
NAVSEA REVIEWED ASTM F-718

International Paint, LLC

Interline 604

THA Series / THA 665

MIL-PRF-23236

If this product is to be applied as part of a coating system, all components of the system must be as listed on the QPL.

This NAVSEA-REVIEWED ASTM F-718 data sheet is the only data sheet approved for use when utilizing this coating for U.S. Navy preservation projects. NAVSEA's review covers only the application process for the material. The review does not denote the material as a qualified product, nor does it constitute an approval for purchase/procurement of the material. For products on the Qualified Products List (QPL) for this MILSPEC, please refer to <http://assist.daps.dla.mil/quicksearch/>.

Questions regarding modifications or updates of this ASTM F-718 shall be directed toward:

NST Center
(502) 638-4400
F718Admin@nstcenter.com

SHIPBUILDERS AND MARINE PAINTS AND COATINGS PRODUCT/PROCEDURE DATA SHEET

CONTINUATION SHEET USED: ☒ YES ☐ NO

Date: 01/2009 Rev.A1

I. GENERIC TYPE AND DESCRIPTION: Epoxy Tank Lining

Specification Number, Type, Class and/or Grade (if Applicable): MIL-PRF-23236

II. MANUFACTURERS DATA:

(a) MANUFACTURER: International Paint LLC

(b) PRODUCT DESIGNATION: Interline 604
 Part A: THA series
 Part B: THA665

(c) COLOR(S): Off-White, Lt Gray, and Red

(d) USES: Cargo/Ballast Tanks

(e) TECHNICAL SERVICE REPRESENTATIVE
 (Include Telephone Nos.): (800) 525-6824
 Technical Information Fax: (713) 684-1511

(f) NOT RECOMMENDED FOR: Potable water tanks

III. PROPERTIES:

(a) % VOLUME SOLIDS (ASTM D 2697): 80% $\pm$ 3%(b) % WEIGHT SOLIDS (ASTM D1475): 87% $\pm$ 3%

(c) FLASH POINT (ASTM TEST METHOD D 93 OR D 56 OR D 3278): 117°F MIXED

(d) WEIGHT PER VOLUME: (FTMS 141a4184.1): 14.1 $\pm$ 0.3 lbs/gal

(e) % EDGE RETENTION (IF REQUIRED BY APPLICABLE SPECIFICATION): N/A

(f) SHELF LIFE: Part A: 6 months
 Part B: 18 months

(g) VISCOSITY (STATE TEST METHOD TO BE USED): COMPONENT A: 3 – 7 poise (ICI Cone and Plate Method)
 COMPONENT B: 74 KU (Stormer Method)
 MIXED: 95 – 115 KU (Stormer Method)

(h) PACKAGING: Part A: 4 gallons in a 5 gallon container
 Part B: 1 gallon in a 1 gallon container

(i) NUMBER OF COMPONENTS: 2

(j) GLOSS (ASTM D 523): 30 @ 60 degrees

(k) STORAGE REQUIREMENTS: TEMP. MIN. 45°F MAX. 95°F

ADDITIONAL PAINT STORAGE REQUIREMENTS: N/A

(l) VOLATILE ORGANIC COMPOUND (EPA TEST METHOD 24): 194g/l, 1.62lbs/gal

(m) WEIGHT OF DRY FILM (WEIGHT/FT² AT 1 MIL THICKNESS): 0.0097 lbs

(n) SPECIAL PROPERTIES (e.g., STAIN RESISTANCE, LOW SOLAR ABSORBANCE, MOISTURE TOLERANCE): N/A

IV. SURFACE PREPARATION MINIMUM REQUIREMENTS (USE SPECIFIC STANDARD NUMBERS):

(a) INITIAL – Apply over near white metal blast SSPC-SP 10.

(b) TOUCH-UP – Ensure the area is clean and dry. Power tool clean to SSPC-SP 3 or SSPC-SP 11 or spot blast to SSPC-SP 10 near white metal.

(c) PROFILE (INCLUDE METHOD USED) – Profilometer Gauge or Testex Replica Tape MIN. 2 mils MAX. 4 mils

(d) SPECIAL INSTRUCTIONS – N/A

(e) PRIMER REQUIREMENTS (IF APPLICABLE): Not required. This product may be applied directly over Interplate 937 or Interplate 997 shop primers, which have been cleaned to SSPC-SP 1 Standard in Non-Critical areas.

