

Solvent Free Epoxy Tank Coating

PRODUCT DESCRIPTION A light coloured, solvent free, pure epoxy coating.

INTENDED USES A high performance tank coating for potable water tanks.
For use at Newbuilding or Maintenance & Repair.

PRODUCT INFORMATION

Colour	THA970-White, THA971-Buff
Part B (Curing Agent)	THA972
Volume Solids	100%
Mix Ratio	2.20 volume(s) Part A to 1 volume(s) Part B
Typical Film Thickness	300 microns dry (300 microns wet)
Theoretical Coverage	3.33 m ² /litre at 300 microns dft, allow appropriate loss factors
Method of Application	Airless Spray, Brush, Roller
Flash Point (Typical)	Part A >101°C; Part B >101°C; Mixed >101°C

Drying Information	10°C	15°C	25°C	35°C
Touch Dry [ISO 9117/3:2010]	22 hrs	19 hrs	9 hrs	8 hrs
Hard Dry [ISO 9117-1:2009]	45 hrs	32 hrs	17 hrs	10 hrs
Walk-on Time	48 hrs	42 hrs	24 hrs	12 hrs
Pot Life	90 mins	80 mins	60 mins	35 mins

Overcoating Data - see limitations	Substrate Temperature							
	10°C		15°C		25°C		35°C	
Overcoated By	Min	Max	Min	Max	Min	Max	Min	Max
Interline 975	36 hrs	28 days	24 hrs	28 days	16 hrs	14 days	7 hrs	14 days

Note When used in non-marine applications, different overcoating intervals apply - refer to the International Protective Coatings Interline 975 datasheet.

REGULATORY DATA

VOC	0 g/lit as supplied (EPA Method 24) 0 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 colour and normal manufacturing tolerances.

Solvent Free 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 - Carriage of Potable Water (Folkehelseinstituttet, Norway)

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. Consult your International Paint representative for details.

SYSTEMS AND COMPATIBILITY

Consult your International Paint representative for the system best suited for the surfaces to be protected. When using in potable water tanks, consult the Interline 975 Potable Water Tank Application Guidelines.

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/MAJOR REFURBISHMENT

For potable water tanks, the entire tank must be blast cleaned to a minimum of Sa2½ (ISO 8501-1:2007). A sharp angular surface profile of 75-100 microns is recommended. If oxidation has occurred between blasting and application of Interline 975, the surface should be reblasted to the specified standard. Surface defects revealed by the blast cleaning process, should be ground, filled, or treated in the appropriate manner.

Solvent Free 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. DO NOT THIN !
Airless Spray	Recommended Tip Range 0.53-0.66 mm (21-26 thou) Total output fluid pressure at spray tip not less than 211 - 246 kg/cm ² (3000 - 3500 p.s.i.) (>60:1 pump) Mixed material temperatures should be between 30-35°C for optimum spraying.
Conventional Spray	Application by conventional spray is not recommended.
Brush	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 GTA853/GTA415
Work Stoppages and Cleanup	Do not allow material to remain in hoses, gun or spray equipment. Thoroughly flush all equipment with International GTA853/GTA415. 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 GTA853/GTA415. 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 vapour 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.

Solvent Free Epoxy Tank Coating

LIMITATIONS

At ambient temperatures below 30°C an in-line heater is needed to assist application. Consult International Paint for detailed instructions.

This product will not cure adequately below 10°C. For maximum performance the curing temperature should be kept above 10°C and below 40°C. Thinning is not allowed.

The climatic conditions within the tank must be controlled to maintain a maximum relative humidity of 50% at temperatures between 10-15°C, and a maximum relative humidity of 60% at temperature of 16°C 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 3°C above the dew point. For optimum application properties bring the material to 30°C, 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	11 lt	20 lt	5 lt	5 lt
For availability of other unit sizes consult International Paint					
UNIT SHIPPING WEIGHT (TYPICAL)	Unit Size	Unit Weight			
	16 lt	23 Kg			
STORAGE	Shelf Life	12 months minimum at 25°C. 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, 2015

www.international-marine.com