Interline® 982

Epoxy

PRODUCT DESCRIPTION

A two component epoxy holding primer.

INTENDED USES

As a blast holding primer, for the temporary protection of freshly blasted steel during the application of tank linings.

As a versatile primer to maximise the effect of dehumidification utilised during the lining of tank internals.

A fully compatible tank primer which will maintain the optimum performance of the applied tank lining.

PRACTICAL INFORMATION FOR INTERLINE 982

Colour	Primrose
Gloss Level	Not applicable
Volume Solids	30%
Typical Thickness	15-40 microns (0.6-1.6 mils) dry equivalent to 50-133 microns (2-5.3 mils) wet
Theoretical Coverage	12 m²/litre at 25 microns d.f.t and stated volume solids 481 sq.ft/US gallon at 1 mils d.f.t and stated volume solids
Practical Coverage	Allow appropriate loss factors
Method of Application	Airless Spray, Air Spray, Brush, Roller

Drying Time

			Overcoating Interval with recommended topcoats	
Temperature	**Touch Dry**	**Hard Dry**	*Minimum*	*Maximum*
10°C (50°F)	45 minutes	5 hours	24 hours	28 days[1]
15°C (59°F)	30 minutes	3 hours	24 hours	28 days[1]
25°C (77°F)	20 minutes	90 minutes	24 hours	28 days[1]
40°C (104°F)	10 minutes	30 minutes	16 hours	28 days[1]

[1] The maximum overcoating interval will vary depending upon the topcoat system and the products to be stored. Please consult International Protective Coatings for further details.

REGULATORY DATA

Flash Point (Typical)	Part A 21°C (70°F); Part B 23°C (73°F); Mixed 21°C (70°F)	
Product Weight	1.24 kg/l (10.3 lb/gal)	
VOC	5.04 lb/gal (605 g/lt) 488 g/kg	EPA Method 24 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

Abrasive blast clean to Sa2½ (ISO 8501-1:2007) or SSPC-SP10. If oxidation has occurred between blasting and application of Interline 982, the surface should be reblasted to the specified visual standard. Surface defects revealed by the blast cleaning process should be ground, filled, or treated in the appropriate manner.

Thin Film Systems

A sharp, angular surface profile of 50-75 microns (2-3 mils) is recommended.

Heavy Duty Systems & Glass Reinforced Systems

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

This product is NOT recommended over hand prepared steel.

APPLICATION

Mixing

Interline 982 must be applied in accordance with the detailed International Protective Coatings Working Procedures for the 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.

(1) Agitate Base (Part A) with a power agitator.
(2) Combine entire contents of Curing Agent (Part B) with Base (Part A) and mix thoroughly with power agitator.

Mix Ratio

8.2 part(s) : 1 part(s) by volume

Working Pot Life

10°C (50°F)	15°C (59°F)	25°C (77°F)	40°C (104°F)
10 hours	8 hours	6 hours	3 hours

Airless Spray	Recommended	Tip Range 0.43-0.53 mm (17-21 thou) Total output fluid pressure at spray tip not less than 141 kg/cm² (2005 p.s.i.)
Air Spray (Pressure Pot)	Recommended	Gun DeVilbiss MBC or JGA Air Cap 704 or 765 Fluid Tip E
Brush	Suitable - small areas only	Typically 15-25 microns (0.6-1.0 mils) can be achieved
Roller	Suitable - small areas only	Typically 15-25 microns (0.6-1.0 mils) can be achieved
Thinner	International GTA220 (or International GTA415)	Do not thin more than allowed by local environmental legislation

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 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 approrpriate regional regulations/legislation.

PRODUCT CHARACTERISTICS

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.

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

Surface temperature must always be a minimum of 3°C above dew point.

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

This product will not cure adequately below 5°C (41°F). For maximum performance ambient curing temperatures should be above 10°C (50°F).

When applying Interline 982 in confined spaces ensure adequate ventilation.

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.

Dry film thicknesses above 40 microns (1.6 mils) and below 15 microns (0.6 mils) may adversely affect appearance and performance.

For heavy duty and GRP systems excessive film thicknesses must be avoided, 15-25 microns (0.6-1.0 mil) must be specified if primer is required. To achieve this dry film thickness Interline 982 may be thinned to a maximum of 25%.

Over-application of Interline 982 will extend both the minimum overcoating periods and handling times, and may be detrimental to long term overcoating properties.

This product has the following specification approvals:

- BS6920 Water Fittings & Byelaws Scheme as the primer for Interline 925.

Note: VOC values are typical and are provided for guidance purpose only. These may be subject to variation depending on factors such as differences in colour and normal manufacturing tolerances.

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

SYSTEMS COMPATIBILITY

The following topcoats are recommended for Interline 982:

Interline 850	Interline 983
Interline 921	Interline 984
Interline 925	Interline 985

Consult International Protective Coatings to confirm that Interline 982 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
- Tank Linings Working Procedures

Individual copies of these information sections are available upon request.

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 drying (Refer to product datasheets for typical drying times) to keep solvent concentrations within 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 drying. 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 (Parts A and B 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.

PACK SIZE	Unit Size	Part A		Part B	
		Vol	Pack	Vol	Pack
	20 litre	17.83 litre	20 litre	2.17 litre	2.5 litre
	5 US gal	4.46 US gal	5 US gal	0.54 US gal	1 US gal
	For availability of other pack sizes, contact International Protective Coatings.				

SHIPPING WEIGHT (TYPICAL)	Unit Size	Part A	Part B
	20 litre	25.1 kg	2.4 kg
	5 US gal	51.8 lb	5.2 lb

STORAGE	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.

Important Note

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