Interline® 955

Novolac Vinyl Ester

PRODUCT DESCRIPTION

A two-component, chemical and abrasion resistant, glass flake reinforced vinyl ester.

INTENDED USES

Interline 955 is primarily intended for the internal lining of chemical storage tanks and vessels where acidic chemicals or hot media are to be stored, such as in oil, gas and chemical processing, pulp and paper plants, and for structural steelwork in environments where frequent contact with corrosive chemicals is likely to occur.

PRACTICAL INFORMATION FOR INTERLINE 955

Color White, Buff

Gloss Level Semi Gloss

Volume Solids 100% reactive

Typical Thickness 16-24 mils (400-600 microns) dry equivalent to 18.8-28.2 mils (471-706 microns) wet

Practical Coverage 85 sq.ft/US gallon at 16 mils d.f.t and 85% volume solids
2.10 m²/litre at 400 microns d.f.t and 85% volume solids
(see Page 3 Product Characteristics)

Method of Application Airless Spray, Brush

Drying Time

			Overcoating Interval with recommended topcoats	
Temperature	**Touch Dry**	**Hard Dry**	*Minimum*	*Maximum*
50°F (10°C)	5 hours	6 hours	6 hours	3 days
59°F (15°C)	4 hours	5 hours	5 hours	3 days
77°F (25°C)	4 hours	5 hours	5 hours	2 days
95°F (35°C)	4 hours	5 hours	5 hours	24 hours

These dry times have been obtained using the recommended amount of retarder for each temperature (see Product Characteristics).

REGULATORY DATA

Flash Point (Typical) Part A 90°F (32°C); Part B 212°F (100°C); Mixed 90°F (32°C)

Product Weight 10.0 lb/gal (1.2 kg/l)

VOC 29 g/kg EU Solvent Emissions Directive (Council Directive 1999/13/EC)

See Product Characteristics section for further details

Interline® 955

Novolac Vinyl Ester

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. Oil or grease should be removed in accordance with SSPC-SP1 solvent cleaning.

Steel Substrates

Abrasive blast clean to SSPC SP10 or Sa2½ (ISO 8501-1:2007). If oxidation has occurred between blasting and application of Interline 955, 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. A sharp, angular surface profile of 3-4 mils (75-100 microns) is recommended.

Interline 955 may also be applied over Intergard 269 for some cargoes; see page 3. The Intergard 269 may be overcoated up to 90 days after application provided the surface is abraded and fresh water washed. Alternatively, the blast standard can be maintained by the use of dehumidification.

If a holding primer is required for Interline 955 then the use of Interline 949 is advised (see system compatibility). Alternatively, the blast standard can be maintained by the use of dehumidification.

Shop Primed Steel

Prior to application of Interline 955, all shop primed steelwork must be re-blasted to a visual standard as outlined above.

Concrete Substrates

Concrete should be well cured prior to application of the flooring, lining or coating system. Refer to the Concrete Surface Preparation Guidelines for more information.

APPLICATION

Mixing

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.

An optional retarder solution is available for this material. (See Product Characteristics for details.)

Mix Ratio

98 part(s) : 2 part(s) by volume

Working Pot Life

50°F (10°C)	59°F (15°C)	77°F (25°C)	95°F (35°C)
1 hour	1 hour	40 minutes	40 minutes

Airless Spray	Recommended	Tip Range 25-35 thou (0.63-0.89 mm) Total output fluid pressure at spray tip not less than 3000 psi (211 kg/cm²)
Air Spray (Pressure Pot)	Not recommended	
Brush	Suitable - Small areas only	Typically 3.0 mils (75 microns) can be achieved
Roller	Not recommended	
Thinner	Not suitable	**DO NOT THIN**
Cleaner	International GTA853	**N.B. Clean all equipment immediately after use.**

Work Stoppages

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.

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 should be once every hour using GTA415 cooled to <59°F (15°C).

All surplus materials and empty containers should be disposed of in accordance with appropriate regional regulations/legislation.

Interline® 955

Novolac Vinyl Ester

PRODUCT CHARACTERISTICS

The detailed Interline 955 Application Guidelines should be consulted prior to use.

