International Paint, LLC

Interline 783 Finish, Ultra High Solids Two-Pack Fast Cure Solvent-Free Coating

PRODUCT DESIGNATIONS

Part A: THA782/THA783/THA788/THA789/THA Series

Part B: THA785

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:

NSWC-PD

nswccd_astm_f718@navy.mil

SHIPBUILDERS AND MARINE PAINTS AND COATINGS PRODUCT/PROCEDURE DATA SHEET

CONTINUATION SHEET USED: ☐ YES ☐ NO

Date: 1/2017 Rev. A4

I. GENERIC TYPE AND DESCRIPTION: Interline 783 Finish, Ultra High Solids Two-Pack Fast Cure Solvent-Free Coating
Specification Number: MIL-PRF-23236

II. MANUFACTURERS DATA:

(a) MANUFACTURER: International Paint LLC, 6001 Antoine Drive, Houston, TX 77091

(b) PRODUCT DESIGNATION: Part A: THA782/THA783/THA788/THA789/THA Series; Part B: THA785

(c) COLOR(S): Buff (THA782), Grey (THA783), Terracotta Red (THA788) , White (THA789)

(d) USES: Seawater Tanks, Ballast Tanks, Fuel Tanks, Voids, CHT Tanks, Bilges, Well Decks and Well Deck Overhead, and other areas where single coat fast cure might apply

(e) TECHNICAL SERVICE REPRESENTATIVE
(Include Telephone Numbers): 1-800-525-6824 (or contact your local International Paint representative)

(f) NOT INTENDED FOR USE IN: Potable Water tanks

III. PROPERTIES:

(a) PERCENT VOLUME SOLIDS (ASTM D2697): 95 ± 3%

(b) PERCENT WEIGHT SOLIDS (ASTM D2369): 90 ± 3%

(c) FLASH POINT (ASTM D3278): Part A 117°F, Part B 138°F, Mixed 124°F

(d) WEIGHT PER VOLUME (ASTM D1475):

Part A 11.0 -11.6 lbs

Part B: 8.50 – 8.80 lbs

Mixed: 10.45 – 10.9 lbs

(e) PERCENT EDGE RETENTION (IF REQUIRED BY APPLICABLE SPECIFICATION – LIST TEST METHOD USED): 70% minimum on 1mm radius

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

(g) VISCOSITY (ASTM D4287): : PART A: 11-16 Poise

PART B: 1-3 Poise

MIXED: 7-11 Poise

(h) PACKAGING: Part A: 3 gal in a 5 gal container; Part B 1 gal in a 1 gal container

(i) NUMBER OF COMPONENTS: 2

(j) GLOSS (ASTM D523): 50 – 70 gloss units @ 60°

(k) STORAGE REQUIREMENTS: TEMPERATURE 40 °F MIN. 100°F MAX.

ADDITIONAL PAINT STORAGE REQUIREMENTS: Refer to Standard Item 009-32

(l) VOLATILE ORGANIC COMPOUNDS (VOCS- EPA TEST METHOD 24): 120 g/L (1.0 lbs/gal)

(m) WEIGHT PER AREA OF DRY FILM AT 1 MIL THICKNESS: 0.0063 lbs

(n) SPECIAL PROPERTIES: Interline 783 Buff contains optically active pigmentation, edge retentive, high build, low temperature cure, single coat, and rapid cure.

IV. SURFACE PREPARATION MINIMUM REQUIREMENTS:

(a) INITIAL: Paint only clean, dry surfaces. Remove all grease, oil, soluble contaminants and other detrimental foreign matter by 'solvent cleaning' (SSPC-SP 1). Remove all shop primer, and grit blast clean to SSPC-SP 10 standard.

(b) TOUCH-UP: SSPC-SP11 Power Tool Clean to Bare Metal areas requiring touch-up. Clean and abrade 1" to 2" of coating surface adjacent to touch-up areas with 80 grit sandpaper (or equivalent) to create tie-in and promote adhesion prior to recoating.

