

# Interline<sup>®</sup> 500

Glass Flake Epoxy Phenolic



## PRODUCT DESCRIPTION

A two component glass flake, epoxy phenolic tank lining.

## INTENDED USES

Tank lining suitable for petroleum products, chemicals, fresh water and salt water at elevated and ambient temperatures. Glass flake reinforcement provides an advanced level of protection against wear, mechanical damage and permeation.

## PRACTICAL INFORMATION FOR INTERLINE 500

**Color** Green, Gray  
**Gloss Level** Not applicable  
**Volume Solids** 78%  
**Typical Thickness** 6.0-10.0 mils (150-250 microns) dry equivalent to 7.7-12.8 mils (192-320 microns) wet  
**Theoretical Coverage** 209 sq.ft./US gallon at 6.0 mils d.f.t. and stated volume solids  
5.2 m<sup>2</sup>/liter at 150 microns d.f.t. and stated volume solids  
**Practical Coverage** Allow appropriate loss factors  
**Method of Application** Airless Spray, Air Spray

### Drying Time

Temperature	Touch Dry	Hard Dry	Overcoating Interval with recommended topcoats	
			Minimum	Maximum
50°F (10°C)	6 hours	48 hours	42 hours	96 hours
59°F (15°C)	5 hours	36 hours	30 hours	72 hours
77°F (25°C)	4 hours	18 hours	8 hours	48 hours
104°F (40°C)	1½ hours	14 hours	7 hours	36 hours

## REGULATORY DATA

**Flash Point** Base (Part A) 53°F (12°C) Curing Agent (Part B) 47°F (8°C) Mixed 52°F (11°C)  
**Product Weight** 11.49 lb/gal (1.38 kg/l)  
**VOC** 2.22 lb/gal (266 g/l) USA EPA-24 (Calculated)



*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 8504:2000. 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. 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 2-3 mils (50-75 microns) is recommended. Interline 500 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 (thinned 50% GTA415) to 0.5-1.0 mils (13-25 microns) dry film thickness before oxidation occurs. Alternatively, the blast standard can be maintained by use of dehumidification. Concrete should be cured for a minimum of 28 days prior to coating. The moisture content of the concrete should be below 6%. All surfaces should be clean, dry and free from curing compounds, release agents, trowelling compounds, surface hardeners, efflorescence, grease, oil, dirt, old coatings and loose or disintegrating concrete. All poured and precast concrete must also be sweep blasted (preferred) or acid etched to remove laitence.

### APPLICATION

<b>Mixing</b>	Interline 982 must be applied in accordance with the Interline 500 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. (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			
<b>Mix Ratio</b>	19 parts : 1 part by volume.			
<b>Working Pot Life</b>	50°F (10°C) 4 hours	59°F (15°C) 4 hours	77°F (25°C) 3 hours	104°F (40°C) 1 hour
<b>Airless Spray</b>	Recommended.	- Tip range 41-55 thou (1.03-1.38 mm) - Total output fluid pressure at spray tip not less than 3000 p.s.i. (200 kg/cm <sup>2</sup> )		
<b>Air Spray (Pressure Pot)</b>	Recommended.	Gun Air Cap Fluid Tip	DeVilbiss MBC or JGA 64 D	
<b>Brush</b>	Suitable (Small areas only)	Typically 2-4 mils (50-100 microns) can be achieved		
<b>Roller</b>	Suitable (Small areas only)	Typically 2-4 mils (50-100 micron) can be achieved		
<b>Thinner</b>	International GTA415	Do not thin more than allowed by local environmental legislation.		
<b>Cleaner</b>	International GTA415			
<b>Work Stoppages</b>	Do not allow material to remain in hoses, gun or spray equipment. Thoroughly flush all equipment with International GTA415. 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 GTA415. 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

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.

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

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

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

When applying Interline 500 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 jeopardize 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. 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 Lining Working Procedures for proper repair procedures.

Maximum chemical resistance is not attained until the film has completely cured. Cure is a function of temperature, humidity and film thickness. Normally films at 12 mils (300 microns) dry film thickness will exhibit full and complete cure for optimal chemical resistance in 7-10 days at 77°F (25°C). Curing times are proportionately shorter at elevated temperatures and longer at lower temperatures.

### SYSTEMS COMPATIBILITY

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Interline 500 will generally be applied to correctly prepared steel, however, the following primer may be used:

Interline 982

Interline 500 should only be topcoated with itself and should never be overcoated with another product.

Consult International Protective Coatings to confirm that Interline 500 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 documents available at [www.international-pc.com](http://www.international-pc.com):

- 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>	5 gallon unit	Interline 500 Base	4.75 gallons in a 5 gallon container
		Interline 500 Curing Agent	0.25 gallons in quart container
	For availability of other pack sizes contact International Protective Coatings		
<b>SHIPPING WEIGHT</b>	U.N. Shipping No.	1263	
	5 gallon unit	58.8 lb (26.7 kg) Base (Part A)	2.3 lb (1.0 kg) Curing Agent (Part B)
<b>STORAGE</b>	Shelf Life	12 months minimum at 77°F (25°C). Subject to re-inspection thereafter. Store in dry, shaded conditions away from sources of heat and ignition.	

### Important Note

*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. While we endeavor 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.*

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It is the user's responsibility to check that this sheet is current prior to using the product. Issue date: 1st August 1997