

Interline® 704 On-board Repair Procedure

Revision 1, July 2015

The principle requirements for repairs to Interline® 704 damaged either at the initial coating stage (caused by de-staging, etc) or caused during service, i.e. tank cleaning equipment damages, spot corrosion, etc are:



1. Square off area to be repaired and protect intact coating (masking tape or similar).
2. Ensure the area to be repaired is clean and free from dirt by using detergent wash or chemical cleaning.
3. Make sure surface is dry.
4. Remove any corrosion or damaged paint by means of either:



a. Vacuum blasting (Sa2.5).



b. Hand tools, i.e. disc sander or grinder (St3).

5. To avoid damage to the coating, scrapers should not be used for minor repairs.
6. Any pittings which, in the opinion of the Classification Society, do not need re-welding, should be prepared by needle gun and/or cone shaped grinder to remove corrosion deposits.
7. It is not normally recommended to use filler in pittings as it is likely to detach, taking with it any paint which has subsequently been applied, thus exposing the steelwork to possible further corrosion. If however, it is decided to use filler, it must be applied after the first coat of the system, then overcoated with the remaining coats.
8. Abrade area immediately surrounding repair to provide key for subsequent paint application. Typically 25mm of coating surrounding the exposed steel should be sanded to a feathered edge using medium grit aluminium oxide paper.



Examples of squared off areas, spot blasting and feathering back of intact coating

9. Remove all dust particles by brush or vacuum and clean surface to remove contaminants with suitable solvent (Acetone for example).
10. When temperatures fall below 5°C base and curing agent must be stored in premises, (storeroom, hut, etc), which are heated to a temperature in excess of 5°C for a period of not less than 48 hours immediately prior to use.



11. Steel and ambient temperature should be above 5°C and less than 40°C when applying and curing paint. For maximum performance ambient curing temperatures should be above 10°C. Relative humidity should not exceed 85% during application and cure. If RH exceeds 85%, each repair coat should be sanded prior to application of subsequent coat, to ensure good adhesion of topcoat. An induction period of 30 minutes is recommended at temperatures below 25°C.
12. Only mix full units of Interline 704. Where multiple spots are being applied to more than one tank it is recommended that all spots are prepared suitable for paint application. One full unit should be mixed and then split into smaller containers.
13. Mixed paint should be above 5°C and applied in accordance with our recommendations by brush or roller noting that several coats may be required to achieve the target dry film thickness of 250 microns (10.00 mils) (Minimum acceptable dry film thickness is 210 microns (8.27 mils)).

Pot-life	>3hours (5°C to 35°C)
Maximum Humidity	85% (inside tank)

Overcoating Times	Minimum recoat	Maximum recoat
5°C	36 hours	35 days
10°C	24 hours	32 days
15°C	18 hours	28 days
20°C	12 hours	24 days
25°C	9 hours	21 days
30°C	8 hours	18 days
35°C	7 hours	14 days
40°C	6 hours	11 days

14. Minimum time to cargo entry is as follows.

Temperature	Time to Cargo Loading
5°C	20 Days
10°C	15 Days
15°C	11 Days
20°C	9 Days
25°C	7 Days
30°C	6 Days
35°C	5 Days
40°C	4 Days