

PRODUCT DESCRIPTION

A two component, heavy duty vinyl ester coating reinforced with glass flake to increase chemical and abrasion resistance.

A chemically resistant, vinyl ester coating which can be applied using standard airless spray equipment at material temperatures up to 95°F (35°C).

INTENDED USES

Interline 955 is primarily intended for the internal lining of chemical storage tanks and vessels where acidic chemicals or hot media are to be stored at temperatures up to 194°F (90°C).

Interline 955 has also found extensive use in a number of industry sectors, including refineries, pulp and paper plants and chemical plants where it has been widely used for coating steelwork in corrosive environments where frequent contact with aggressive chemicals, e.g. acids is likely to occur. Interline 955 is also suitable for application in areas where exposures to dry temperatures up to 266°F (130°C) are encountered.

PRACTICAL INFORMATION FOR INTERLINE 955

Color	White, Buff
Gloss Level	Semi Gloss
Volume Solids	100% reactive, although determined volume solids depends upon the application conditions. A recommended working figure is 85%.
Typical Thickness	16-24 mils (400-600 microns) dry equivalent to 18.8-28.2 mils (471-706 microns) wetbased on 85% volume solids
Theoretical Coverage	85 sq.ft/US gallon at 16 mils d.f.t and 85% volume solids 2.10 m ² /litre at 400 microns d.f.t and 85% volume solids
Practical Coverage	Allow appropriate loss factors
Method of Application	Airless Spray, Brush

Drying Time

Temperature	Touch Dry	Hard Dry	Overcoating Interval with recommended topcoats	
			Minimum	Maximum
50°F (10°C)	5 hours	6 hours	6 hours	3 days
59°F (15°C)	4 hours	5 hours	5 hours	3 days
77°F (25°C)	4 hours	5 hours	5 hours	2 days
95°F (35°C)	4 hours	5 hours	5 hours	24 hours

These dry times have been obtained using the recommended amount of retarder for each temperature (see Product Characteristics).

REGULATORY DATA **Flash Point (Typical)** Part A 90°F (32°C); Part B 212°F (100°C); Mixed 90°F (32°C)

Product Weight 10.0 lb/gal (1.2 kg/l)

VOC 29 g/kg 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.

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

Abrasive Blast

Abrasive blast clean to SSPC SP10 or Sa2½ (ISO 8501-1:2007). If oxidation has occurred between blasting and application of Interline 955, 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.

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

If a holding primer is required for Interline 955 then the use of Interline 949 is advised (see system compatibility). Alternatively, the blast standard can be maintained by the use of dehumidification.

Shop Primed Steel

Prior to application of Interline 955, all shop primed steelwork must be re-blasted to a visual standard as outlined above.

APPLICATION

Mixing	<p>Interline 955 must be applied in accordance with the detailed International Protective Coatings Working Procedures for the application of Tank Linings.</p> <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>An optional retarder solution is available for this material. (See Product Characteristics for details.)</p>			
Mix Ratio	98 part(s) : 2 part(s) by volume			
Working Pot Life	50°F (10°C)	59°F (15°C)	77°F (25°C)	95°F (35°C)
	1 hour	1 hour	40 minutes	40 minutes
Airless Spray	Recommended	Tip Range 25-35 thou (0.63-0.89 mm) Total output fluid pressure at spray tip not less than 3000 psi (211 kg/cm ²)		
Air Spray (Pressure Pot)	Not recommended			
Brush	Suitable - Small areas only Typically 3.0 mils (75 microns) can be achieved			
Roller	Not recommended			
Thinner	Not suitable	DO NOT THIN		
Cleaner	International GTA853	N.B. Clean all equipment immediately after use.		
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 GTA415. It is good working practice to periodically flush out spray equipment during the course of the working day. Frequency of cleaning should be once every hour using GTA415 cooled to <59°F (15°C). All surplus materials and empty containers should be disposed of in accordance with appropriate regional regulations/legislation.			

PRODUCT CHARACTERISTICS

The detailed Interline 955 Application Guidelines should be consulted prior to use.

Elevated storage temperatures reduce shelf life. Uncatalyzed Interline 955 is stable for 6 months from date of manufacture when stored below 68°F (20°C) in its original sealed containers. Interline 955 should never be stored in direct sunlight. It is recommended that material temperatures be kept as low as possible via refrigeration if necessary in order to prolong shelf life and ensure a 1 hour pot life during airless spray application. It is important to take into consideration that material temperatures will increase following mixing. A recommended storage temperature range is 46°F-66°F (8°C-19°C).

