

PRODUCT DESCRIPTION

A two component, solvent free epoxy caulking compound, for application with plural component airless spray equipment (Matcote® Process).

INTENDED USES

Interline 983 is suitable for use as a spray applied caulk for the treatment of weld seams, lap joints, rivets or other surface projections, to provide a smooth, uniform transition between surfaces prior to the application of a glass reinforced laminate system.

Used in conjunction with Interline 985 as part of the Interline Matcote® system with chopped glass fiber as a refurbishment system for corroded steel. May also be used as an adhesive for non-welding steel repairs.

PRACTICAL INFORMATION FOR INTERLINE 983

| | |
|------------------------------|--|
| Color | Blue |
| Gloss Level | Not applicable |
| Volume Solids | 100% |
| Typical Thickness | 40-80 mils (1000-2000 microns) dry equivalent to 40-80 mils (1000-2000 microns) wet Note: Actual application thickness is dependent upon the steel condition and configuration to be coated |
| Theoretical Coverage | 40 sq.ft/US gallon at 40 mils d.f.t and stated volume solids 1 m ² /liter at 1000 microns d.f.t and stated volume solids |
| Practical Coverage | Allow appropriate loss factors |
| Method of Application | Plural component airless spray (Matcote process), Trowel, Putty knife |

Drying Time

| Temperature | Touch Dry | Hard Dry | Overcoating Interval with recommended topcoats | |
|--------------|-----------|----------|--|----------|
| | | | Minimum | Maximum |
| 50°F (10°C) | 22 hours | 42 hours | 24 hours | 72 hours |
| 59°F (15°C) | 18 hours | 28 hours | 20 hours | 60 hours |
| 77°F (25°C) | 10 hours | 22 hours | 12 hours | 36 hours |
| 104°F (40°C) | 3 hours | 12 hours | 5 hours | 18 hours |

REGULATORY DATA

Flash Point Part A 214°F (101°C); Part B 214°F (101°C); Mixed 214°F (101°C)

Product Weight 10.3 lb/gal (1.2300 kg/l)

VOC 0 g/l (0.00 lb/gal) (Calculated)

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 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 SSPC-SP10 or Sa2½ (ISO 8501-1:2007).

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

Interline 983 must be applied before oxidation of the steel occurs. If oxidation does occur the entire oxidized area should be reblasted to the standard specified above.

Primed Surfaces

Where local VOC regulations allow, surfaces may be primed with Interline 982 to 0.5-1.0 mils (15-25 microns) dry film thickness before oxidation occurs. Alternatively, the blast standard can be maintained by use of dehumidification.

Interline 982 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.

APPLICATION

| | | | | |
|---------------------------------------|--|----------------------------|---------------------------|----------------------------|
| Mixing | Interline 983 must be applied in accordance with the detailed International Protective Coatings Working Procedures for the application of Tank Linings. | | | |
| | This material is supplied in full containers for use with plural component airless spray equipment. Once mixed, Interline 983 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) Add individual components to the appropriate hopper of the proportioning pump. | | | |
| Mix Ratio | 2 part(s) : 1 part(s) by volume | | | |
| Working Pot Life | 50°F (10°C) 4 hours | 59°F (15°C) 150 minutes | 77°F (25°C) 90 minutes | 104°F (40°C) 30 minutes |
| Plural component airless spray | Recommended | | | |
| Airless Spray | Not recommended | | | |
| Air Spray (Pressure Pot) | Not suitable | | | |
| Brush | Not suitable | | | |
| Roller | Not suitable | | | |
| Thinner | Not suitable | | - DO NOT THIN | |
| Cleaner | International GTA822 | | or International GTA415 | |
| Work Stoppages | Do not allow material to remain in hoses, gun or spray equipment. Release pressure from the material hose and thoroughly flush fluid line and spray gun with International GTA415. Do not re-pressurize equipment until ready to resume spraying operations, and ensure pot life limitations are adhered to. | | | |
| Clean Up | 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. | | | |
| | All surplus materials and empty containers should be disposed of in accordance with appropriate regional regulations/legislation. | | | |

PRODUCT CHARACTERISTICS

The detailed Interline 983 Working Procedures should be consulted prior to use.

Requires special airless spray equipment with heated tanks and hoses, and in-line mixing. Consult International Protective Coatings for availability of equipment and application specialist to assist with the application. Interline 983 is designed to be applied at the specified film thickness in a single coat, multiple pass application. Brush application should be used for stripe coats and touch-up only.

Prior to application, bring both components and the mixed paint to between 95°F (35°C) and 112°F (50°C).

Airless spray using heated plural component equipment. Recommended tip sizes 31-39 thou (0.79-0.99 mm). Caulk with Interline 983 to 40-80 mils (1000-2000 microns) dry film thickness. Interline 983 may be overcoated as long as it is "tack-free". Once the caulk has exceeded its maximum recoat interval, it must be sweep blasted to provide a physical "key" prior to being overcoated.

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

Do not apply at steel temperatures below 50°F (10°C).

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

The curing times will vary depending upon dry film thickness and conditions that exist during application and throughout curing periods.

This product severely yellows when exposed to sunlight, and should not be used on tank exteriors where color stability is important.

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 the USA-EPA Method 24 and UK-PG6/23(92), Appendix 3 protocols. This is due to the high temperatures used in the test procedures.

Note: VOC values quoted are based on maximum possible for the product taking into account variations due to color differences and normal manufacturing tolerances.

Low molecular weight reactive additives, which will form part of the film during normal ambient cure conditions, will also effect VOC values determined using EPA Method 24.

SYSTEMS COMPATIBILITY

The following primers are suitable for Interline 983:

Interline 982

This product is normally topcoated with itself or Interline 985, for other suitable primers/topcoats, consult International Protective Coatings.

Consult International Protective Coatings to confirm that Interline 983 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 985 Technical Specification for Glass Fibre Reinforced System

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 curing (refer to product datasheets for typical curing times) to ensure 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 curing. 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.

Warning: This product contains liquid epoxies and modified polyamines and may cause skin sensitization if not used correctly.

| PACK SIZE | Unit Size | Part A | | Part B | |
|--|------------|--|----------|----------|----------|
| | | Vol | Pack | Vol | Pack |
| | 60 liter | 40 liter | 20 liter | 20 liter | 20 liter |
| | 15 US gal | 10 US gal | 5 US gal | 5 US gal | 5 US gal |
| For availability of other pack sizes contact International Protective Coatings | | | | | |
| SHIPPING WEIGHT | Unit Size | Part A | | Part B | |
| | 60 liter | 55.2 kg | | 24.4 kg | |
| | 15 US gal | 114.2 lb | | 50.3 lb | |
| U.N. Shipping No. Non Hazardous (Base) : UN1760 (Curing Agent) | | | | | |
| STORAGE | Shelf Life | 18 months minimum at 77°F (25°C). 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. While we endeavor 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: 11/29/2011

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