(c) PROFILE (INCLUDE METHOD USED): 2 mils MIN. 5mils MAX. (Profilometer Gauge or Testex Replica Tape)

(d) SPECIAL INSTRUCTIONS: N/A

(e) PRIMER REQUIREMENTS: Self priming or prime with Interline 783 primer

(f) MAXIMUM ALLOWABLE CONDUCTIVITY (INCLUDE METHOD USED): Please refer to NAVSEA Standard item 009-32

(g) MAXIMUM DEGREE OF FLASH RUSTING ALLOWED: Refer to NAVSEA Standard item 009-32

SPECIAL SAFETY PRECAUTIONS:

PLEASE REFER TO MATERIAL SAFETY DATA SHEET

V. MIXING PROCEDURES:

(a) MIXING RATIOS BY WEIGHT: NA
BY VOLUME: 3:1 (A:B)

(b) INDUCTION TIME: None

(c) RECOMMENDED CLEANING SOLVENT (NO THINNING ALLOWED): GTA415, GTA407, GTA840 or GTA056

(d) POT LIFE:

< 10 min @ 77°F (Applied by plural feed airless spray)

SPECIAL INSTRUCTIONS: Plural feed spray equipment only recommended. Plural feed spray equipment only recommended. Material is supplied in two containers as a unit. Agitate base (Part A) with power agitator prior to loading paint into the plural component hopper. For additional information please contact you local International Paint Representative or visit http://www.international-marine.com/ApplicationGuidelines/Interline%20783%20-%20Cargo%20Tanks.pdf

VI. APPLICATION:

(a) ENVIRONMENTAL LIMITATIONS:

SUBSTRATE TEMPERATURE:	32°F MIN.	110° F MAX.
AMBIENT TEMPERATURE:	32°F MIN.	110° F MAX.

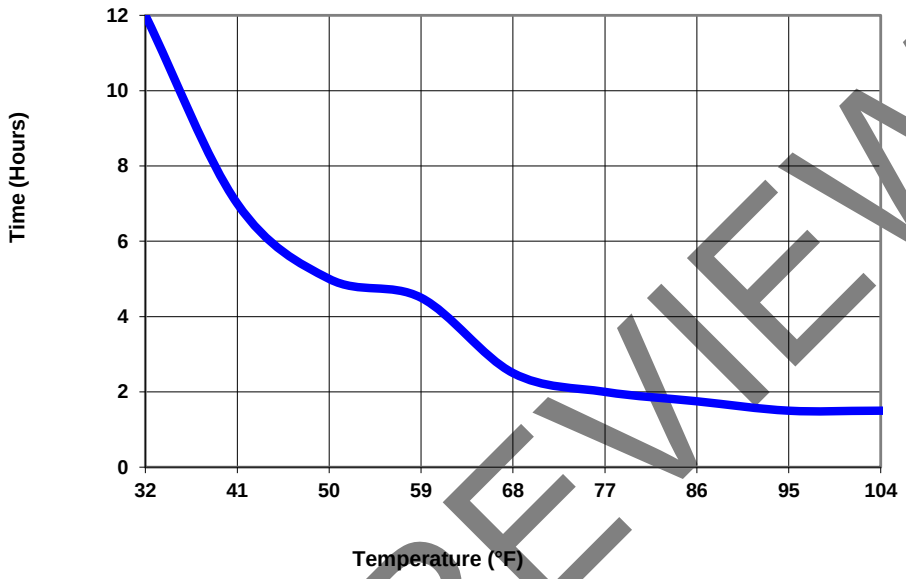
(b) FILM THICKNESS (SSPC PA2-73T) -

PER COAT:		SINGLE COAT SYSTEM	
WET MIN. 8.4 mils	WET MAX. 14.7 mils	WET MIN. 21 mils	WET MAX. 31.6 mils
DRY MIN. 8 mils	DRY MAX. 14 mils	DRY MIN. 20 mils	DRY MAX. 30 mils