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.

This product must **not** be thinned as the use of thinners may severely inhibit the curing mechanism of the coating.

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

Maximum steel temperature at the time of application is 140°F (60°C) and maximum relative humidity during the application and cure period is 80%.

Interline 955 must be specified as a minimum of 2 coats at 16 mils (400 microns) per coat to give a total dry film thickness of not less than 32 mils (800 microns) in order to achieve optimum performance.

Interline 955 can be applied in a wide range of climatic conditions, including material temperatures up to 95°F (35°C). However, at material temperatures greater than 77°F (25°C) the use of a retarder solution is required in order to maintain the working pot life, allowing normal airless spray methods to be employed. The recommended level of retarder solution is as follows:-

<77°F (25°C)	No retarder required
77-95°F (25-35°C)	1 unit of retarder required.

The retarder solution must always be added to the base prior to the addition of the initiator and mixed thoroughly using a power agitator. Where material temperatures are consistently high, i.e. >95°F (35°C), material should be refrigerated, consult International Protective Coatings for specific advice.

Although Interline 955 is 100% reactive, depending upon the application conditions, the practical volume solids may be lower and International Protective Coatings suggest a value of 85% for estimating spreading rate.

This product will not cure adequately below 41°F (5°C). For maximum performance ambient curing temperatures should be above 59°F (15°C).

Maximum continuous dry temperature resistance for Interline 955 is 266°F (130°C).

Maximum temperature in immersed conditions for Interline 955 is 194°F (90°C).

Consult International Protective Coatings for temperature limits for specific cargoes.

Interline 955 is not intended to be used as a cosmetic finish and color stability will not be achievable.

For storage of inorganic or organic acids, consult International Protective Coatings for specific advice on cargo compatibility, suitable painting schemes and procedures.

When surface temperatures exceed 95°F (35°C), or when exposed to direct sunlight, Interline 955 should be overcoated as soon as hard dry to avoid intercoat adhesion problems.

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 color and normal manufacturing tolerances.

SYSTEMS COMPATIBILITY

Interline 955 can be applied directly to correctly prepared bare steel. However, it is suitable for application over the following primer:

Interline 949

This product is not recommended to be topcoated other than by:

Interline 955

For additional information, consult International Protective Coatings.

Consult International Protective Coatings to confirm that Interline 955 is suitable for contact with the product to be stored.

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
- Interline 955 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. All work involving the application and use of this product should be performed in compliance with all relevant national Health, Safety and Environmental standards, regulations and legislation.

Proper ventilation must be provided during application and afterwards during drying (Refer to product datasheets for typical drying times) to keep solvent concentrations within safe limits and prevent fires and explosions. Forced extraction will be required in confined spaces. Ventilation and/or respiratory personal protective equipment (airfed hoods or appropriate cartridge masks) must be provided during application and drying. Take precautions to avoid skin and eye contact (overalls, gloves, goggles, masks, barrier cream, etc).

Before use, obtain, read and then follow the advice given on the Material Safety Data Sheets (Base and Curing Agent if two-pack) and the Health and Safety section of the Coatings Applications Procedures for this product.

In the event that 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.

The detailed safety measures are dependent on application methods and the work environment. If you do not fully understand these warnings and instructions or if you cannot strictly comply with them, do not use the product and consult International Protective Coatings.

PACK SIZE	Unit Size	Part A		Part B	
		Vol	Pack	Vol	Pack
	20 liter	19.6 liter	20 liter	0.4 liter	0.5 liter
The optional retarder solution is available as 50ml in a 50ml container. For availability of other pack sizes contact International Protective Coatings					
SHIPPING WEIGHT (TYPICAL)	Unit Size	Part A	Part B		
	20 liter	25.3 kg	0.5 kg		
	U.N. Shipping No.	Part A - 1263	Part B - 5105		
STORAGE	Shelf Life	6 months minimum at <68°F (20°C). Subject to re-inspection thereafter. Store in dry, shaded conditions away from sources of heat and ignition. During storage and shipment, Interline 955 initiator must not be exposed to temperatures exceeding 30°C (90°F). Refrigeration recommended.			

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 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.

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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