Interline® 1064

Novolac Vinyl Ester

PRODUCT DESCRIPTION

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

INTENDED USES

Interline 1064 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 1064

Colour	White, Buff, Grey
Gloss Level	Semi Gloss
Volume Solids	100% reactive
Typical Thickness	400-500 microns (16-20 mils) dry equivalent to 471-588 microns (18.8-23.5 mils) wet
Practical Coverage	2.13 m²/litre at 400 microns d.f.t and 85% volume solids 85 sq.ft/US gallon at 16 mils 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*
10°C (50°F)	5 hours	6 hours	6 hours	28 days
25°C (77°F)	2 hours	4.5 hours	5 hours	28 days
35°C (95°F)	1.5 hours	2.5 hours	5 hours	28 days

REGULATORY DATA

Flash Point (Typical)	Part A 32°C (90°F); Part B 57°C (135°F); Mixed 32°C (90°F)	
Product Weight	1.26 kg/l (10.5 lb/gal)	
VOC	2.06 lb/gal (248 g/lt)	EPA Method 24

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 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

Abrasive blast clean to Sa2½ (ISO 8501-1:2007) or SSPC-SP6 (or SSPC-SP10 for optimum performance). If oxidation has occurred between blasting and application of Interline 1064, 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 75-100 microns (3-4 mils) is recommended.

Concrete Substrates

Interline 1064 is also suitable for application to concrete in certain conditions; please see Product Application Guidelines for further 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.

Mix Ratio

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

Working Pot Life

10°C (50°F)	25°C (77°F)	35°C (95°F)
90 minutes	55 minutes	40 minutes

Airless Spray	Recommended	Tip Range 0.89-1.09 mm (35-43 thou) Total output fluid pressure at spray tip not less than 211 kg/cm² (3000 p.s.i.)
Air Spray (Pressure Pot)	Not recommended	
Brush	Suitable - small areas only	Typically 75 microns (3.0 mils) can be achieved
Roller	Not recommended	
Thinner	Not recommended	- **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 GTA853. 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 GTA853 cooled to <15°C (59°F).

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

PRODUCT CHARACTERISTICS

The detailed Interline 1064 Application Guidelines should be consulted prior to use.

Elevated storage temperatures reduce shelf life. Uncatalysed Interline 1064 is stable for 6 months from date of manufacture when stored below 20°C (68°F) in its original sealed containers. Interline 1064 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 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 8°C-19°C (46°F-66°F).

Interline 1064 must be specified as a minimum of 2 coats at 400 microns (16 mils) per coat to give a total dry film thickness of not less than 800 microns (32 mils) in order to achieve optimum performance.

Although Interline 1064 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 3°C (5°F) above dew point.

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

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

Maximum continuous dry temperature resistance for Interline 1064 is 160ºC (320°F).

Maximum temperature in immersed conditions for Interline 1064 is 90°C (194°F).

Consult International Protective Coatings for temperature limits for specific cargoes.

Interline 1064 is not intended to be used as a cosmetic finish and colour 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.

When surface temperatures exceed 35°C (95°F), or when exposed to direct sunlight, Interline 1064 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 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

Interline 1064 is normally applied directly to steel, however, it can be applied over the following primers:

Ceilcote 370HT Primer (for service conditions between 60ºC (140ºF) and 90ºC (195ºF))
Ceilcote 380 Primer (for service conditions up to 60ºC (140ºF))

Interline 1064 is designed only to be topcoated with itself.

For additional information, consult International Protective Coatings.

Consult International Protective Coatings to confirm that Interline 1064 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

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 in accordance with the advice given on this sheet, the Safety Data Sheet and the container(s), and should not be used without reference to the Safety Data Sheet (SDS).

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 AkzoNobel for further advice.

PACK SIZE	Unit Size	Part A		Part B	
		Vol	Pack	Vol	Pack
	20 litre	19.6 litre	20 litre	0.4 litre	0.5 litre
	For availability of other pack sizes, contact AkzoNobel.				

SHIPPING WEIGHT (TYPICAL)	Unit Size	Part A	Part B
	20 litre	26.5 kg	0.5 kg

STORAGE	Shelf Life	6 months at 20°C (68°F). Subject to re-inspection thereafter. Store in dry, shaded conditions away from sources of heat and ignition. During storage and shipment, Interline 1064 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.

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.

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