

Epoxy Phenolic Tank Coating

PRODUCT DESCRIPTION A two pack, high solids, epoxy phenolic coating.

INTENDED USES A tank coating which is approved for the carriage of potable water.
For use at Newbuilding or Maintenance & Repair.

PRODUCT INFORMATION

Colour	TLA850-White, TLA851-Grey
Finish/Sheen	Not applicable
Part B (Curing Agent)	TLA856
Volume Solids	76% ±2% (ISO 3233:1998)
Mix Ratio	4.00 volume(s) Part A to 1 volume(s) Part B
Typical Film Thickness	125 microns dry (164 microns wet)
Theoretical Coverage	6.08 m ² /litre at 125 microns dft, allow appropriate loss factors
Method of Application	Airless Spray, Roller, Brush
Flash Point (Typical)	Part A 42°C; Part B 54°C; Mixed 43°C
Induction Period	15 minutes at temperatures below 15°C

Drying Information	10°C	15°C	25°C	35°C
Touch Dry [ISO 9117/3:2010]	9 hrs	8 hrs	5 hrs	3 hrs
Hard Dry [ISO 9117-1:2009]	24 hrs	20 hrs	8 hrs	5 hrs
Pot Life	3 hrs	2 hrs	60 mins	30 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 850	24 hrs	30 days	20 hrs	30 days	8 hrs	30 days	5 hrs	21 days

REGULATORY DATA

VOC 225 g/lit as supplied (EPA Method 24)
143 g/kg of liquid paint as supplied. EU Solvent Emissions Directive (Council Directive 1999/13/EC)
172 g/lit Chinese National Standard GB23985

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.

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CERTIFICATION

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

- Potable Water - Certification for tanks greater than 1,500 gallons (ANSI Standard 61)
- Potable Water - Carriage of Potable Water (Folkehelseinstituttet, Norway)
- Potable Water - Certification for tanks greater than 40,000mm²/lt (AS / NZS 4020 : 2005)
- Potable Water - Carriage of Potable Water (TUV, Singapore) (BS6920:2000)

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 850 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

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

Weld seams and damaged areas should be blast cleaned to Sa2½ (ISO 8501-1:2007) or power tooled to Pt3 (JSRA SPSS:1984)

Intact shop primer should be prepared by abrasive blast cleaning to Sa2½ (ISO 8501-1:2007).

A sharp, angular surface profile of 50-100 microns is recommended.

For blasted areas, the primer should be applied before oxidation occurs. If oxidation does occur, the entire oxidised area should be reblasted to the specified standard above.

MAJOR REFURBISHMENT

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 50-100 microns is recommended.

Interline 850 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.

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)

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APPLICATION

Mixing	Material is supplied in 2 containers as a unit. Always mix a complete unit in the proportions supplied. (1) Agitate Base (Part A) with a power agitator. (2) Combine entire contents of Curing Agent (Part B) with Base (Part A) and mix thoroughly with power agitator.
Thinner	International GTA220, GTA415. Thinning is not normally required. Consult the local representative for advice during application in extreme conditions. Do not thin more than allowed by local environmental legislation.
Airless Spray	Recommended Tip Range 0.53-0.68 mm (21-27 thou) Total output fluid pressure at spray tip not less than 176 kg/cm ² (2500 p.s.i.)
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 GTA415/GTA853
Work Stoppages and Cleanup	Do not allow material to remain in hoses, gun or spray equipment. Thoroughly flush all equipment with International GTA415/GTA853. 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/GTA853. 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

China – Contact (86) 532 83889090

R.O.W. - Contact Regional Office

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LIMITATIONS

When used in cargo tanks Interline 850 should not be applied below 10°C. However, for potable water tanks, Interline 850 may be applied at steel temperatures down to 5°C. Consult International Paint for specific cure schedules.

The drying times and overcoating intervals may alter due to various on-site factors such as tank configuration, ventilation rates, etc. The tank should be flushed adequately with potable water prior to filling. Discolouration of the coating may occur during washing, depending on the ionic content (eg: Cu²⁺, Fe³⁺) of the water, coating performance will not be affected. For the drying time to filling and flushing procedure consult International Paint.

For minimum cure time prior to flooding coated tanks, consult the detailed coating application procedures. 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 21-27°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	16 lt	20 lt	4 lt	5 lt
	5 US gal	4 US gal	5 US gal	1 US gal	1 US gal

For availability of other unit sizes consult International Paint

UNIT SHIPPING WEIGHT (TYPICAL)	Unit Size	Unit Weight
		20 lt
	5 US gal	69.1 lb

STORAGE	Shelf Life	12 months minimum at temperatures up to 25°C. Subject to reinspection thereafter. Store in dry, shaded conditions away from sources of heat and ignition.
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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.

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