

# Interline 944

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**Product Description**

A two component solvent based thin film epoxy tank coating.

**Intended Uses**

As an economical coating for the corrosion protection of the internals of steel storage tanks and vessels.

Suitable for the storage of an extensive range of products including solvents, crude oils, white oil refined products, aviation fuels, aqueous solutions, brackish water and caustic soda.

**Practical Information for Interline 944**

<b>Colour</b>	Pink, White
<b>Gloss Level</b>	Not applicable
<b>Volume Solids</b>	58%
<b>Typical Thickness</b>	100-150 microns (4-6 mils) dry equivalent to 172-259 microns (6.9-10.3 mils) wet
<b>Theoretical Coverage</b>	4.64 m <sup>2</sup> /litre at 125 microns d.f.t and stated volume solids 186 sq.ft/US gallon at 5 mils d.f.t and stated volume solids
<b>Practical Coverage</b>	Allow appropriate loss factors
<b>Method of Application</b>	Airless spray, Air spray, Brush, Roller

**Drying Time**

Temperature	Touch Dry	Hard Dry	Overcoating Interval Interline 944 with self	
			<i>Minimum</i>	<i>Maximum*</i>
10°C (50°F)	10 hours	24 hours	48 hours	7-28 days
15°C (59°F)	7 hours	16 hours	36 hours	7-28 days
25°C (77°F)	3 hours	8 hours	24 hours	7-28 days
40°C (104°F)	1 hour	3 hours	12 hours	3-14 days

\* The maximum overcoating interval will vary depending upon the products to be stored. Please consult International Protective Coatings for further details.

**Regulatory Data**

<b>Flash Point</b>	Base (Part A) 25°C (77°F)	C/A (Part B) 23°C (73°F)	Mixed 24°C (75°F)
<b>Product Weight</b>	1.52 kg/l (12.68 lb/gal)		
<b>VOC</b>	440 g/l	UK - PG6/23(92), Appendix 3	
	3.42 lb/gal (410 g/l) 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 50-75 microns (2-3 mils) is recommended.

Interline 944 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 25-40 microns (1.0-1.6 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.

### Shop Primed Steelwork

Weld seams and damaged areas should be blast cleaned to Sa2½ (ISO 8501-1:1988) or SSPC-SP10. If the shop primer shows extensive or widely scattered breakdown overall sweep blasting may be necessary.

## Application

<b>Mixing</b>	Interline 944 must be applied in accordance with the Interline 944 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. 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.			
	<ol style="list-style-type: none"> <li>(1) Agitate Base (Part A) with a power agitator.</li> <li>(2) Combine entire contents of Curing Agent (Part B) with Base (Part A) and mix thoroughly with power agitator.</li> </ol>			
<b>Mix Ratio</b>	5.7 parts : 1.0 part by volume			
<b>Working Pot Life</b>	10°C (50°F) 10 hours	15°C (59°F) 8 hours	25°C (77°F) 6 hours	40°C (104°F) 3 hours
<b>Airless Spray</b>	Recommended	<ul style="list-style-type: none"> <li>- Tip range 0.53-0.68 mm (21-27 thou).</li> <li>- Total output fluid pressure at spray tip not less than 176 kg/cm<sup>2</sup> (2,500 p.s.i.).</li> </ul>		
<b>Air Spray (Pressure Pot)</b>	Recommended	Gun	DeVilbiss MBC or JGA	
		Air Cap	704 or 765	
		Fluid Tip	E	
<b>Brush</b>	Suitable - Small areas only	Typically 50-75 microns (2-3 mils) can be achieved.		
<b>Roller</b>	Suitable - Small areas only	Typically 50-75 microns (2-3 mils) can be achieved.		
<b>Thinner</b>	International GTA220 (or GTA415)	Do not thin more than allowed by local environmental legislation.		
<b>Cleaner</b>	International GTA853 (or GTA415)			
<b>Work Stoppages</b>	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.			
<b>Clean Up</b>	Clean all equipment immediately after use with International GTA853. 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

The detailed Tank Lining Working Procedures should be consulted prior to use.

Interline 944 is typically specified as a two coat system at 125 microns (5 mils) per coat to give a total coating system dry film thickness of 250 microns (10 mils). Exact specification for total dry film thickness will be dependent upon service end use requirements. Consult International Protective Coatings for specific advice regarding tank lining applications.

Maximum film build in one coat is best attained by airless spray. When applying by methods other than airless spray, the required film build is unlikely to be achieved. Application by air spray may require a multiple cross spray pattern to attain optimum film build. The use of other methods, e.g. brush or roller, may require more than one coat and are suggested only for small areas, or initial stripe coating.

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).

The relative humidity should not exceed 80% during application and curing.

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.

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. 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 250 microns (10 mils) dry film thickness will exhibit full and complete cure for optimal chemical resistance in 7-10 days at 25°C (77°F) and 50% relative humidity. Curing times are proportionately shorter at elevated temperatures and longer at lower temperatures.

This product has the following specification approvals:

DEF Stan 80.97 for the Lining of Bulk Aviation Fuel Tanks

Air BP F2D2 for the Lining of Aviation Fuel Tanks

PRA test reports citing the material's suitability against Shell Painting Specification Chapter V

## Systems Compatibility

Interline 944 can be applied directly to correctly prepared bare steel. However, it is also suitable for application over the following primer:

Interline 982

Interline 944 should only be topcoated with itself, and should never be overcoated with another product.

Consult International Protective Coatings to confirm that Interline 944 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.

<b>Pack Size</b>	20 litre unit	Interline 944 Base	17 litres in a 20 litre container
		Interline 944 Curing Agent	3 litres in a 5 litre container
	5 gallon unit	Interline 944 Base	4.25 gallons in a 5 gallon container
		Interline 944 Curing Agent	0.75 gallons in a 1 gallon container
For availability of other pack sizes contact International Protective Coatings			
<b>Shipping Weight</b>	U.N. Shipping No. 1263		
	20 litre unit	29.4 kg (64.8 lb) Base (Part A)	3.4 kg (7.5 lb) Curing Agent (Part B)
	5 gallon unit	26 kg (57.3 lb) Base (Part A)	2.8 kg (6.1 lb) Curing Agent (Part B)
<b>Storage</b>	Shelf Life		
	12 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 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: 19/06/2002*

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