Interline 925

Epoxy Tank Coating

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

INTENDED USES

A high performance potable water tank coating which can also be used in ballast tanks, void spaces, cofferdams and wet spaces.
For use at Newbuilding or Maintenance & Repair.

Certified to ANSI/NSF Standard 61.
NSF Certification is for tanks greater than 1,000 gallons

PRODUCT INFORMATION

Colour	THA125/THA127-White, THA125/THA126-Cream (Rest of World) 925A/92510B-White, 925A/92503B-Cream (USA)
Finish/Sheen	Gloss (ISO 2813 : 1978)
Converter/Curing Agent	THA126, THA127, 92510B, 92503B
Volume Solids	100% (ISO 3233:1998)
Mix Ratio	3 volumes Part A to 1 volume Part B
Typical Film Thickness	300 microns dry (300 microns wet) . NSF approval is based on 450 microns dry.
Theoretical Coverage	3.33 (m^2/lt) at 300 microns dft, allow appropriate loss factors
Method of Application	Airless Spray, Brush, Roller
Flash Point	Part A >101°C ; Part B >101°C ; Mixed >101°C

Drying Information

	10ºC	15ºC	25ºC	35ºC
Touch Dry [ISO 1517:73]	15hrs	12hrs	8hrs	5hrs
Hard Dry [ISO 9117:90]	36hrs	24hrs	18hrs	8hrs
Pot Life	2hrs	90mins	60mins	45mins

Overcoating Data - see limitations

	Substrate Temperature							
	10ºC		15ºC		25ºC		35ºC	
Overcoated By	Min	Max	Min	Max	Min	Max	Min	Max
Interline 925	36hrs	5days	24hrs	4days	18hrs	3days	8hrs	24hrs

Note: When used in non-marine applications, different overcoating intervals apply - refer to the International Protective Coatings Interline 925 datasheet.

REGULATORY DATA

VOC	0 g/lt (0.00 lb/US Gal) calculated 0 g/lt as supplied (PG6/23:1997)

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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 - Certification for tanks greater than 1,000 gallons (ANSI Standard 61)
- Potable Water - Offshore installations (Norwegian National Institute of Public Health)
- Potable Water - Compliant with The Vessel Sanitation Programme (VSP) Construction Guidelines

Consult your International Representative for details.

SYSTEMS AND COMPATIBILITY

Consult your International Representative for the system best suited for the surfaces to be protected.
When using in ballast, potable or grey water tanks, consult the Interline 925 Ballast, Potable or Grey Water Tanks 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.
Welds and damaged areas should be blast cleaned to Sa2½ (ISO 8501-1:1988). Intact shop primer should be prepared by sweep blasting to International standard AS3 or by power tooling to Pt3 (JSRA SSPC:1984).
For PVB and unapproved shop primers, the surface should be blast cleaned to Sa2½ (ISO 8501-1:1988)
NOTE
For potable water tanks, the entire tank must be blast cleaned to a minimum of Sa2½ (ISO 8501-1:1988).

MAJOR REFURBISHMENT
Abrasive blast clean to Sa2½ (ISO 8501-1:1988). If oxidation has occurred between blasting and application of Interline 925, the surface should be reblasted to the specified visual standard. Surface defects revealed by the blast cleaning process, should be ground, filled, or treated in the appropriate manner.

REPAIR
Consult International.

Consult your International 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 8501-1:1988)

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.
Airless Spray	Recommended. - Tip range 0.53 - 0.64mm (21-25 thou) - Total output fluid pressure at spray tip not less than 211 kg/cm² (3000 p.s.i.) 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 GTA822 or GTA415 (USA)
Work Stoppages and Cleanup	Do not allow material to remain in hoses, gun or spray equipment. Thoroughly flush all equipment with International GTA822 or GTA415 (USA). 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 GTA822 or GTA415 (USA). 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 (see page 4 of Data Sheet)

LIMITATIONS

This product will not cure adequately below 10°C (50°F). For maximum performance ambient curing temperatures should be above 10°C (50°F).
For maximum relative humidity, see detailed coating procedure. Consult International.
The drying times and overcoating intervals may alter due to various on-site factors such as tank configuration and ventilation rates.
For minimum cure time prior to flooding coated tanks, consult the detailed coating application procedures.
At ambient temperatures below 30°C (86°F) an in-line heater or hot twin feed unit is needed to assist application. Consult International for detailed instructions.
Due to the presence of low molecular weight chemicals in the formulation, some VOC may be recorded when this product is tested in accordance with EPA Method 24 or UK-PG6/23:1997. This is due to the high temperatures used in these test 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 Representative for specific recommendations.
Apply in good weather. Temperature of the surface to be coated must be at least 3°C (5°F) above the dew point.
For optimum application properties bring the material to 30-35°C (86-95°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 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

20 litre unit: Interline 925, Part A, 15 litres in a 20 litre container and Part B, 5 litre in a 5 litre container.
4 US gallon unit: Interline 925, Part A, 3 US gallons in a 5 US gallon container and Part B, 1 US gallon in a 1 US gallon container.
For availability of other unit sizes consult International.

UNIT SHIPPING WEIGHT

20 litre unit: 33 kg
4 US gallon unit : 55.3 lb

STORAGE

Shelf Life
12 months minimum at 25°C (77°F). Subject to re-inspection thereafter. Store in dry, shaded conditions away from sources of heat and ignition.

WORLDWIDE AVAILABILITY

Consult International.

DISCLAIMER

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 his own risk. All advice we give 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 standard terms and 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 that this data sheet is current prior to using the product. It is the user's responsibility to check with his local International representative that this data sheet is current prior to using the product.

Regional Addresses

Head Office	European Region	Asia Region	Australasia Region	North American Region	South American Region
International Coatings Ltd	International Coatings Ltd	International Coatings Pte Ltd	Akzo Nobel Pty Limited	International Paint Inc	Akzo Nobel Coatings Ltd
Oriel House	Stoneygate Lane	3 Neythal Road	115 Hyde Road	6001 Antoine Drive	Av. Paiva 999 - Neves
16 Connaught Place	Felling, Gateshead	Jurong Town	Yeronga, Brisbane	Houston	Sao Goncalo/RJ
London W2 2ZB	Tyne & Wear NE10 0JY	Singapore 628570	Queensland 4104	Texas 77091	24426-140
United Kingdom	United Kingdom		Australia	United States of America	Brazil
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