

PRODUCT DESCRIPTION

A two pack VOC (340g/lit) compliant zinc silicate tank coating.

INTENDED USES

A tank coating suitable for the carriage of petroleum products, solvents (including methanol) and other neutral cargoes.
For use at Newbuilding or Maintenance & Repair.

PRODUCT INFORMATION

Color	QHA345-Reddish Grey
Finish/Sheen	Matt
Part B (Curing Agent)	QHA346 (zinc dust)
Volume Solids	78% ±2% (ISO 3233:1998)
Mix Ratio	1.0 weight(s) Part A to 2.86 weight(s) Part B
Typical Film Thickness	4 mils dry (5.1 mils wet)
Theoretical Coverage	313 ft ² /US gal at 4 mils dft, allow appropriate loss factors * Coverage rates are calculated based upon volume solids test (ISO 3233:1998) determinations. Conduct usage rate observation for best determination of actual coverage.
Method of Application	Airless Spray, Brush, Conventional Spray, Roller
Flash Point	Part A 66°F ; Part B Non-inflammable ; Mixed 70°F (Setaflash) (ASTM D-3278)
Induction Period	Not required

Drying Information	41°F	50°F	77°F	104°F
Touch Dry [ISO 1517:73]	40 mins	30 mins	15 mins	15 mins
Hard Dry [ISO 9117:90]	3 hrs	2 hrs	60 mins	60 mins
Pot Life	16 hrs	12 hrs	8 hrs	4 hrs

Overcoating Data - see limitations	Substrate Temperature							
	41°F		50°F		77°F		104°F	
Overcoated By	Min	Max	Min	Max	Min	Max	Min	Max
Interline 344	24 hrs	10 days	24 hrs	10 days	24 hrs	10 days	24 hrs	7 days

REGULATORY DATA

VOC 340 g/lit (2.84 lb/US gal) as supplied (EPA Method 24)
84 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.

CERTIFICATION

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

- Food Contact - Compliant with EU Framework Directive 1935/2004

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 cargo tanks, consult the Interline 344 Cargo Tank 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.
This product must only be applied to surfaces prepared by abrasive blast cleaning to Sa2½ (ISO 8501-1:2007).
A sharp, angular surface profile of 1.2 - 2.5 mils is recommended.

MAJOR REFURBISHMENT

Abrasive blast clean to Sa2½ (ISO 8501-1:2007).
Interline 344 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.
A sharp, angular surface profile of 1.2 - 2.5 mils is recommended.

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)**

APPLICATION

Mixing	Interline 344 is supplied in 2 parts, a liquid binder component (Part A) and a zinc dust component (Part B). Always mix a complete unit in the proportions supplied. (1) Agitate Part A with a mechanical agitator, (2) Remove moisture absorbent packing from zinc dust (Part B) and discard. (3) Slowly add zinc dust into Part A (Liquid) while agitating with mechanical mixer and allow to mix for at least 5 minutes. DO NOT ADD LIQUID TO POWDER (4) Sieve material through a 30-60 mesh screen into mechanical agitator equipped tank, container or pressure pot. (5) Operate mechanical agitator at low speed (approximately 20 R.P.M.) sufficient to keep zinc dust in suspension during spraying. (6) Keep system closed and free of moisture wherever possible. Pot life varies with temperature and humidity conditions and will be reduced if excessive moisture is present during mixing or in equipment. In extreme cases, this may cause the material to "set-up".
Thinner	Not required for airless spray application. For conventional spray application, use GTA138 (max 5% by volume). DO NOT thin more than allowed by local environmental legislation.
Airless Spray	Recommended Tip Range 0.38-0.53 mm (15-21 thou) Total output fluid pressure at spray tip not less than 112 - 141 kg/cm ² (1590 - 2010 p.s.i.). Use a 60 mesh filter in pump manifold or an in-line filter.
Conventional Spray	Use suitable proprietary equipment. Thinning may be required.
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 GTA138
Work Stoppages and Cleanup	Do not allow material to remain in hoses, gun or spray equipment. Thoroughly flush all equipment with International GTA138. 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 GTA138. 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

LIMITATIONS

International Paint should be consulted to confirm that the tank coating is suitable for the range of cargoes to be carried.

The drying times and overcoating intervals may alter due to various on-site factors such as humidity, tank configuration, ventilation rates, etc.

Consult the detailed coating application procedures for the time interval required between coating completion and cargo loading.

Care should be taken to maintain the recommended wet film thickness in order to avoid excessive dry film thickness. Over application of Interline 344 may lead to mud-cracking, which will require complete removal of the affected areas by abrasive blasting and re-application in accordance with the original specification.

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 70°F-81°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
13.2 lt	8.78 lt	18.9 lt	4.44 lt	20 lt
3.5 US gal	2.32 US gal	5 US gal	1.17 US gal	3 US gal

For availability of other unit sizes consult International Paint

UNIT SHIPPING WEIGHT

Unit Size	Unit Weight
13.2 lt	45.3 Kg
3.5 US gal	100 lb

STORAGE

Shelf Life

Part A - 9 months minimum from date of manufacture when maintained in protected storage at temperatures up to 77°F.

Part B - 12 months minimum when maintained in protected storage at temperatures up to 77°F.


Subject to reinspection 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 law) any loss or damage arising out of the use of the product. 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 International Paint representative that this data sheet is current prior to using the product.

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