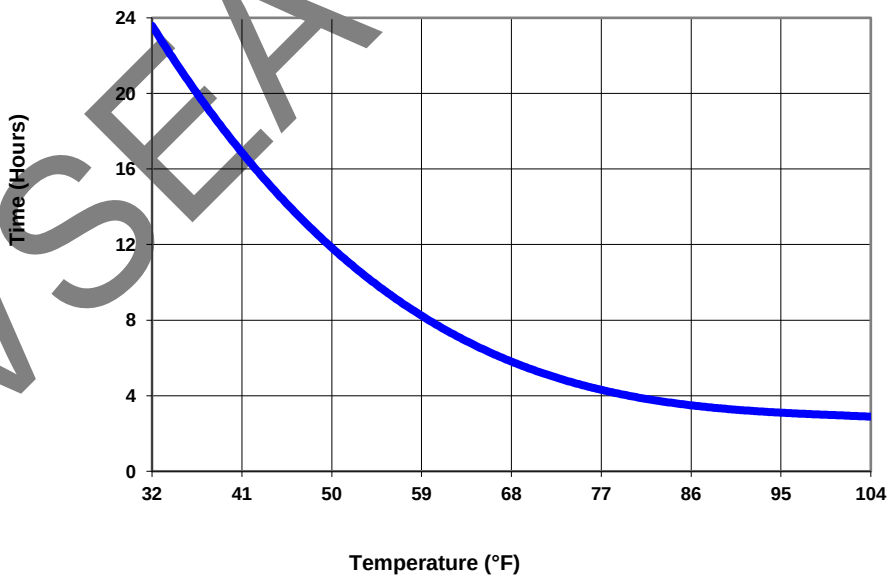
TOTAL SYSTEM:
DRY MIN. NA DRY MAX. NA

(c) DRY TIMES (ASTM D1640): See below Graphs

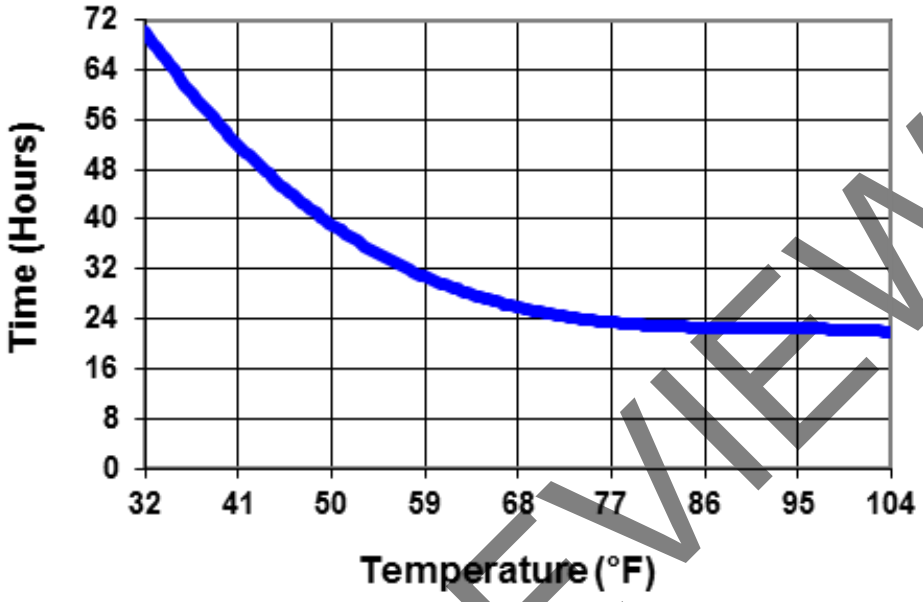
Interline 783: Touch Dry



