

Interline 967

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WORLD WIDE PRODUCT RANGE

Product Description

A two component, solvent free glass reinforced epoxy laminate system.

Intended Uses

For use in conjunction with glass fibre mat as a reinforced laminate, and as an unreinforced gel coat to provide a coating system for the refurbishment of corroded storage tank floors.

Also suitable for the extended protection of new tanks as a proven alternative to glass reinforced polyester laminate systems.

Interline 967 is designed for the protection of bulk storage tanks containing crude oils or white oil products.

Practical Information for Interline 967

Colour	Clear, Buff
Gloss Level	Not applicable
Volume Solids	100%
Typical Thickness	Laminate (glass fibre reinforced): 1,250-1,500 microns (50-60 mils) dry equivalent to 1,250-1,500 microns (50-60 mils) wet, according to specification. Gel Coat: 250-500 microns (10-20 mils) dry, equivalent to 250-500 microns (10-20 mils) wet, according to specification.
Theoretical Coverage	Gel Coat: 2.86 m ² /litre at stated volume solids and 350 microns d.f.t. 114 sq.ft/US gallon at stated volume solids and 14 mils d.f.t. Laminate: Thickness is dependent upon the configuration of the surface to be coated.
Practical Coverage	Allow appropriate loss factors
Method of Application	Airless spray, Roller

Drying Time

Temperature	Touch Dry	Hard Dry	Overcoating Interval with Interline 967 with Self	
			<i>Minimum</i>	<i>Maximum</i>
10°C (50°F)	18 hours	36 hours	36 hours	72 hours
15°C (59°F)	14 hours	24 hours	24 hours	60 hours
25°C (77°F)	8 hours	18 hours	18 hours	36 hours
40°C (104°F)	4 hours	8 hours	8 hours	24 hours

Regulatory Data

Flash Point	Base (Part A) >101°C (>214°F)	C/A (Part B) >101°C (>214°F)	Mixed >101°C (>214°F)
Product Weight	1.32 kg/l (11.02 lb/gal)		
VOC	0.00 g/l (Calculated)	UK - PG6/23(92), Appendix 3	
	0.00 lb/gal (0.00 g/l) (Calculated)	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 where required smooth weld seams and sharp edges.

Abrasive Blast Cleaning

This product must only be applied to surfaces prepared by abrasive blast cleaning to Sa2½ (ISO 8501-1:1988) or SSPC-SP10.

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

Interline 967 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.

Surfaces may be primed with Interline 982 to 15-25 microns (0.6-1.0 mils) 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.

Caulk Application

Prior to application of the laminate all weld seams, lap joints, plate edges should be caulked with Interline 903, alternatively Interline 967, filled with a suitable aggregate may be used. For further advice consult International Protective Coatings.

Application

Mixing	Interline 967 must be applied in accordance with the Interline 967 system sheet and the detailed International Protective Coatings Tank Linings Recommended Working procedures.			
	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 parts : 1 part by volume			
Working Pot Life	10°C (50°F) 60 minutes	15°C (59°F) 45 minutes	25°C (77°F) 30 minutes	40°C (104°F) 15 minutes
Airless Spray	Recommended - Tip range 0.53-0.66 mm (21-26 thou) - Total output fluid pressure at spray tip not less than 176 kg/cm ² (2,500 p.s.i.)			
Air Spray (Pressure Pot)	Not recommended			
Brush	Suitable		Stripe coats and small areas only.	
Roller	Recommended		See Product Characteristics	
Thinner	Not suitable - DO NOT THIN.			
Cleaner	International GTA822 (or GTA415)			
Work Stoppages	Do not allow material to remain in hoses, gun or spray equipment. Thoroughly flush all equipment with International GTA822. 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 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.			

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Product Characteristics

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

For hand lay application, Interline 967 should be mixed immediately before use and should be limited to a quantity that can be used within the working pot life. Apply a coat of Interline 967 at 600-800 microns (24-32 mils) wet film thickness, by spray or roller to the primed/caulked surface. Lay International glass fibre mat into the resin, and use a ribbed roller to force the glass mat into the wet resin. Apply additional resin and roll until the fibre glass mat is completely saturated and free of entrapped air. Once the laminate has cured, apply an unreinforced gel coat of Interline 967 at 250-500 microns (10-20 mils) wet film thickness by spray or roller.

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

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

The climatic conditions within the tank should be controlled to maintain a maximum relative humidity of 50% at temperatures between 10-15°C (50-59°F), and a maximum relative humidity of 60% at temperatures of 16°C (61°F) and above, during the application and curing schedule.

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 500 microns (20 mils), can be checked using a suitable high voltage pulsating type holiday detector, set at 100 volts per 25 microns dry film thickness (100 volts per mil). 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 Tank Linings Recommended Working Procedures for detailed repair procedures.

Maximum resistance is not attainable until the film has completely cured. Cure is a function of temperature, humidity and film thickness. Normally films at 1,500 microns (60 mils) dry film thickness will exhibit full and complete cure for optimal chemical resistance in 7-10 days at 25°C (77°F). Curing times are proportionately shorter at elevated temperatures and longer at lower temperatures.

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

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

Material is not suitable for storage of refined materials such as unleaded gasoline. It is also not suitable for the storage of aqueous media at temperatures in excess of 40°C (104°F).

This product is recommended for the storage of crude oil and white oil products.

Systems Compatibility

The following primers are suitable for Interline 967:

Interline 903
Interline 982

For other suitable primers/topcoats, please consult International Protective Coatings.

Consult International Protective Coatings to confirm that Interline 967 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

Individual copies of the following information are available upon request.

- Tank Linings Recommended Working Procedures

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.

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

Pack Size	20 litre unit	Interline 967 Base	13.33 litres in a 20 litre container
		Interline 967 Curing Agent	6.67 litres in a 10 litre container
	3 gallon unit	Interline 967 Base	2 gallons in a 5 gallon container
		Interline 967 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. Non Hazardous		
	20 litre unit	19.2 kg (42.2 lb) Base (Part A)	10.1 kg (22.2 lb) Curing Agent (Part B)
	3 gallon unit	11.4 kg (25.3 lb) Base (Part A)	5.2 kg (11.6 lb) Curing Agent (Part B)
Storage	Shelf Life		
	18 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 from 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: 1st June 1997

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International Protective Coatings

Worldwide Availability

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