

PRODUCT DESCRIPTION

A two component, solvent free epoxy tank lining to be applied by plural component airless spray. Used in conjunction with chopped glass fiber roving to form a glass reinforced system.

INTENDED USES

This product is part of the Interline Matcote® Process and is applied via simultaneous spraying of chopped glass fiber and resin.

To provide a lining system for the internals of new tanks and a refurbishment system for corroded storage tanks.

This is a proven tank lining system with excellent chemical resistance to a range of cargoes including crude oils, fuel oils, and white oils, and has an extensive 30 years track record.

PRACTICAL INFORMATION FOR INTERLINE 985

Color	Blue, White
Gloss Level	Not applicable
Volume Solids	100%
Typical Thickness	Laminate (glass fiber reinforced): 50-56 mils (1250-1400 microns) dry, equivalent to 50-56 mils (1250-1400 microns) wet, according to specification. Gel Coat: 10-20 mils (250-500 microns) dry, equivalent to 10-20 mils (250-500 microns) wet, according to specification.
Theoretical Coverage	Unreinforced: 115 sq.ft/US gallon at 14 mils d.f.t and stated volume solids 2.90 m ² /liter at 350 microns d.f.t and stated volume solids Laminate: Thickness and coverage are dependent upon the configuration of the surface to be coated.
Practical Coverage	Allow appropriate loss factors
Method of Application	Plural component airless spray (Matcote process), Brush, Roller

Drying Time

Temperature	Touch Dry	Hard Dry	Overcoating Interval with recommended topcoats	
			Minimum	Maximum
50°F (10°C)	18 hours	48 hours	48 hours	72 hours
59°F (15°C)	10 hours	30 hours	30 hours	48 hours
77°F (25°C)	7 hours	20 hours	20 hours	36 hours
104°F (40°C)	3 hours	6 hours	6 hours	16 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 (1.23 kg/l)	
VOC	1 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.

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 Sa2½ (ISO 8501-1:2007) or SSPC SP10. A sharp, angular surface profile of 3-4 mils (75-100 microns) is recommended.

Interline 985 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.

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 982 to 0.6-1.0 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.

Laminate Systems

Prior to application of the laminate all weld seams, lap joints, plate edges or other designated areas should be caulked using Interline 983. Please refer to Interline 985 Technical Specification for Glass Fibre Reinforced Systems.

Gel Coat Application

Prior to application of the gel coat, the entire surface to be coated should be abraded to remove any protruding fiberglass strands or other irregularities. The surface should then be vacuum cleaned.

APPLICATION

Mixing	Interline 985 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 985 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)	59°F (15°C)	77°F (25°C)	104°F (40°C)
	75 minutes	60 minutes	30 minutes	15 minutes
Plural component airless spray	Recommended			
Airless Spray	Not recommended			
Air Spray (Conventional)	Not suitable			
Brush	Suitable - Small areas only	Typically 6.0-8.0 mils (150-200 microns) can be achieved		
Roller	Suitable - Small areas only	Typically 6.0-8.0 mils (150-200 microns) can be achieved		
Thinner	Not suitable	- DO NOT THIN		
Cleaner	International GTA853	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 GTA415. 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 985 Working Procedures should be consulted prior to use. When utilizing Interline 985 as a glass fibre laminate system, please refer to the detailed Interline 985 Technical Specification for Glass Fibre Reinforced Systems. Exact specification for total dry film thickness and number of coats will be dependent upon the service end use requirements. Consult International Protective Coatings for specific advice regarding tank lining applications.

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 985 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.

Airless spray using heated plural component equipment capable of accurate proportioning. Recommended tip sizes are as follows: 27-36 thou (0.68-0.91 mm) for laminate application; 31-36 thou (0.79-0.91 mm) for gel coat application. Spray apply Interline 985 together with chopped International GQA015 fiberglass roving, then consolidate to a 50-56 mils (1250-1400 microns) dry film thickness laminate by rolling the mixture with a ribbed roller. Consult specified recoat minimum for application of gel coat [unreinforced 10-20 mils (250-500 microns) dry film thickness], giving an overall system minimum thickness of 60-76 mils (1500-1900 microns) dry film thickness.

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

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

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

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

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 and the coating system should be free of all pinholes or other holidays. Dry film thicknesses in excess of 20 mils (500 microns), can be checked using a suitable high voltage pulsating type holiday detector, set at 100 volts per mil (25 microns d.f.t.). Excessive voltage may produce a holiday in the coating film. 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 985 Working Procedures for detailed repair procedures.

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.

This product has the following specification approvals:

Chevron as an epoxy laminate lining (L31).

U.S. Department of Navy Specification NF95 13661 for fuel storage.

US Department of Defense citing good long term performance (Shell and Exxon).

In certain circumstances, Interline 985 may be used to produce fiberglass laminate by hand lay techniques. Consult International Protective Coatings for details.

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

Interline 985 can be applied directly to correctly prepared bare steel. However, it is suitable for application over the following primer:

Interline 982

Interline 985 can also be applied over Interline 983 caulk where this material has been specified.

The product is normally topcoated with itself. For other suitable primers/topcoats please consult International Protective Coatings.

Consult International Protective Coatings to confirm that Interline 985 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 Working Procedures
- Interline 985 Technical Specification for Glass Fibre Reinforced Systems

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	52.8 kg		27.2 kg	
	15 US gal	110.2 lb		56.4 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 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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