Interline® 704

Epoxy

PRODUCT DESCRIPTION

A two component, chemically resistant epoxy tank lining

INTENDED USES

To provide corrosion protection to the internals of steel storage tanks containing a range of products, including crude oil, gasolines, MTBE, caustic solutions and a selected range of aromatic and aliphatic solvents.

PRACTICAL INFORMATION FOR INTERLINE 704

Colour	Pink, White, Grey
Gloss Level	Semi Gloss
Volume Solids	53%
Typical Thickness	80-125 microns (3.2-5 mils) dry equivalent to 151-236 microns (6-9.4 mils) wet
Theoretical Coverage	4.20 m²/litre at 125 microns d.f.t and stated volume solids 170 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, Brush, Roller

Drying Time

			Overcoating Interval with recommended topcoats	
Temperature	**Touch Dry**	**Hard Dry**	*Minimum*	*Maximum*
5°C (41°F)	6 hours	24 hours	36 hours	35 days
15°C (59°F)	4.5 hours	15 hours	28 hours	26 days
25°C (77°F)	3 hours	8 hours	9 hours	21 days
40°C (104°F)	45 minutes	5 hours	6 hours	10 days

REGULATORY DATA

Flash Point (Typical)	Part A 24°C (75°F); Part B 23°C (73°F); Mixed 26°C (79°F)	
Product Weight	1.42 kg/l (11.8 lb/gal)	
VOC	3.54 lb/gal (425 g/lt) 333 g/kg	EPA Method 24 EU Solvent Emissions Directive (Council Directive 2010/75/EU)

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

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

A sharp, angular surface profile of 50 - 100 microns (2-3.9 mils) is recommended.

Interline 704 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 to 40 microns (1.5 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

Interline 704 must be applied in accordance with the Interline 704 detailed International Protective Coatings Recommended Working Procedures.

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

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

Working Pot Life

5°C (41°F)	15°C (59°F)	25°C (77°F)	40°C (104°F)
9 hours	7.5 hours	5 hours	2 hours

Airless Spray	Recommended	Tip Range 0.53-0.68 mm (21-27 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	Recommended - Small areas only	Typically 50-75 microns (2.0-3.0 mils) can be achieved
Roller	Recommended - Small areas only	Typically 50-75 microns (2.0-3.0 mils) can be achieved
Thinner	International GTA220 (or GTA415)	Do not thin more than allowed by local environmental legislation
Cleaner	International GTA822 (or GTA415)	

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 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

The detailed Interline 704 Application Guidelines should be consulted prior to use.

Interline 704 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.

Apply by airless spray only. Application by other methods, e.g. brush, roller, may require more than one coat and should only be used for small areas or touch-up work.

When applying Interline 704 by brush or roller, it may be necessary to apply multiple coats to achieve the total specified system dry film thickness.

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

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

This product will not cure adequately below 5ºC (41ºF).

The relative humidity within the confines of the tank should not exceed 85%.

When applying Interline 704 in confined spaces ensure adequate ventilation.

For multi-coat application, exposure to temperatures below 5ºC (41ºF) during or immediately after application may result in incomplete cure and surface contamination that could jeopardise 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 Interline 704 Application Guidelines 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 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.

This product has the following specification approvals:

- Food Contact - FDA Compliant : Liquid & Dry Foodstuffs
- Food Contact - Carriage of Grain (NOHA)
- Tank Coating - Recognised Corrosion Control Coating (Lloyd's Register)

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 704 should only be topcoated with itself, and should never be overcoated with another product.

Interline 982 can be used as a suitable holding primer.

Consult International Protective Coatings to confirm that Interline 704 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
- Interline 704 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 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	15.56 litre	20 litre	4.44 litre	5 litre
	For availability of other pack sizes, contact AkzoNobel.				

SHIPPING WEIGHT (TYPICAL)	Unit Size	Part A	Part B
	20 litre	26 kg	4.6 kg

STORAGE		
	Shelf Life	12 months minimum at 25°C (77°F). 6 months minimum at temperatures greater than 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.

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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