

Interline 850

Epoxy Phenolic



Product Description A two component, chemically resistant, high solids, high build epoxy phenolic tank lining.

Intended Uses To provide corrosion protection for the internals of steel storage tanks containing a range of products, including crude oil, unleaded gasoline blends, MTBE, jet fuels, caustic solutions, potable water and a selected range of aromatic and aliphatic solvents.



Certified to ANSI/NSF Standard 61. NSF Certification is for tanks greater than 500 gallons.

Practical Information for Interline 850

Colour	Buff, White & Grey
Gloss Level	Not applicable
Volume Solids	76%
Typical Thickness	100-150 microns (4-6 mils) dry equivalent to 132-197 microns (5.3-7.9 mils) wet
Theoretical Coverage	6.1 m ² /litre at 125 microns d.f.t and stated volume solids 244 sq.ft/US gallon at 5 mils d.f.t and stated volume solids
Practical Coverage	Allow appropriate loss factors
Method of Application	Airless spray, Air spray, Brush, Roller
Drying Time	

Temperature	Touch Dry	Hard Dry	Overcoating Interval with Interline 850 with Self	
			<i>Minimum</i>	<i>Maximum</i>
10°C (50°F)	9 hours	24 hours	24 hours	30 days
15°C (59°F)	8 hours	20 hours	20 hours	30 days
25°C (77°F)	5 hours	8 hours	8 hours	30 days
40°C (104°F)	3 hours	5 hours	5 hours	21 days

Regulatory Data

Flash Point	Base (Part A) 42°C (108°F)	C/A (Part B) 54°C (129°F)	Mixed 43°C (109°F)
Product Weight	1.54 kg/l (12.85 lb/gal)		
VOC	212 g/l	UK - PG6/23(92), Appendix 3	
	1.88 lb/gal (225 g/l)	USA - EPA Method 24	



Ecotech is an initiative by International Protective Coatings a world leader in coating technology to promote the use of environmentally sensitive products across the globe.

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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 8504:1992.

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 a minimum of Sa2½ (ISO 8501-1:1988) or SSPC-SP10.

A sharp, angular surface profile of 50-75 microns (2-3 mils) 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.

Where local VOC regulations allow, surfaces may be primed with Interline 850 (thinned 10-15% GTA420) to 40 microns (1.5 mils) dry film thickness before oxidation occurs. Alternatively, the blast standard can be maintained by use of dehumidification.

Areas of breakdown, damage, weld seams etc., should be prepared to the specified standard (e.g. Sa2½ (ISO 8501-1:1988) or SSPC SP10 or power tool cleaned to Pt3 (JSRA SPSS:1984) or SSPC SP11).

Application

Mixing

Interline 850 must be applied in accordance with the Interline 850 system sheet and the detailed International Protective Coatings Recommended Working Procedures for application of Tank Linings.

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

Mix Ratio

4 parts : 1 part by volume

Working Pot Life

10°C (50°F)	15°C (59°F)	25°C (77°F)	40°C (104°F)
3 hours	2 hours	1 hour	30 minutes

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/cm² (2,500 p.s.i.)

Air Spray (Pressure Pot)

Recommended Gun DeVilbiss MBC or JGA
Air cap 704 or 765
Fluid Tip E

Brush

Recommended - Typically 50-75 microns (2-3 mils) can be achieved
Small areas only

Roller

Recommended - Typically 50-75 microns (2-3 mils) can be achieved
Small areas only

Thinner

International GTA420 Do not thin more than allowed by local
(or GTA415) environmental legislation.

Cleaner

International GTA853
(or 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.

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Product

Characteristics

The detailed Interline 850 Working Procedures should be consulted prior to use.

Interline 850 is typically specified as a two coat system at 125 µm (5 mils) per coat to give a total coating system dry film thickness of 250 microns (10 mils). Exact specification for total dry film thickness will be dependent upon service and use requirements. Consult International Protective Coatings for specific advise regarding tank lining application.

When used as a primer coat applied at 40 microns (1.5 mils) dry film thickness Interline 850 can hold a blast for up to 28 days in the semi-protected environment of a tank interior. If moisture is present on the surface, oxidation will occur and reblasting will be required. As an alternative, a full coat may be applied, provided the overcoating intervals are adhered to and all surfaces are correctly cleaned and prepared prior to overcoating with Interline 850.

For potable water service, consult International Protective Coatings with regards to permissible thinning levels.

