NAVSEA REVIEWED ASTM F-718

International Paint, LLC

Interline 624 Finish - THA623/THA625/THA627

Two Pack Ultra High Solids Epoxy Tank Coating - Finish

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 https://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

ASTM F 718

SHIPBUILDERS AND MARINE PAINTS AND COATINGS PRODUCT/PROCEDURE DATA SHEET

CONTINUATION SHEET USED: ☒ YES ☐ NO

Date: 10/2010 Rev. C1

I. GENERIC TYPE AND DESCRIPTION: Two Pack Ultra High Solids Epoxy Tank Coating - Finish
Specification Number, Type, Class and/or Grade (If Applicable): MIL-PRF-23236

II. MANUFACTURERS DATA:

(a) MANUFACTURER: International Paint LLC

(b) PRODUCT DESIGNATION: Interline 624 Finish
Part A: THA623/THA625
Part B: THA627

(c) COLOR(S): White & Gray

(d) USES: Fuel/Chemical, Ballast Tank, CHT tank coating, well deck overheads.

(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): 98 ± 2%

(b) % WEIGHT SOLIDS (ASTM D1475): 93 ± 2%

(c): FLASH POINT (ASTM TEST METHOD D 93 OR D 56 OR D 3278): 181ºF MIXED

(d): WEIGHT PER VOLUME: (FTMS 141a4184.1): 11.0 – 11.4 lbs/gal MIXED

(e) % EDGE RETENTION (IF REQUIRED BY APPLICABLE SPECIFICATION): 70% minimum on 1 mm radius.

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

(g) VISCOSITY (STATE TEST METHOD TO BE USED): COMPONENT A: N/A

COMPONENT B: N/A

MIXED: 5 P Cone & Plate Viscosity (77˚F)

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

(i): NUMBER OF COMPONENTS: 2

(j) GLOSS (ASTM D 523): > 30 (Glossy)

(k) STORAGE REQUIREMENTS: TEMP. MIN. 41˚F MAX. 85˚F

ADDITIONAL PAINT STORAGE REQUIREMENTS: N/A

(l) VOLATILE ORGANIC COMPOUND (EPA TEST METHOD 24): 98 g/L, 0.82 lbs/gal

(m) WEIGHT OF DRY FILM (WEIGHT/FT^2 AT 1 MIL THICKNESS): 0.0067 lbs

(n): SPECIAL PROPERTIES (e.g., STAIN RESISTANCE, LOW SOLAR ABSORBANCE, MOISTURE TOLERANCE): None

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

(a) INITIAL – Paint only clean, dry surfaces. Remove all grease, oil, soluble contaminants and other detrimental foreign matter by solvent cleaning to SSPC-SP 1

(b) TOUCH-UP – Damaged areas should be blast cleaned to SSPC-SP 10 or power tool cleaned to SSPC-SP 11.

(c) PROFILE (INCLUDE METHOD USED) - MIN. N/A MAX. N/A

(d) SPECIAL INSTRUCTIONS – N/A

(e) PRIMER REQUIREMENTS (IF APPLICABLE): Consult the ASTM F718 of THA626/THA627 Buff Primer for specific information.

(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 – 6.12:1 (A:B)
BY VOLUME – 4:1 (A:B)

(b) INDUCTION TIME – Not Required

(c) RECOMMENDED SOLVENT – THINNING – NO THINNING ALLLOWED
CONFINED AREAS - NO THINNING ALLOWED
NON-CONFINED AREAS - NO THINNING ALLOWED
CLEAN UP – GTA415

(d) THINNING REQUIREMENTS (RATIO) – NO THINNING ALLOWED

(e) POT LIFE - 50 Min(s) @ 50ºF

30 Min(s) @ 77ºF

15 Min(s) @ 95ºF

(f) SPECIAL INSTRUCTIONS – Mixing of components with temperature > 77˚F will result in reduced pot life.

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-PA 2):

PER COAT:
WET MIN. 10.5 mils WET MAX. 21.1 mils

DRY MIN. 10 mils DRY MAX. 20 mils

TOTAL SYSTEM:

DRY MIN. 14 mils DRY MAX. 28 mils

(c) DRY TIMES (ASTM D 1640) – See graphs on following page

(d) EQUIPMENT REQUIREMENTS (INCLUDE PREFERRED, SUITABLE, NOT SUITABLE REQUIREMENTS) – Plural feed airless spray, or airless spray (70:1). Brush and roller for touch-up only. Conventional spray not recommended. Stripe coating may be carried out by brush/roller or spray.

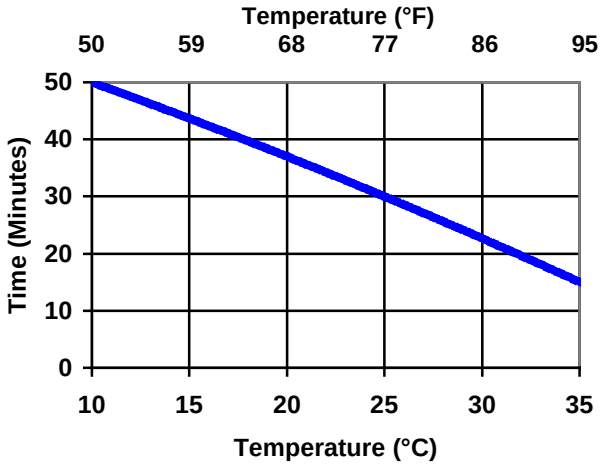
IF PLURAL COMPONENT EQUIPMENT IS REQUIRED, STATE SO – Recommended but not required.

IF HEATED LINES ARE REQUIRED, STATE SO – Contact your local International Paint Representative.

