

Epoxy Phenolic

PRODUCT DESCRIPTION	A light coloured, solvent free, tar free, two pack epoxy phenolic cargo tank coating.			
INTENDED USES	A high performance, solvent free coating system for fuel carriage, crude oil and white oil carriage and for use in potable water tanks. For use at Newbuilding or Maintenance & Repair.			
PRODUCT INFORMATION	Colour	THA645-Grey, THA646-Buff		
	Finish/Sheen	Gloss		
	Part B (Curing Agent)	THA647		
	Volume Solids	95% ±2% (ISO 3233:1998)		
	Mix Ratio	4 volume(s) Part A to 1 volume(s) Part B		
	Typical Film Thickness	175 microns dry (184 microns wet) For additional scheme information refer to the Interline 644 Application Guideline		
	Theoretical Coverage	5.43 m ² /litre at 175 microns dft, allow appropriate loss factors		
	Method of Application	Plural Feed Airless Spray, Airless Spray, Brush, Roller		
	Flash Point (Typical)	Part A 83°C; Part B 110°C; Mixed 83°C		
	Induction Period	Not required		

Drying Information	10°C	15°C	25°C	35°C
Touch Dry [ISO 9117/3:2010]	18 hrs	12 hrs	5 hrs	3 hrs
Hard Dry [ISO 9117-1:2009]	40 hrs	30 hrs	16 hrs	6 hrs
Pot Life	50 mins		30 mins	15 mins

Note Pot life at a temperature of 10°C is for information only. Recommended mixed paint temperature prior to application is 25°C minimum. See also Mixing information on page 2.

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 644	40 hrs	14 days	30 hrs	14 days	18 hrs	14 days	8 hrs	14 days

REGULATORY DATA	VOC	98 g/lit (0.82 lb/US Gal) as supplied (EPA Method 24) 110 g/kg of liquid paint as supplied. EU Solvent Emissions Directive (Council Directive 1999/13/EC)
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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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SYSTEMS AND COMPATIBILITY

Consult your International Paint representative for the system best suited for the surfaces to be protected.

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/MAJOR REFURBISHMENT

Abrasive blast clean to Sa2½ (ISO 8501-1:2007). If oxidation has occurred between blasting and application of Interline 644, the surface should be reblasted to the specified visual standard.

Surface defects revealed by the blast cleaning process, should be ground, welded, or treated in the appropriate manner.

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

For all shop primers, the surface should be blast cleaned to Sa2½ (ISO 8501-1:2007).

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

REPAIR

Consult International Paint.

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)

MIXING OF PRODUCT PRIOR TO APPLICATION

Single Feed

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) The temperature of Part A and Part B prior to mixing should be 25°C. Higher component temperatures will reduce the working pot life of product. If the temperature of the two components exceeds 30°C then it is recommended that plural component airless spray equipment is used.

(2) Agitate Base (Part A) with a power agitator

(3) Agitate Curing Agent (Part B) with a power agitator

(4) Combine entire contents of Curing Agent (Part B) with Base (Part A) and mix thoroughly with a power agitator.

(5) Use promptly and within the pot life specified

Plural Feed

(1) Base (Part A) and Curing Agent (Part B) are not mixed before application

(2) Base (Part A) to be circulated through the spray unit, heating with in-line heaters, until it has reached 30°C

(3) Curing Agent (Part B) to remain at ambient temperature

WELDING OR FLAME CUTTING ON METAL COATED WITH Interline 644

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."

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APPLICATION

Mixing	For information on mixing see page 2.
Thinner	Do not thin.
Airless Spray	<p>Ensure spray gun is rated beyond the maximum fluid outlet pressure of the pump to be used.</p> <p>Single Feed</p> <ul style="list-style-type: none">- Tip range 0.015" - 0.021" (381-530 microns). Smaller tip gives better film thickness control- Total output fluid pressure at spray tip not less than 5000 p.s.i. (352 kg/cm²) <p>Pump Ratio 70:1</p> <p>It is recommended that an in-line heater is installed as close to the pump fluid outlet as possible. This will allow the operator to use heat to improve flow of material through long paint hoses. The heater should be set to achieve a paint temperature at the gun of 28-32°C. Do not have the in-line heater set too high.</p> <p>It is recommended that the hose length is kept to a minimum and should not exceed 150ft (46m). Best results are obtained with 3/8" (9.5 mm) ID paint hose and 1/4" (6.4 mm) ID whip end.</p> <p>Plural Feed</p> <ul style="list-style-type: none">- Tip range 0.015" - 0.021" (381-530 microns). Smaller tip gives better film thickness control- Total output fluid pressure at spray tip not less than 3500 p.s.i. (246 kg/cm²)- Base to be recirculated through the spray unit, using in-line heater, to heat to 30°C- Curing Agent to remain at ambient temperature- Mixed paint line to be kept as short as possible <p>When using plural component spray equipment it is important to ensure an adequate supply of both components to the main proportioning unit. If feeder pumps are employed, they should be carefully set in order to maintain the supply of Part A and Part B and to prevent cavitation in the feeder hoses. Failure to do this will result in an incorrect mix ratio. Correct proportioning should always be checked using the method recommended by the equipment supplier.</p>
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
Work Stoppages and Cleanup	<p>Do not allow material to remain in hoses, gun or spray equipment. Thoroughly flush all equipment with International GTA822. 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.</p> <p>Clean all equipment immediately after use with International GTA822. 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.</p> <p>All surplus materials and empty containers should be disposed of in accordance with appropriate regional regulations/legislation.</p> <p>For plural component application it is important to flush out the in-line static mixer, mixed paint hose and gun during stoppages greater than 10 minutes.</p>
Welding	For information on welding see page 2.

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.

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

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LIMITATIONS

At ambient temperatures below 25°C paint lines must be lagged.

This product will not cure adequately below 10°C.

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

Consult your International Paint representative for the time interval required between coating completion and first cargo loading.

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 25°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

For availability of other unit sizes consult International Paint

UNIT SHIPPING WEIGHT (TYPICAL)	Unit Size	Unit Weight
	20 lt	30.85 Kg

STORAGE	Shelf Life	Part A - 12 months at 25°C. Storage for long periods at temperatures greater than 25°C may result in poor spray properties. Part B - 12 months at 25°C

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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