At temperatures below 15°C (59°F), it is recommended that Interline 850 is allowed a 15 minute induction period after mixing, prior to commencing application.

Maximum film build in one coat is best attained by airless spray. When applying by methods other than airless spray, the required film build is unlikely to be achieved. Application by air spray may require a multiple cross spray pattern to attain optimum film build. The use of other methods, e.g. brush or roller, may require more than one coat and are suggested only for small areas, or initial stripe coating.

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

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

For general use, it is not recommended to apply Interline 850 at steel temperatures below 10°C (50°F). However for potable water storage only, Interline 850 may be applied at steel temperatures of 5°C (41°F) and above. Consult International Protective Coatings for specific cure schedules.

When applying Interline 850 in confined spaces ensure adequate ventilation.

For multi-coat applications, exposure to low temperatures during, or immediately after application may result in incomplete cure and surface contamination that could jeopardise subsequent intercoat adhesion.

This product severely yellows when exposed to sunlight and should not be used on exteriors where colour is important.

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. 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 Tank Linings Working Procedures for proper repair procedures.

Maximum chemical resistance is not attained until the film has completely cured. Cure is a function of temperature, humidity and film thickness. Normally films at 250 microns (10 mils) total system dry film thickness will exhibit full and complete cure for optimal chemical resistance in 7-10 days at 25°C (77°F) and 50% relative humidity. Curing times are proportionately shorter at elevated temperatures and longer at lower temperatures.

Interline 850 is not recommended for storage of aqueous media at temperatures in excess of 60°C (140°F).

Interline 850 is not suitable for exposure to acidic conditions.

This product has the following specification approvals :

Air BP Specification F2D2 Section 2.1 - Tank Linings.

US Military Specification MIL-PRF-4556F (Buff and White colours only).

DEF stan 80-97 for the lining of bulk aviation fuel tanks.

Certified to ANSI/NSF Standard 61. NSF certification is for tanks greater than 500 gallon, pipes 25 inches in diameter or greater and for valves 2 inches in diameter or greater.

Norwegian National Institute of Public Health for use in Potable Water Tanks on Offshore Installations.

Meets permissible levels of extractable materials as stated in CFR21-175.300 (Micro Materials Report).

Consult International Protective Coatings for specific approved specifications.

Systems

Compatibility

This system is self-priming and is not suitable for application over other primers. Interline 850 should only be topcoated with itself, and should never be overcoated with another product.

Interline 982 can be used as a holding primer in certain situations. Consult International Protective Coatings for specific recommendations.

Consult International Protective Coatings to confirm that Interline 850 is suitable for contact with the product to be stored.

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Additional Information

Further information regarding industry standards, terms and abbreviations used in this data sheet can be found in the following sections of the International Protective Coatings data manual:

- Definitions & Abbreviations
- Surface Preparation
- Paint Application
- Theoretical & Practical Coverage
- Interline 850 Recommended Working Procedures

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	20 litre unit	Interline 850 Base	16 litres in a 20 litre container
		Interline 850 Curing Agent	4 litres in a 5 litre container
	5 gallon unit	Interline 850 Base	4 gallons in a 5 gallon container
		Interline 850 Curing Agent	1 gallon in a 1 gallon container
For availability of other pack sizes contact International Protective Coatings			
Shipping Weight	U.N. Shipping No. 1263		
	20 litre unit	29.0 kg (63.9 lb) Base (Part A)	4.3 kg (9.5 lb) Curing Agent (Part B)
	5 gallon unit	27.3 kg (60.4 lb) Base (Part A)	3.9 kg (8.7 lb) Curing Agent (Part B)
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.	

Disclaimer

The information given in this sheet is not intended to be exhaustive and any person using the product for any purpose other than that specifically recommended in this 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. Any warranty, if given, or specific Terms & Conditions of Sale are contained in International's Terms & Conditions of Sale, a copy of which can be obtained on request. Whilst we endeavour to ensure that all advice we give about the product (whether in this sheet or otherwise) is correct we have no control over either the quality or 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 whatsoever or howsoever arising for the performance of the product or for any loss or damage (other than death or personal injury resulting from our negligence) arising out of the use of the product. The information contained in this sheet is liable to modification from time to time in the light of experience and our policy of continuous product development.

It is the user's responsibility to check that this sheet is current prior to using the product. Issue date: 18/10/2002

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International Protective Coatings

Worldwide Availability

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