspan="2">77°F</td><td colspan="2">95°F</td></tr><tr><td>Touch Dry [ISO 9117/3:2010]</td><td colspan="2">15 hrs</td><td colspan="2">12 hrs</td><td colspan="2">8 hrs</td><td colspan="2">5 hrs</td></tr><tr><td>Hard Dry [ISO 9117-1:2009]</td><td colspan="2">36 hrs</td><td colspan="2">24 hrs</td><td colspan="2">18 hrs</td><td colspan="2">8 hrs</td></tr><tr><td>Pot Life</td><td colspan="2">2 hrs</td><td colspan="2">90 mins</td><td colspan="2">60 mins</td><td colspan="2">45 mins</td></tr><tr><td>Overcoating Data - see limitations</td><td colspan="8">Substrate Temperature</td></tr><tr><td></td><td colspan="2">50°F</td><td colspan="2">59°F</td><td colspan="2">77°F</td><td colspan="2">95°F</td></tr><tr><td>Overcoated By</td><td>Min</td><td>Max</td><td>Min</td><td>Max</td><td>Min</td><td>Max</td><td>Min</td><td>Max</td></tr><tr><td>Interline 925</td><td>36 hrs</td><td>5 days</td><td>24 hrs</td><td>3 days</td><td>18 hrs</td><td>36 hrs</td><td>8 hrs</td><td>16 hrs</td></tr><tr><td>Note</td><td colspan="8">When used in non-marine applications, different overcoating intervals apply - refer to the International Protective Coatings Interline 925 datasheet.</td></tr></table>								Drying Information	50°F		59°F		77°F		95°F		Touch Dry [ISO 9117/3:2010]	15 hrs		12 hrs		8 hrs		5 hrs		Hard Dry [ISO 9117-1:2009]	36 hrs		24 hrs		18 hrs		8 hrs		Pot Life	2 hrs		90 mins		60 mins		45 mins		Overcoating Data - see limitations	Substrate Temperature									50°F		59°F		77°F		95°F		Overcoated By	Min	Max	Min	Max	Min	Max	Min	Max	Interline 925	36 hrs	5 days	24 hrs	3 days	18 hrs	36 hrs	8 hrs	16 hrs	Note	When used in non-marine applications, different overcoating intervals apply - refer to the International Protective Coatings Interline 925 datasheet.							
Drying Information	50°F		59°F		77°F		95°F																																																																																		
Touch Dry [ISO 9117/3:2010]	15 hrs		12 hrs		8 hrs		5 hrs																																																																																		
Hard Dry [ISO 9117-1:2009]	36 hrs		24 hrs		18 hrs		8 hrs																																																																																		
Pot Life	2 hrs		90 mins		60 mins		45 mins																																																																																		
Overcoating Data - see limitations	Substrate Temperature																																																																																								
	50°F		59°F		77°F		95°F																																																																																		
Overcoated By	Min	Max	Min	Max	Min	Max	Min	Max																																																																																	
Interline 925	36 hrs	5 days	24 hrs	3 days	18 hrs	36 hrs	8 hrs	16 hrs																																																																																	
Note	When used in non-marine applications, different overcoating intervals apply - refer to the International Protective Coatings Interline 925 datasheet.																																																																																								
REGULATORY DATA	<table><tr><td>VOC</td><td colspan="7">125 g/lit (1.04 lb/US gal) as supplied (EPA Method 24) 23 g/kg of liquid paint as supplied. EU Solvent Emissions Directive (Council Directive 1999/13/EC)</td></tr><tr><td colspan="8">Note: VOC values are typical and are provided for guidance purposes only. These may be subject to variation depending on factors such as differences in color and normal manufacturing tolerances.</td></tr></table>								VOC	125 g/lit (1.04 lb/US gal) as supplied (EPA Method 24) 23 g/kg of liquid paint as supplied. EU Solvent Emissions Directive (Council Directive 1999/13/EC)							Note: VOC values are typical and are provided for guidance purposes only. These may be subject to variation depending on factors such as differences in color and normal manufacturing tolerances.																																																																								
VOC	125 g/lit (1.04 lb/US gal) as supplied (EPA Method 24) 23 g/kg of liquid paint as supplied. EU Solvent Emissions Directive (Council Directive 1999/13/EC)																																																																																								
Note: VOC values are typical and are provided for guidance purposes only. These may be subject to variation depending on factors such as differences in color and normal manufacturing tolerances.																																																																																									

Epoxy Tank Coating

CERTIFICATION

When used as part of an approved scheme, this material has the following certification:

- Potable Water - Carriage of Potable Water (WRC) (BS6920:Part 1)
- Potable Water - Compliant with The Vessel Sanitation Programme (VSP) Construction Guidelines
- Potable Water - Carriage of Potable Water (Folkehelseinstituttet, Norway)

Consult your International Paint representative for details.

Potable Water Certification issued by external bodies is dependent upon formulation and/or manufacturing site. Based on this, products supplied in different territories may not be approved to all of the standards listed above.

SYSTEMS AND COMPATIBILITY

Consult your International Paint representative for the system best suited for the surfaces to be protected. When using in potable or grey water tanks, consult the Interline 925 Potable or Grey Water Tanks Application Procedures.

SURFACE PREPARATIONS

Use in accordance with the standard Worldwide Marine Specifications.

All surfaces to be coated should be clean, dry and free from contamination.

