Interline® 1046

Epoxy Phenolic

PRODUCT DESCRIPTION

A two component, chemically resistant, high solids, high build epoxy phenolic tank lining providing static dissipation properties.

INTENDED USES

To provide corrosion protection to the internals of steel storage tanks containing a range of products, including crude oil, unleaded gasoline blends, MTBE, and a selected range of aromatic and aliphatic solvents where accumulation of static charge is likely to be a problem.

PRACTICAL INFORMATION FOR INTERLINE 1046

Colour	Grey
Gloss Level	Not applicable
Volume Solids	76% ± 2%
Typical Thickness	100-150 microns (4-6 mils) dry equivalent to 132-197 microns (5.3-7.9 mils) wet
Theoretical Coverage	6.08 m²/litre at 125 microns d.f.t and stated volume solids 244 sq.ft/US gallon at 5 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 self	
Temperature	**Touch Dry**	**Hard Dry**	*Minimum*	*Maximum*
10°C (50°F)	9 hours	24 hours	24 hours	15 days
15°C (59°F)	8 hours	20 hours	20 hours	15 days
25°C (77°F)	4 hours	8 hours	8 hours	15 days
40°C (104°F)	3 hours	5 hours	5 hours	10 days

REGULATORY DATA

Flash Point (Typical)	Part A 42°C (108°F); Part B 54°C (129°F); Mixed 43°C (109°F)	
Product Weight	1.5 kg/l (12.5 lb/gal)	
VOC	1.88 lb/gal (226 g/lt)	EPA Method 24
	213 g/kg	EU Solvent Emissions Directive (Council Directive 2010/75/EU)
	186 g/lt	Chinese National Standard GB23985

Coating hazard marker GB 30981.2-S-Pb≤1000-NC Qualified for GB 30981.2-2025

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 8504:2019.

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 a minimum Sa2½ (ISO 8501-1:2007) or SSPC-SP10.

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

Interline 1046 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.

Where local VOC regulations allow, surfaces may be primed with Interline 1046 (thinned 10-15%) to 80 microns (3.2 mils) dry film thickness before oxidation occurs. Alternatively, the blast standard can be maintained by use of dehumidification.

Areas of breakdown, damage, weld seams, etc., should be prepared to the specified standard (e.g. Sa2½ (ISO 8501-1:2007) or SSPC SP10 or power tool cleaned to Pt3 (JSRA SPSS:1984) or SSPC SP11).

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.

Mix Ratio

3.8 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)
3 hours	2 hours	1 hour	45 minutes

Airless Spray	Suitable	Tip Range 0.48-0.58 mm (19-23 thou) Total output fluid pressure at spray tip not less than 204 kg/cm² (2901 p.s.i.)	
Air Spray (Pressure Pot)	Suitable	Gun Air Cap Fluid Tip	DeVilbiss MBC or JGA 704 or 765 E
Brush	Recommended	Typically 80 microns (3.2 mils) can be achieved	
Roller	Recommended	Typically 50-75 microns (2.0-3.0 mils) can be achieved	
Thinner	International GTA220 (or International GTA415)	Thinning is not normally required. Consult the local representative for advice during application in extreme conditions. Do not thin more than allowed by local environmental legislation.	
Cleaner	International GTA853 (or International GTA415)		

Work Stoppages

Do not allow material to remain in hoses, gun or spray equipment. Thoroughly flush all equipment with International GTA220. 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 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.

PRODUCT CHARACTERISTICS

Interline 1046 should not be applied over non-approved primers or old coatings as this may interfere with the static dissipation properties.

Interline 1046 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.

When used as a primer coat applied at 80 microns (3.2 mils) dry film thickness, Interline 1046 can hold a blast for up to 14 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. As an alternative, a full coat may be applied, provided the overcoating intervals are adhered to and all surfaces are correctly cleaned and prepared prior to overcoating with Interline 1046.

At temperatures below 15°C (59°F), it is recommended that Interline 1046 is allowed a 15 minute induction period after mixing, prior to commencing application.

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 and initial stripe coating.

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

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.

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 250 microns (10 mils) total system 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.

For storage of cargoes above ambient temperatures, consult International Protective Coatings for further details.

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.

SYSTEMS COMPATIBILITY

This system is self-priming and is not suitable for application over other primers. Interline 1046 should only be topcoated with itself, and should never be overcoated with another product.

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

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	15.83 litre	20 litre	4.17 litre	5 litre
	For availability of other pack sizes, contact AkzoNobel.				

SHIPPING WEIGHT (TYPICAL)	Unit Size	Part A	Part B
	20 litre	26.19 kg	4 kg

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

The information in this data sheet is not intended to be exhaustive; any person using the product for any purpose other than that specifically recommended in this data sheet without first obtaining written confirmation from us as to the suitability of the product for the intended purpose does so at their own risk. All advice given or statements made about the product (whether in this data sheet or otherwise) is correct to the best of our knowledge but we have no control over the quality or the 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 at all for the performance of the product or for (subject to the maximum extent permitted by law) any loss or damage arising out of the use of the product. We hereby disclaim any warranties or representations, express or implied, by operation of law or otherwise, including, without limitation, any implied warranty of merchantability or fitness for a particular purpose. All products supplied and technical advice given are subject to our Conditions of Sale. You should request a copy of this document and review it carefully. The information contained in this data sheet is liable to modification from time to time in the light of experience and our policy of continuous development. It is the user's responsibility to check with their local representative that this data sheet is current prior to using the product.

This Technical Data Sheet is available on our website at www.international-marine.com or www.international-pc.com, and should be the same as this document. Should there be any discrepancies between this document and the version of the Technical Data Sheet that appears on the website, then the version on the website will take precedence.

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