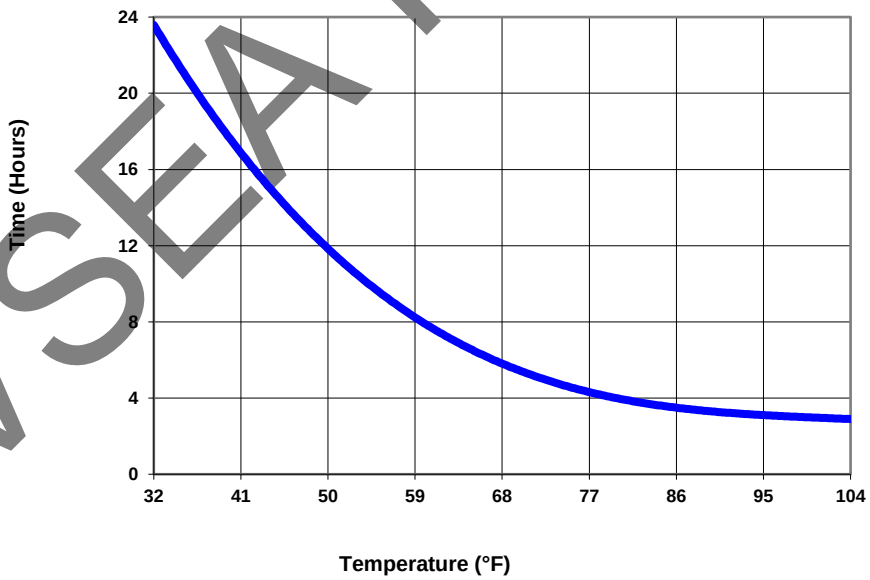
Interline 783: Hard Dry



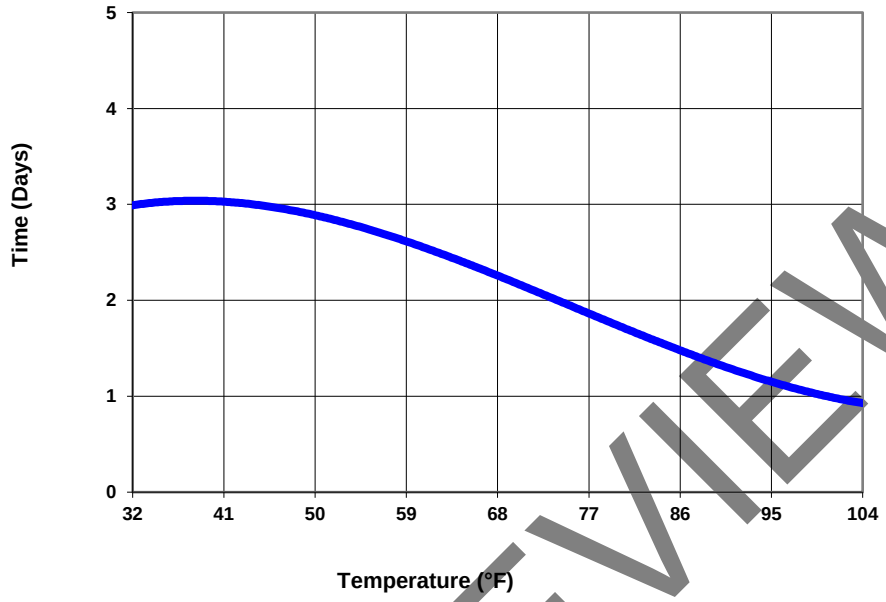
Interline 783: Time to Ballast



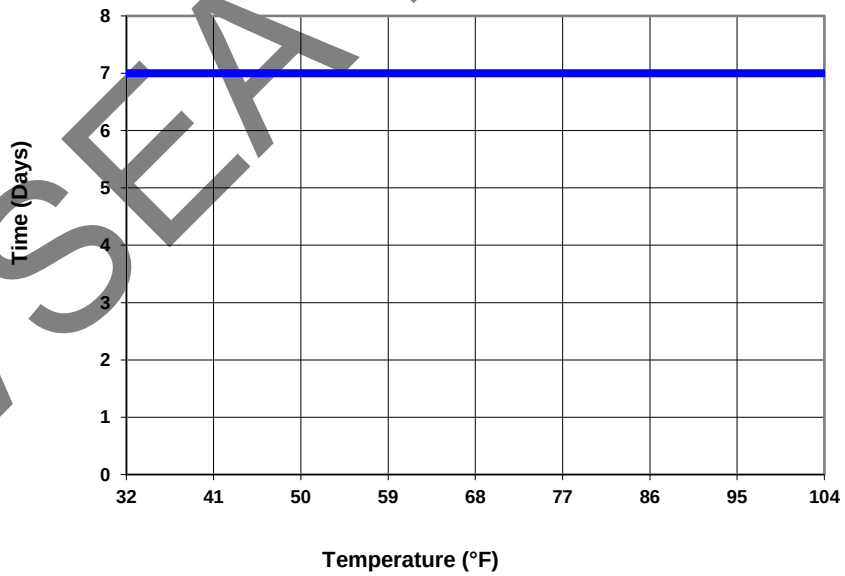
Interline 783: Minimum Overcoating



