Interline® 921

Epoxy

PRODUCT DESCRIPTION

A two component, solvent free, chemically resistant epoxy phenolic caulking compound formulated to provide ease of application, and greater flexibility in scheduling of tank lining applications.

INTENDED USES

As a versatile caulking compound suitable for application by standard airless spray equipment in both new construction situations, and for refurbishment of corroded tanks. The extended recoat window afforded by Interline 921 allows increased flexibility in working practice, and improved scheduling of contracts to allow more rapid return to service.

Interline 921 caulking compound should be used for the treatment of weld seams, lap joints, kerb angles and other surface irregularities to provide a smooth uniform transition between uneven surfaces, prior to the application of Interline glass reinforced laminate systems.

PRACTICAL INFORMATION FOR INTERLINE 921

Color	Cream
Gloss Level	Not applicable
Volume Solids	100%
Typical Thickness	40-160 mils (1000-4000 microns) dry equivalent to 40-160 mils (1000-4000 microns) wet
Theoretical Coverage	20 sq.ft/US gallon at 80 mils d.f.t and stated volume solids 0.50 m²/liter at 2000 microns d.f.t and stated volume solids Note: Actual application thickness is dependent upon the steel condition and configuration to be coated
Practical Coverage	Allow appropriate loss factors
Method of Application	Airless Spray, Plural component airless spray

Drying Time

			Overcoating Interval with recommended topcoats	
Temperature	**Touch Dry**	**Hard Dry**	*Minimum*	*Maximum*
50°F (10°C)	10 hours	36 hours	36 hours	28 days
59°F (15°C)	9 hours	20 hours	20 hours	28 days
77°F (25°C)	6 hours	12 hours	12 hours	28 days
104°F (40°C)	2 hours	5 hours	5 hours	10 days

REGULATORY DATA

Flash Point (Typical)	Part A >214°F (101°C); Part B 120°F (49°C); Mixed 167°F (75°C)	
Product Weight	10.8 lb/gal (1.30 kg/l)	
VOC	0.75 lb/gal (90 g/lt) 38 g/kg	EPA Method 24 EU Solvent Emissions Directive (Council Directive 2010/75/EC)

See Product Characteristics section for further details

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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 8504:2019.

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 3-4 mils (75-100 microns) is recommended.

Interline 921 must be applied before oxidation of the steel occurs. If oxidation does occur the entire oxidized 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 982 to 0.6-1.0 mils (15-25 microns) dry film thickness before oxidation occurs. Alternatively, the blast standard can be maintained by use of dehumidification.

Interline 982 can hold a blast for up to 28 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.

APPLICATION

Mixing

Interline 921 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) Agitate Curing Agent (Part B) with a power agitator.
(3) Combine entire contents of Curing Agent (Part B) with Base (Part A) and mix thoroughly with power agitator.

Mix Ratio

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

Working Pot Life

50°F (10°C)	59°F (15°C)	77°F (25°C)	104°F (40°C)
60 minutes	50 minutes	30 minutes	15 minutes

Plural component airless spray	Suitable	Consult International Protective Coatings for specific recommendations. See Product Characteristics.
Airless Spray	Recommended	Tip Range 26-31 thou (0.66-0.79 mm) Total output fluid pressure at spray tip not less than 3000 psi (211 kg/cm²)
Air Spray (Pressure Pot)	Not recommended	
Brush	Not suitable	
Roller	Not suitable	

Thinner	Not suitable	**DO NOT THIN**
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 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 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

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.

Interline 921 can be applied by standard 63:1 ratio airless spray equipment when the paint temperature is maintained between 59-77°F (15-25°C). At lower temperatures an in-line heater of a suitable pressure rating may be used to assist with pumping and atomization of the product. Additionally, Interline 921 is suitable for application by plural component airless spray equipment capable of accurate proportioning, which allows more flexible application at high temperatures..

Due to pot life limitations, airless spray using plural component spray equipment is normally required for applications at temperatures greater than 77°F (25°C).

Heavily pitted areas should be stripe coated by brush, to ensure good “wetting” of the surface.
Fill deeply pitted areas by manual knife application or squeegee, to provide a level finish, flush with the adjoining 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).

The climatic conditions within the tank must be controlled to maintain a maximum relative humidity of 70% at all temperatures.

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.

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 color and normal manufacturing tolerances.

SYSTEMS COMPATIBILITY

Interline 921 can be applied directly to correctly prepared bare steel. However, it is suitable for application over the following primer:

Interline 982

Interline 921 is normally topcoated with itself or Interline 984. For other primers/topcoats, consult International Protective Coatings.

Consult International Protective Coatings to confirm that Interline 921 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:

- Definitions & Abbreviations
- Surface Preparation
- Paint Application
- Theoretical & Practical Coverage
- Interline 984 Technical Specification for Glass Fibre Reinforced System

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 curing (refer to product datasheets for typical curing times) to ensure 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 curing. 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 (Base and Curing Agent 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.

Warning: This product contains liquid epoxies and modified polyamines and may cause skin sensitization if not used correctly.

PACK SIZE

Unit Size	Part A		Part B	
	Vol	Pack	Vol	Pack
18 liter	12 liter	20 liter	6 liter	10 liter
3 US gal	2 US gal	5 US gal	1 US gal	1 US gal

For availability of other pack sizes, contact AkzoNobel.

SHIPPING WEIGHT (TYPICAL)

Unit Size	Part A	Part B
18 liter	16.64 kg	10.02 kg
3 US gal	24.2 lb	12.8 lb

U.N.Shipping No. UN3082 (Base) : UN2924 (Curing Agent)

STORAGE

Shelf Life: 18 months minimum at 77°F (25°C). Subject to re-inspection thereafter. Store in dry, shaded conditions away from sources of heat and ignition. International Paint recommends storage above 50°F (10°C) at all times to ensure stability of the product.

Disclaimer

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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