

PRODUCT DESCRIPTION

A two component, chemically resistant epoxy phenolic tank lining.

INTENDED USES

Interline 994 is designed for storage of a range of aggressive chemicals and is particularly effective when used in the rail industry to provide resistance to molten sulphur.

Suitable for use during new construction or maintenance and repair.

PRACTICAL INFORMATION FOR INTERLINE 994

Colour	Buff, Grey
Gloss Level	Semi Gloss
Volume Solids	70% ± 2%
Typical Thickness	100-200 microns (4-8 mils) dry equivalent to 143-286 microns (5.7-11.4 mils) wet
Theoretical Coverage	4 m ² /litre at 175 microns d.f.t and stated volume solids 160 sq.ft/US gallon at 7 mils d.f.t and stated volume solids
Practical Coverage	Allow appropriate loss factors
Method of Application	Airless Spray, Brush, Roller

Drying Time

Temperature	Touch Dry	Hard Dry	Overcoating Interval with recommended topcoats	
			<i>Minimum</i>	<i>Maximum</i>
10°C (50°F)	6 hours	24 hours	60 hours	10 days
15°C (59°F)	5.5 hours	16 hours	50 hours	14 days
25°C (77°F)	3 hours	6 hours	36 hours	14 days
40°C (104°F)	2 hours	3 hours	14 hours	14 days

REGULATORY DATA

Flash Point	Part A 24°C (75°F); Part B 27°C (81°F); Mixed 25°C (77°F)	
Product Weight	1.67 kg/l (13.9 lb/gal)	
VOC	2.42 lb/gal (290 g/l) 187 g/kg	EPA Method 24 EU Solvent Emissions Directive (Council Directive 1999/13/EC)

See Product Characteristics section for further details

**SURFACE
PREPARATION**

All surfaces to be coated should be clean, dry and free from contamination. Prior to paint application all surfaces should be assessed and treated in accordance with ISO 8504:2000.

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

Oil or grease should be removed in accordance with SSPC-SP1 solvent cleaning.

Abrasive Blast Cleaning

This product must only be applied to surfaces prepared by abrasive blast cleaning to Sa2½ (ISO 8501-1:2007) or SSPC-SP10.

A sharp angular surface profile of 75-100 microns (3-4 mils) is recommended.

Interline 994 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.

APPLICATION

Mixing	<p>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.</p> <p>(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</p> <p>It is recommended that Interline 994 is allowed a 20 minute induction period after mixing, prior to commencing application.</p>			
Mix Ratio	7.38 part(s) : 1 part(s) by volume			
Working Pot Life	10°C (50°F) 6 hours	15°C (59°F) 5 hours	25°C (77°F) 3 hours	40°C (104°F) 1 hour
Airless Spray	Recommended	Tip Range 0.38-0.58 mm (15-23 thou) Total output fluid pressure at spray tip not less than 176 kg/cm ² (2503 p.s.i.)		
Brush	Recommended - Small areas only			
Roller	Recommended - Small areas only			
Thinner	Not recommended	Use International GTA840 only in exceptional circumstances (maximum 5% by volume). Do not thin more than allowed by local environmental legislation		
Cleaner	International GTA822 or International GTA415			
Work Stoppages	Do not allow material to remain in hoses, gun or spray equipment. Thoroughly flush all equipment with International GTA822 or International 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 Up	Clean all equipment immediately after use with International GTA822 or International GTA415. It is good working practice to periodically flush out spray equipment during the course of the working day. Frequency should 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.			

PRODUCT CHARACTERISTICS

Interline 994 will not cure adequately below 10°C (50°F). At no time during the application and up to the first 48 hours after application of the final coat must the steel temperature fall below 10°C (50°F) and the relative humidity exceed 50%.

When applying Interline 994 in confined spaces ensure adequate ventilation.

International Protective Coatings should be consulted to confirm that Interline 994 is suitable for the range of chemicals to be stored. For storage of certain chemicals, a mandatory heated post-cure is required.

The drying times and overcoating intervals may alter due to various on-site factors such as tank configuration, ventilation rates etc. Consult International Protective Coatings for the time interval required between coating completion and cargo loading.

Surface temperature must always be a minimum of 3°C (5°F) above dew point.

Care should be exercised to avoid the application of dry film thicknesses in excess of 200 microns (8 mils). The recommended total system DFT is 150-200 microns (6-8 mils), applied as one 150-200 micron coat or two 75-100 micron (3-4 mil) coats.

Apply in good weather. The minimum temperature of 10°C (50°F) must be maintained throughout the application and for a minimum period of 48 hours after application of the final coat of the system. Interline 994 should be brought up to 15°C (59°F) 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 datasheet.

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

Food Contact - FDA Compliant in accordance with section 175.300 of the Code of Federal Regulations for tanks of capacity greater than 530,000 US Gallons (2006 cubic metres).

Note: VOC values are typical and are provided for guidance purpose only. These may be subject to variation depending on factors such as differences in colour and normal manufacturing tolerances.

Low molecular weight reactive additives, which will form part of the film during normal ambient cure conditions, will also affect VOC values determined using EPA Method 24.

SYSTEMS COMPATIBILITY

Interline 994 will normally be applied to correctly prepared steel substrates.

Interline 994 should only be overcoated with itself.

ADDITIONAL INFORMATION

Further information regarding industry standards, terms and abbreviations used in this data sheet can be found in the following documents available at www.international-pc.com:

- Definitions & Abbreviations
- Surface Preparation
- Paint Application
- Theoretical & Practical Coverage

Individual copies of these information sections are available upon request.

SAFETY PRECAUTIONS

This product is intended for use only by professional applicators in industrial situations in accordance with the advice given on this sheet, the Material Safety Data Sheet and the container(s), and should not be used without reference to the Material Safety Data Sheet (MSDS) which International Protective Coatings has provided to its customers.

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.

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.

If in doubt regarding the suitability of use of this product, consult International Protective Coatings for further advice.

PACK SIZE	Unit Size	Part A		Part B	
		Vol	Pack	Vol	Pack
	20 litre	17.56 litre	20 litre	2.38 litre	2.5 litre
	5 US gal	3.52 US gal	5 US gal	0.48 US gal	0.5 US gal
For availability of other pack sizes, contact International Protective Coatings.					
SHIPPING WEIGHT	Unit Size	Part A		Part B	
	20 litre	31.17 kg		2.29 kg	
	5 US gal	54.6 lb		4.5 lb	
STORAGE	Shelf Life	Part A - 12 months minimum at 25°C (77°F). Part B - 18 months minimum at 25°C (77°F). Subject to re-inspection thereafter. Store in dry, shaded conditions away from sources of heat and ignition.			

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 International Paint representative that this data sheet is current prior to using the product.

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