High pressure fresh water wash or fresh water wash, as appropriate, and remove all oil or grease, soluble contaminants and other foreign matter in accordance with SSPC-SP1 solvent cleaning.

NEWBUILDING

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

Welds and damaged areas should be blast cleaned to Sa2½ (ISO 8501-1:2007). Intact shop primer should be prepared by sweep blasting to International Paint standard AS3 or by power tooling to Pt3 (JSRA SSPC:1984).

For PVB and unapproved shop primers, the surface should be blast cleaned to Sa2½ (ISO 8501-1:2007)

NOTE

For potable water tanks, the entire tank must be blast cleaned to a minimum of Sa2½ (ISO 8501-1:2007).

MAJOR REFURBISHMENT

Abrasive blast clean to Sa2½ (ISO 8501-1:2007). If oxidation has occurred between blasting and application of Interline 925, the surface should be reblasted to the specified visual standard.

REPAIR

Consult International Paint.

Consult your International Paint representative for specific recommendations.

NOTE

For use in Marine situations in North America, the following surface preparation standards can be used:

SSPC-SP10 in place of Sa2½ (ISO 8501-1:2007)

SSPC-SP11 in place of Pt3 (JSRA SPSS:1984)

Epoxy Tank Coating

APPLICATION

Mixing	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.
Thinner	Not recommended.
Airless Spray	Recommended Tip Range 21-25 thou (0.53-0.64 mm) Total output fluid pressure at spray tip not less than 3000 psi (211 kg/cm ²) Mixed material temperatures should be between 86-95°F for optimum spraying.
Conventional Spray	Application by brush is recommended for small areas only. Multiple coats may be required to achieve specified film thickness.
Roller	Application by roller is recommended for small areas only. Multiple coats may be required to achieve specified film thickness.
Cleaner	International GTA415/GTA822
Work Stoppages and Cleanup	Do not allow material to remain in hoses, gun or spray equipment. Thoroughly flush all equipment with International GTA415/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 all equipment immediately after use with International GTA415/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. Do not exceed pot life limitations. All surplus materials and empty containers should be disposed of in accordance with appropriate regional regulations/legislation.
Welding	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. In North America do so in accordance with instruction in ANSI/ASC Z49.1 "Safety in Welding and Cutting."

SAFETY

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.

Prior to use, obtain, consult and follow the Material Safety Data Sheet for this product concerning health and safety information. Read and follow all precautionary notices on the Material Safety Data Sheet and container labels. If you do not fully understand these warnings and instructions or if you can not strictly comply with them, do not use this product. Proper ventilation and protective measures must be provided during application and drying to keep solvent vapor concentrations within safe limits and to protect against toxic or oxygen deficient hazards. Take precautions to avoid skin and eye contact (ie. gloves, goggles, face masks, barrier creams etc.) Actual safety measures are dependant on application methods and work environment.

EMERGENCY CONTACT NUMBERS:

USA/Canada - Medical Advisory Number 1-800-854-6813

Europe - Contact (44) 191 4696111. For advice to Doctors & Hospitals only contact (44) 207 6359191

R.O.W. - Contact Regional Office

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

Epoxy Tank Coating

LIMITATIONS

At ambient temperatures below 77°F paint lines must be lagged. In-line heaters should not be used unless absolutely necessary. Consult International Paint for detailed instructions.

This product will not cure adequately below 50°F. For maximum performance the curing temperature should be kept below 95°F. Particular care should be taken to avoid exceeding this in localised areas when artificial heating is introduced.

The climatic conditions within the tank must be controlled to maintain a maximum relative humidity of 50% at temperatures between 50-60°F, and a maximum relative humidity of 60% at temperature of 61°F and above.

The drying times and overcoating intervals may alter due to various on-site factors such as tank configuration and ventilation rates. Maximum overcoating intervals may need to be reduced when application takes place in conditions of poor ventilation. Consult International Paint.

Overcoating information is given for guidance only and is subject to regional variation depending upon local climate and environmental conditions. Consult your local International Paint representative for specific recommendations.

Apply in good weather. Temperature of the surface to be coated must be at least 5°F above the dew point. For optimum application properties bring the material to 86°F-37°F, unless specifically instructed otherwise, prior to mixing and application. Unmixed material (in closed containers) should be maintained in protected storage in accordance with information given in the STORAGE Section of this data sheet. Technical and application data herein is for the purpose of establishing a general guideline of the coating application procedures. Test performance results were obtained in a controlled laboratory environment and International Paint makes no claim that the exhibited published test results, or any other tests, accurately represent results found in all field environments. As application, environmental and design factors can vary significantly, due care should be exercised in the selection, verification of performance and use of the coating.

UNIT SIZE	Unit Size	Part A		Part B	
		Vol	Pack	Vol	Pack
	20 lt	15 lt	20 lt	5 lt	5 lt
	4 US gal	3 US gal	5 US gal	1 US gal	1 US gal

For availability of other unit sizes consult International Paint

UNIT SHIPPING WEIGHT	Unit Size	Unit Weight
	20 lt	33 Kg
	4 US gal	55.3 lb

STORAGE	Shelf Life	12 months minimum at 77°F. Subject to re-inspection thereafter. Store in dry, shaded conditions away from sources of heat and ignition.

WORLDWIDE AVAILABILITY Consult International Paint.

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.

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

© AkzoNobel, 2018

www.international-marine.com