(f) MAXIMUM ALLOWABLE CONDUCTIVITY (BRESLE PATCH METHOD): Refer to NAVSEA Standard Item 009-32

(g) MAXIMUM DEGREE OF FLASH RUSTING ALLOWABLE (LIST COMMERCIAL STANDARD): None

SPECIAL SAFETY PRECAUTIONS:
REFER TO MATERIAL SAFETY DATA SHEET

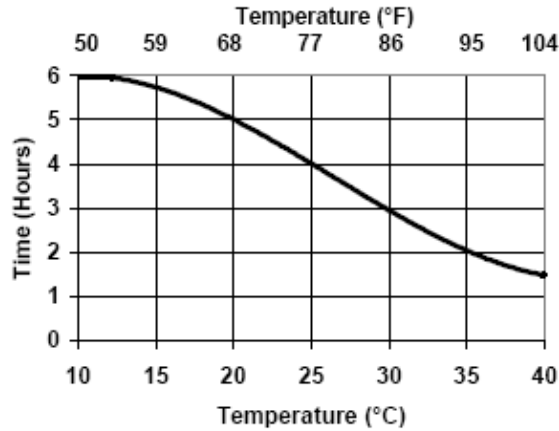
V. MIXING PROCEDURES:

- (a) MIXING RATIOS BY WEIGHT – 7.9 : 1 (A: B)
BY VOLUME – 4 : 1 (A: B)
- (b) INDUCTION TIME – 15 mins at temperatures below 73°F
- (c) RECOMMENDED SOLVENT – THINNING – NO THINNING ALLOWED
CONFINED AREAS - NO THINNING ALLOWED
NON-CONFINED AREAS - NO THINNING ALLOWED
CLEAN UP – GTA220
- (d) THINNING REQUIREMENTS (RATIO) – NO THINNING ALLOWED
- (e) POT LIFE -
8 Hrs @ 50°F
6 Hrs @ 59°F
4 Hrs @ 77°F
2 Hrs @ 95°F
- (f) SPECIAL INSTRUCTIONS – Before application, thoroughly mix in order to fully incorporate all coating components.

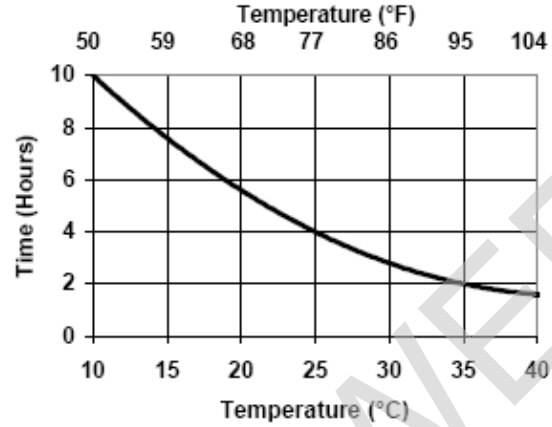
VI. APPLICATION:

- (a) ENVIRONMENTAL LIMITATIONS -
SUBSTRATE TEMPERATURE: MIN. 45°F MAX. 100°F
MINIMUM SUBSTRATE TEMPERATURE DIFFERENCE ABOVE THE DEW POINT - 5°F
RELATIVE HUMIDITY: Refer to NAVSEA Standard Item 009-32
AMBIENT TEMPERATURE: MIN. 50°F MAX. 95°F
- (b) FILM THICKNESS (SSPC PA2):
PER COAT:
WET MIN. 5 mils WET MAX. 7.5 mils
DRY MIN. 4 mils DRY MAX. 8 mils
TOTAL SYSTEM:
DRY MIN. 8 mils DRY MAX. 10 mils
- (c) DRY TIMES (ASTM D 1640) – PLEASE REFER TO GRAPHS ON FOLLOWING PAGE.
- (d) EQUIPMENT REQUIREMENTS (INCLUDE PREFERRED, SUITABLE, NOT SUITABLE REQUIREMENTS) – Airless spray recommended. Brush or roller for small areas only.
IF PLURAL COMPONENT EQUIPMENT IS REQUIRED, STATE SO – N/A
IF HEATED LINES ARE REQUIRED, STATE SO – N/A
- (e) SPECIAL INSTRUCTIONS – ENSURE BOTH COMPONENTS ARE MIXED THOROUGHLY.
- PROVIDE INFORMATION FOR REPAIR PROCEDURES IF THE OVERCOAT WINDOW HAS BEEN EXCEEDED: PLEASE REFER TO NAVSEA STANDARD ITEM 009-32.

