Interline® 984C

Epoxy Phenolic

PRODUCT DESCRIPTION

A two component, chemically resistant, 100% solids, high build epoxy phenolic tank lining providing static dissipation properties.

INTENDED USES

To provide corrosion protection to the internals of steel storage tanks containing flammable cargoes where conductivity of static charge is required to reduce the risk of explosion.

Chemically resistant to most hydrocarbon fuels as well as ethanol making it suitable for biofuels containing any concentration of ethanol.

Suitable for storage of crude oil at elevated temperatures.

PRACTICAL INFORMATION FOR INTERLINE 984C

Colour	Black
Gloss Level	Not applicable
Volume Solids	100%
Typical Thickness	400-1000 microns (16-40 mils) for use as a single coat on tank floors. Thickness is dependent upon application method and specification.
Theoretical Coverage	2 m²/litre at 500 microns d.f.t and stated volume solids 80 sq.ft/US gallon at 20 mils d.f.t and stated volume solids
Practical Coverage	Allow appropriate loss factors
Method of Application	Plural Component Airless Spray, Airless spray

Drying Time

			Overcoating interval with self	
Temperature	**Touch Dry**	**Hard Dry**	*Minimum*	*Maximum*
10°C (50°F)	10 hours	36 hours	36 hours	28 days[1]
15°C (59°F)	9 hours	20 hours	20 hours	28 days[1]
25°C (77°F)	6 hours	12 hours	12 hours	28 days[1]
40°C (104°F)	2 hours	5 hours	5 hours	14 days[1]

[1] The values quoted relate to use within an enclosed tank environment. For situations where UV exposure between coats is likely, maximum overcoating intervals will be shorter. Contact International Protective Coatings for more details.

REGULATORY DATA

Flash Point (Typical)	Part A >101°C (214°F); Part B 49°C (120°F); Mixed 75°C (167°F)	
Product Weight	1.3 kg/l (10.8 lb/gal)	
VOC	0.23 lb/gal (28 g/lt) 84 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 and grease should be removed in accordance with SSPC-SP-1 solvent cleaning.

Steel

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 984C 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.

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.

Mix Ratio

2 part(s):1 part(s) by volume

Working Pot Life

10°C (50°F)	15°C (59°F)	25°C (77°F)	40°C (104°F)
60 minutes	50 minutes	30 minutes	15 minutes

Plural Component Airless Spray	Suitable	See Product Characteristics
Airless Spray	Recommended	Tip Range 0.53-0.68 mm (21-27 thou) Total output fluid pressure at spray tip not less than 211 kg/cm² (3000 p.s.i.)
Brush	Suitable	Small areas only. Typically 150-200 microns (6.0-8.0 mils) can be achieved.
Roller	Suitable	Small areas only. Typically 150-200 microns (6.0-8.0 mils) can be achieved.

Thinner

- **DO NOT THIN**

Cleaner

International GTA853/
International GTA415

Work Stoppages

Do not allow material to remain in hoses, gun or spray equipment. Thoroughly flush all equipment with International 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 Up

Clean all equipment immediately after use with International 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.

All surplus materials and empty containers should be disposed of in accordance with appropriate regional regulations/legislation.

Epoxy Phenolic

PRODUCT CHARACTERISTICS

The detailed Interline 984C Application Guidelines should be consulted prior to use.

This datasheet provides general guidance on the use of Interline 984C. Specific project requirements will be dependent upon the service end use and operating conditions. Always consult International Protective Coatings to confirm that Interline 984C is suitable for contact with the product to be stored.

The detailed project coating specification provided by International Protective Coatings must be followed at all times. Exact specification for total dry film thickness and number of coats will be dependent upon service end use requirements. Consult International Protective Coatings for specific advice.

Application should not take place when relative humidity is more than 80% or when surface temperature is less than 3K (3ºC/5ºF) above the dew point. Do not apply at steel temperatures below 10°C (50°F).

Apply by airless spray only. Application by other methods, e.g. brush or roller, may require more than one coat and is suggested for small areas only or initial stripe coating.

Interline 984C can be applied by standard 63:1 ratio airless spray equipment, depending on the line dimensions; please refer to the Interline 984C Application Guidelines. An in-line heater of a suitable pressure rating may be used to assist with pumping and atomisation of the product. Additionally, Interline 984C is suitable for application by plural component airless spray equipment capable of accurate proportioning.

Heavily pitted areas should be stripe coated by brush, to ensure good "wetting" of the surface.

Exposure to unacceptably low temperatures and/or high humidities during or immediately after application may result in incomplete cure and surface contamination that could jeopardise subsequent intercoat adhesion.

After the last coat has cured hard, the coating system dry film thickness should be measured using a suitable non-destructive magnetic gauge to verify the average total applied system thickness. The coating system should be free of all pinholes or other holidays and verified using a suitable method as recommended in the Interline 984C Application Guidelines. The cured film should be essentially free of runs, sags, drips, inclusions or other defects. All deficiencies and defects should be corrected. The repaired areas shall be retested and allowed to cure as specified before placing the finished lining into service. Consult International Protective Coatings Interline 984C Application Guidelines for detailed repair procedures.

For storage of cargoes above ambient temperatures, consult International Protective Coatings for further details.

In common with all epoxies Interline 984C will chalk and discolour on exterior exposure. However, these phenomena are not detrimental to anti-corrosive performance.

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 984C is only applied directly to correctly prepared steel.

Interline 984C 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
	18 litre	12 litre	20 litre	6 litre	10 litre
	For availability of other pack sizes, contact International Protective Coatings.				
SHIPPING WEIGHT (TYPICAL)	Unit Size	Part A		Part B	
	18 litre	17.48 kg		8.73 kg	
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.			

Important Note

www.international-pc.com