

Interline 983

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WORLD WIDE PRODUCT RANGE

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 fibre as a refurbishment system for corroded steel. May also be used as an adhesive for non-welding steel repairs.

Practical Information for Interline 983

Colour	Blue			
Gloss Level	Not applicable			
Volume Solids	100%			
Typical Thickness	1000-2000 microns (40-80 mils) dry equivalent to 1000-2000 microns (40-80 mils) wet Note: Actual application thickness is dependent upon the steel condition and configuration to be coated			
Theoretical Coverage	1.00 m ² /litre at 1000 microns d.f.t and stated volume solids 40 sq.ft/US gallon at 40 mils 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 <i>Minimum</i> <i>Maximum</i>	
10°C (50°F)	22 hours	42 hours	24 hours	72 hours
15°C (59°F)	18 hours	28 hours	20 hours	60 hours
25°C (77°F)	10 hours	22 hours	12 hours	36 hours
40°C (104°F)	3 hours	12 hours	5 hours	18 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	1.23 kg/l (10.26 lb/gal)		
VOC	0.00 lb/gal (0.00 g/l) (Calculated) USA EPA Method 24		

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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.

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 8501-1:1988) or SSPC-SP10.

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

Interline 983 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.

Primed Surfaces

Surfaces may be primed with Interline 982 to 15-25 microns (0.5-1.0 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.

Application

Mixing	Interline 983 must be applied in accordance with the Interline 985 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.			
	(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 parts : 1 part by volume			
	Working Pot Life Interline 983 is applied by twin feed spray equipment. Usable life in spray line is 10-15 minutes at 35-40°C (95-105°F). Small quantities manually mixed will have a pot life of:			
	10°C (50°F)	15°C (59°F)	25°C (77°F)	40°C (104°F)
	4 hours	2½ hours	90 minutes	30 minutes
	Plural Component Recommended Spray See Product Characteristics section.			
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 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 GTA822. Do not re-pressurise 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.		

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Product Characteristics

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 35°C (95°F) and 50°C (112°F).

Airless spray using heated plural component equipment. Recommended tip sizes 0.79-0.99 mm (31-39 thou). Caulk with Interline 983 to 1000-2000 microns (40-80 mils) 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 3°C (5°F) above dew point.

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

Exposure to unacceptably low temperatures and/or high humidities during, or immediately after, application may result in incomplete cure and surface contamination that could jeopardise 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 colour 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 UK-PG6/23(92), Appendix 3 and USA-EPA Method 24 protocols. This is due to the high temperatures used in the test procedures.

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.

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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	60 litre unit	Interline 983 Base	2 x 20 litres in a 20 litre container
		Interline 983 Curing Agent	1 x 20 litres in a 20 litre container
	15 gallon unit	Interline 983 Base	2 x 5 gallons in a 5 gallon container
		Interline 983 Curing Agent	1 x 5 gallons in a 5 gallon container
	For availability of other pack sizes contact International Protective Coatings		
Shipping Weight	U.N. Shipping No. Non Hazardous (Base) : UN 1760 (Curing Agent)		
	60 litre unit	2 x 27.6 kg (60.7 lb) Base (Part A)	24.4 kg (53.7 lb) Curing Agent (Part B)
	15 gallon unit	2 x 25.9 kg (57.2 lb) Base (Part A)	22.8 kg (50.4 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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