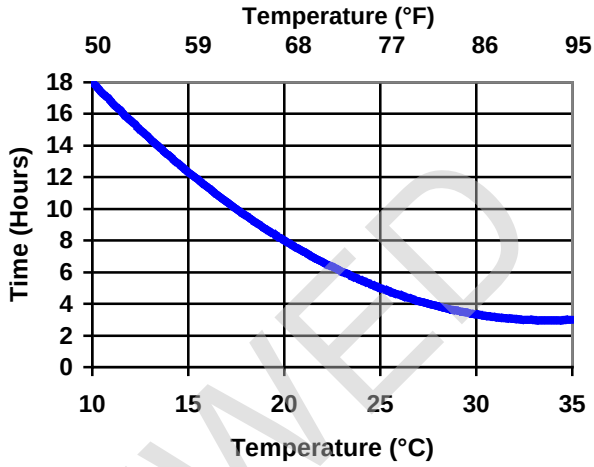
(e) SPECIAL INSTRUCTIONS – If component temperatures are >86˚F, plural feed airless spray is recommended.

REPAIR PROCEDURES IF THE OVERCOAT WINDOW HAS BEEN EXCEEDED: Contact your local International Paint Representative.

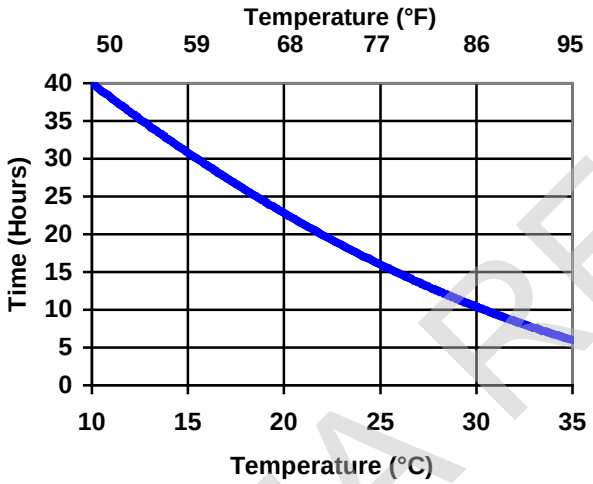
Interline 624: Pot Life



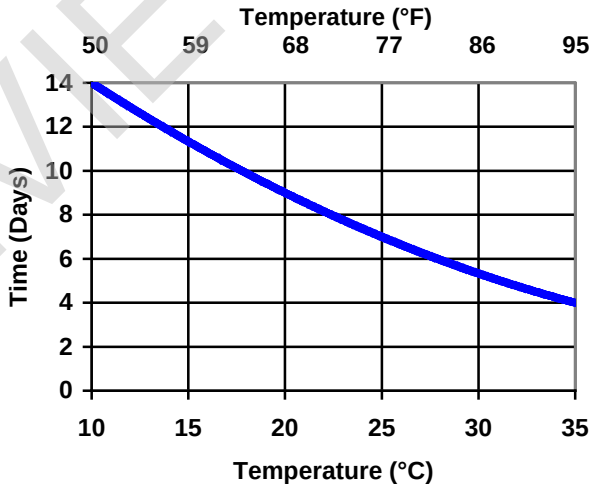
Interline 624: Touch Dry



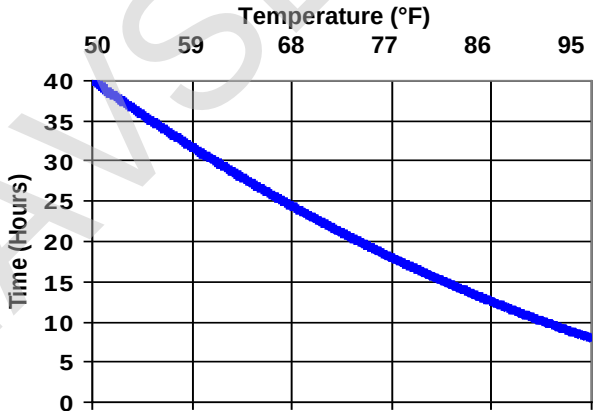
Interline 624: Hard Dry



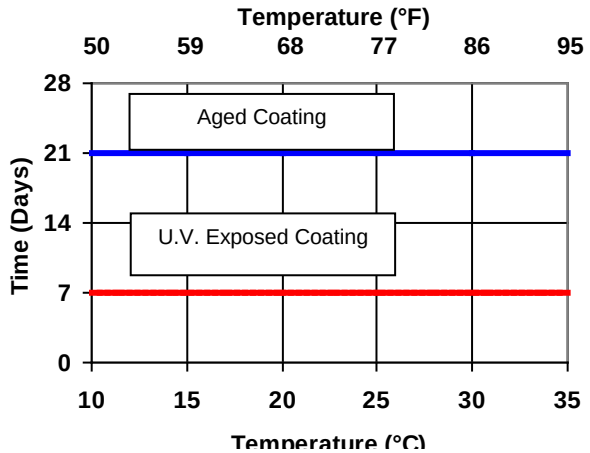
Interline 624: Time to Ballast



Interline 624: Minimum Overcoating Interval



Interline 624: Maximum Overcoating Interval



ASTM F 718 CONTINUATION SHEET FOR

SHIPBUILDERS AND MARINE PAINTS AND COATINGS PRODUCT/PROCEDURE DATA SHEET

Date 10/2010 Rev. C1

I. GENERIC TYPE AND DESCRIPTION: Two Pack Ultra High Solids Epoxy Tank Coating - Finish
Specification Number (If Applicable): MIL-PRF-23236

ADDITIONAL DATA/ INSTRUCTIONS:

II. MANUFACTURERS DATA:

ADD ADDITIONAL COMMENTS FROM PART II HERE White is available in 1 gallon kits.

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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