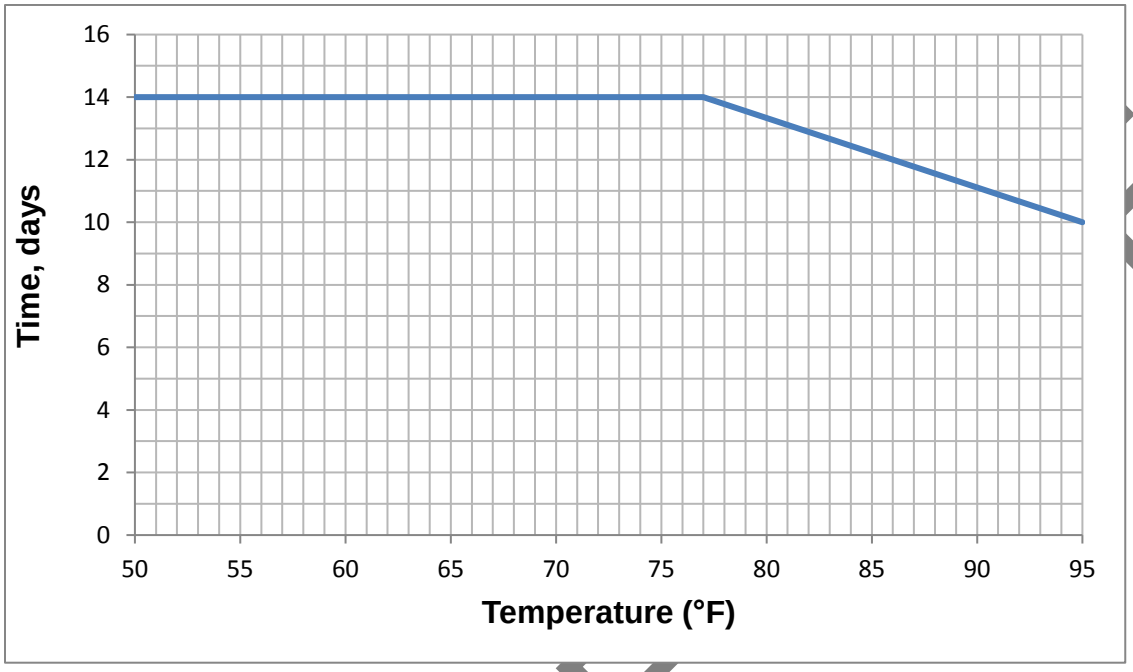
Interline 783: Maximum Overcoating (with UV)



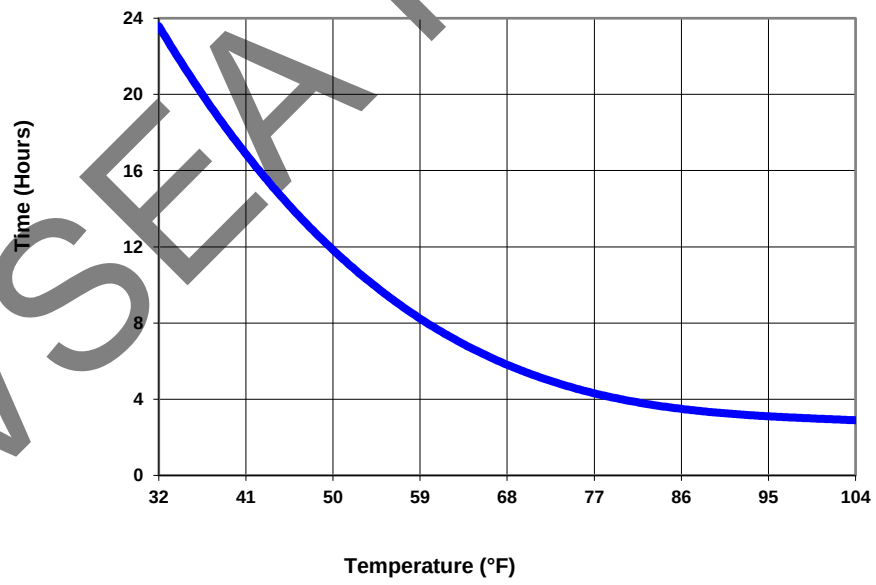
Interline 783: Maximum Overcoating (without UV)



