Interline® 399C

Epoxy Novolac

PRODUCT DESCRIPTION

A highly crosslinked, two component, high build epoxy novolac tank lining providing excellent chemical and heat resistance, with static dissipation properties.

INTENDED USES

Interline 399C has been specifically designed to provide protection for chemical storage tanks where accumulation of static charge is likely to be a problem. It can provide excellent resistance to a wide range of chemicals with temperatures up to 90°C (194°F).
Interline 399C is resistant to crude oil at temperatures up to 90°C (194°F).

PRACTICAL INFORMATION FOR INTERLINE 399C

Colour	Grey
Gloss Level	Not applicable
Volume Solids	70% ± 2%
Typical Thickness	90-150 microns (3.6-6 mils) dry equivalent to 129-214 microns (5.2-8.6 mils) wet
Theoretical Coverage	5.60 m²/litre at 125 microns d.f.t and stated volume solids 225 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

Drying Time

			Overcoating interval with self	
Temperature	**Touch Dry**	**Hard Dry**	*Minimum*	*Maximum*
10°C (50°F)	9 hours	18 hours	36 hours	15 days
25°C (77°F)	3 hours	5 hours	16 hours	15 days
40°C (104°F)	1 hour	4 hours	16 hours	15 days

REGULATORY DATA

Flash Point (Typical)	Part A 27°C (81°F); Part B 55°C (131°F); Mixed 28°C (82°F)	
Product Weight	1.78 kg/l (14.9 lb/gal)	
VOC	2.47 lb/gal (297 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 and free from contamination. Prior to 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

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 399C 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.

APPLICATION

Mixing

Interline 399C 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

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

Working Pot Life

10°C (50°F)	25°C (77°F)	40°C (104°F)
5 hours	90 minutes	45 minutes

Airless Spray

Recommended

Tip Range 0.43-0.53 mm (17-21 thou)
Total output fluid pressure at spray tip not less than 176 kg/cm² (2503 p.s.i.)

Air Spray (Pressure Pot)

Recommended

Gun	DeVilbiss MBC or JGA
Air Cap	704 or 765
Fluid Tip	E

Brush

Suitable - Stripe coats only

Typically 50 microns (2.0 mils) can be achieved

Cleaner

International GTA822 (or GTA415)

Choice of cleaner maybe subject to local legislation. Please consult your local representative for specific advice.

Work Stoppages

Do not allow material to remain in hoses, gun or spray equipment. Thoroughly flush all equipment with International GTA822. 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 GTA822. It is good working practice to periodically clean equipment during the course of the working day. Frequency of cleaning will depend upon amount used, 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

The detailed Application Guidelines should be consulted prior to use.

Interline 399C should not be applied over non-approved primers or old coatings as this may interfere with the static dissipation properties.

Interline 399C 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.

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.

Do not apply at steel temperatures below 10°C (50°F).The relative humidity during application and curing should not exceed 80%.

When applying Interline 399C in confined spaces ensure adequate ventilation.

Good ventilation throughout application and cure, and firm control of film thickness, are essential to ensure full removal of retained solvent and optimum performance of cured film. Total coating system film thickness must not exceed 350 microns (14 mils).

The curing times will vary depending upon dry film thickness and conditions that exist during application and throughout curing periods.

Return to Service

The following minimum cure times are recommended for Interline 399C to achieve its full chemical resistance properties.

Temperature	**Cure Schedule**
10°C (50°F)	14 days
25°C (77°F)	7 days
40°C (104°F)	4 days

Cure schedule refers to the minimum time at the specified substrate temperature prior to immersion in all chemicals as per the chemical resistance list.

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 Interline 399C Application Guidelines for proper repair procedures.

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

This system is self-priming and is not suitable for application over other primers.

Interline 399C should only be topcoated with itself, and should never be overcoated with another product.

Consult International Paint to confirm that Interline 399C 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	17.14 litre	20 litre	2.86 litre	5 litre

For availability of other pack sizes, contact AkzoNobel.

SHIPPING WEIGHT (TYPICAL)

Unit Size	Part A	Part B
20 litre	34.26 kg	3.18 kg

STORAGE

Shelf Life	6 months minimum at 25°C. 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.

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