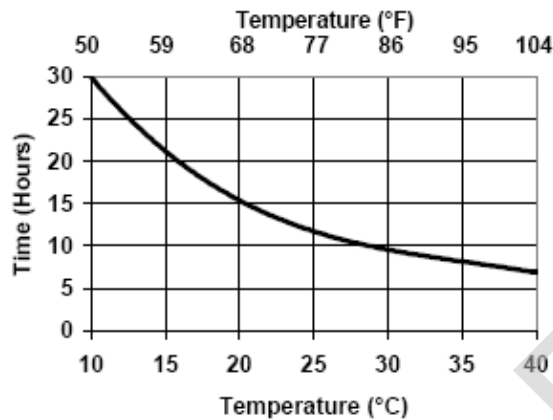
Interline 604: Pot Life



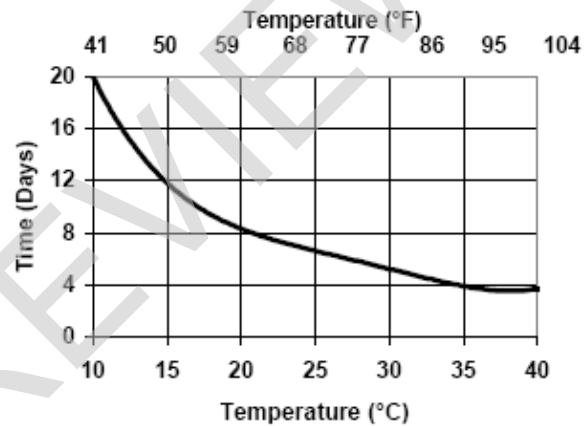
Interline 604: Touch Dry



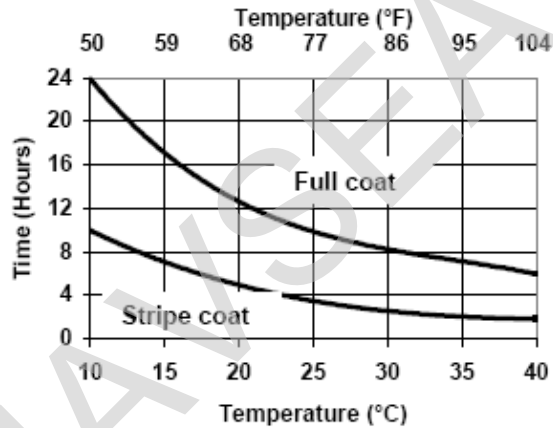
Interline 604: Hard Dry



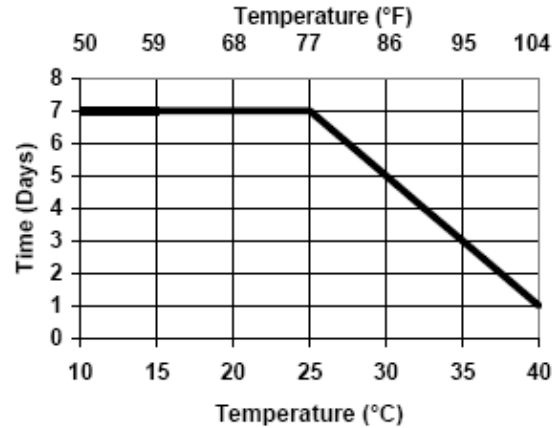
Interline 604: Curing Time



Interline 604: Minimum Overcoating



Interline 604: Maximum Overcoating



ASTM F 718 CONTINUATION SHEET FOR

SHIPBUILDERS AND MARINE PAINTS AND COATINGS PRODUCT/PROCEDURE DATA SHEET

Date 01/2009 Rev. A1

I. GENERIC TYPE AND DESCRIPTION: Interline 604, Epoxy Tank Lining
Specification Number (If Applicable): MIL-PRF-23236

ADDITIONAL DATA/ INSTRUCTIONS:

II. MANUFACTURERS DATA:

ADD ADDITIONAL COMMENTS FROM PART II HERE

III. PROPERTIES:

ADD ADDITIONAL COMMENTS FROM PART III HERE

IV. SURFACE PREPARATION MINIMUM REQUIREMENTS (USE SPECIFIC STANDARD NUMBERS):

ADD ADDITIONAL COMMENTS FROM PART IV HERE

V. MIXING PROCEDURES

ADD ADDITIONAL COMMENTS FROM PART V HERE

VI. APPLICATION REQUIREMENTS

ADD ADDITIONAL COMMENTS FROM PART VI HERE Dry times are normally a function of humidity, ventilation, and temperature. Information given is to be used as a guideline only.
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