Elevated storage temperatures reduce shelf life. Uncatalyzed Interline 955 is stable for 6 months from date of manufacture when stored below 68°F (20°C) in its original sealed containers. Interline 955 should never be stored in direct sunlight. It is recommended that material temperatures be kept as low as possible via refrigeration if necessary in order to prolong shelf life and ensure a 1 hour pot life during airless spray application. It is important to take into consideration that material temperatures will increase following mixing. A recommended storage temperature range is 46°F-66°F (8°C-19°C).

Although Interline 955 is 100% reactive, depending upon the application conditions, the practical volume solids may be lower and International Protective Coatings suggest a value of 85% for estimating spreading rate.

Apply by airless spray only. Application by other methods, e.g. brush or roller, may require more than one coat and is suggested for small areas only or initial stripe coating.

This product must **not** be thinned as the use of thinners may severely inhibit the curing mechanism of the coating.

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

Maximum steel temperature at the time of application is 140°F (60°C) and maximum relative humidity during the application and cure period is 80%.

Interline 955 should typically be specified as a minimum of 2 coats at 16 mils (400 microns) per coat to give a total dry film thickness of not less than 32 mils (800 microns) in order to achieve optimum performance. However, for certain end uses, alternative specifications may be permitted.

Interline 955 can be applied in a wide range of climatic conditions, including material temperatures up to 95°F (35°C). However, at material temperatures greater than 77°F (25°C) the use of a retarder solution is required in order to maintain the working pot life, allowing normal airless spray methods to be employed. The recommended level of retarder solution is as follows:-

<77°F (25°C)	No retarder required
77-95°F (25-35°C)	1 unit of retarder required.

The retarder solution must always be added to the base prior to the addition of the initiator and mixed thoroughly using a power agitator. Where material temperatures are consistently high, i.e. >95°F (35°C), material should be refrigerated, consult International Protective Coatings for specific advice.

This product will not cure adequately below 41°F (5°C). For maximum performance ambient curing temperatures should be above 59°F (15°C).

Maximum continuous dry temperature resistance for Interline 955 is 266°F (130°C).

Maximum temperature in immersed conditions for Interline 955 is 194°F (90°C).

Consult International Protective Coatings for temperature limits for specific cargoes.

Interline 955 is not intended to be used as a cosmetic finish and color stability will not be achievable.

For storage of inorganic or organic acids, consult International Protective Coatings for specific advice on cargo compatibility, suitable painting schemes and procedures.

Intergard 269 may only be used as a holding primer for storage of crude oil/water mixes and refined hydrocarbon cargoes.

When surface temperatures exceed 95°F (35°C), or when exposed to direct sunlight, Interline 955 should be overcoated as soon as hard dry to avoid intercoat adhesion problems.

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 color and normal manufacturing tolerances.

SYSTEMS COMPATIBILITY

Interline 955 should be applied to correctly prepared substrates. However, it is suitable for application to the following primers:

Ceilcote 370HT Primer
Ceilcote 380 Primer
Intergard 269

Interline 955 should only be overcoated with itself.

For additional information, consult International Protective Coatings.

Consult International Protective Coatings to confirm that Interline 955 is suitable for contact with the product to be stored.

Interline® 955

Novolac Vinyl Ester

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 955 Application Guidelines

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 (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.

PACK SIZE

Unit Size	Part A		Part B	
	Vol	Pack	Vol	Pack
20 liter	19.6 liter	20 liter	0.4 liter	0.5 liter

The optional retarder solution is available as 50ml in a 100ml container.
For availability of other pack sizes contact International Protective Coatings

SHIPPING WEIGHT (TYPICAL)

Unit Size	Part A	Part B
20 liter	25.3 kg	0.5 kg

U.N. Shipping No. Part A - 1263 Part B - 5105

STORAGE

Shelf Life: 6 months minimum at <68°F (20°C). Subject to re-inspection thereafter. Store in dry, shaded conditions away from sources of heat and ignition. During storage and shipment, Interline 955 initiator must not be exposed to temperatures exceeding 30°C (90°F). Refrigeration recommended. Best practice would be to hold Parts A and B in separate stores.

Disclaimer