Maximum overcoat of Interline 624 over Interline 783 for stripe coating



Minimum overcoat of Interline 624 over Interline 783 for stripe coating



(d) EQUIPMENT REQUIREMENTS: Plural Feed Airless Spray. Single feed airless spray not recommended. As an alternative method to using rollers, the use of the conventional spray equipment with good mixing and pot life control (but strictly no thinning) can be utilized. Interline 783 should be maintained and applied at a temperature range of 70^0-90^0 F. During application Interline 783 should **not** exceed temperatures of 95^0 F. If mixed product temperatures are allowed to exceed 95^0 F the chemical reaction of the two components will be increased and the workable life of the product will be shortened and risk of product curing in paint lines will be greatly increased. During cold weather applications insulation of paint lines is required to stabilize and maintain the recommended mixed product temperature to the spray-gun. It is also recommended that the line length between the plural feed pumps mixing block to the spray-gun be minimized as much as possible. For additional information please contact you local International Paint Representative or visit http://www.international-marine.com/ApplicationGuidelines/Interline%20783%20-%20Cargo%20Tanks.pdf

(e) SPECIAL INSTRUCTIONS: As per 009-32, Interline 624 is permitted for use with Interline 783 system for touch up and striping.
Recommended pump pressure range between 3,000 – 3,500 psi and product temperature should be between 70^0-90^0 F before feeding to paint lines. It is also recommended that paint line length should not exceed 150 feet past the mixing block. For best application control the recommended tip size range is 15 -19 thousands. For large open areas a 21 thousands tip size may be used (note this will yield a heavier spray pattern and may be more difficult to control wet film thickness).
Mixing ratios **must** be verified prior to application and hoppers must be monitored to prevent cavitations in the spray system as this may result in incorrect mixing ratios.
Do not allow mixed material to remain in hoses, guns or spray equipment. Thoroughly flush all equipment with recommended International thinners. Once units of paint have been mixed they should not be resealed. Prolonged work stoppage is **not** recommended due to short workable life of product. Clean all equipment immediately after use with recommended International thinners. 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. Do not exceed workable life limitations. All surplus materials and empty containers should be disposed of in accordance with appropriate regional regulations/legislation. At ambient temperatures below 70^0 F paint lines need to be insulated to maintain the products recommended temperature range during application. Drying times and overcoating intervals may vary due to on-site factors such as tank size and configuration, environmental engineering controls and ventilation extract rates, etc. Consult your International Paint representative for minimum cure times prior to loading ballast in coated tanks. Overcoating information is given for guidance only and is subject to regional variation depending upon local climate and environmental conditions.

(f)

IF OVERCOAT WINDOW HAS BEEN EXCEEDED FOR CRITICAL APPLICATIONS: If the overcoat window has been exceeded, Clean surface of coating per SSPC-SP 1, aggressively abrade surface with 80 grit sandpaper or equivalent to promote adhesion, clean surface to SSPC-SP 1 again.

ADDITIONAL DATA/INSTRUCTIONS:

II. MANUFACTURERS DATA: ½ gallon kits available for stripe coating. Contact your local International Paint Representative for more information.

III. PROPERTIES:

IV. SURFACE PREPARATION MINIMUM REQUIREMENTS: Cleaning via UHP-WJ does not create an anchor tooth profile. Additional blasting may be necessary to create an acceptable specified profile prior to application of approved primer

V. MIXING PROCEDURES:

VI. APPLICATION REQUIREMENTS:

Dry times are normally a function of humidity, ventilation and temperature. Information given is to be used as a guideline only.

The technical data given herein has been compiled for your assistance and guidance. It is based upon our experience and knowledge. However, as we have no control over the use to which this information is put, no warranty, expressed or implied, is intended or given.