

# MarineLINE® 784

## DESCRIPTION

MarineLINE® is the premier cargo tank coating system available for chemical and product carriers. MarineLINE® is formulated with a patented polymer, designed and engineered with high functional groups per molecule. When heat cured, MarineLINE® coating forms 3-dimensional, screen-like structures with up to 784 cross-links. This far surpasses epoxies that only deliver 2 functional groups with only 4 cross-links.

## FEATURES

- Virtually non-permeable for assurance of product purity
- Faster, easier cleaning
- Maximum versatility to carry a wide range of cargoes
- Excellent flex stressing
- FDA compliant; GRAS - Generally recognized as safe for food grade cargoes
- Superior bond strength and adhesion
- Resistance to wear, abrasion and impact
- Thermal shock resistance -40°C to +150°C (-40°F to +302°F)
- ABS ISO 9001:2015 Certification

## TYPICAL PROPERTIES (MIXED, AS SUPPLIED)

- Stock Colors \_\_\_\_\_ Grey, Red
- V.O.C. as supplied \_\_\_\_\_ Grey: 129 g/L | Red: 130 g/L
- V.O.C. max. at time of use \_\_\_\_\_ Grey: 176 g/L | Red: 178 g/L
- Pot Life \_\_\_\_\_ 75 minutes @ 20°C (68°F)
- Viscosity Reduction \_\_\_\_\_ Reduce with Toluene
- Solids by Volume \_\_\_\_\_ 85%
- Recommended System Film Thickness  
(dry) mils average (Topcoat & Basecoat) \_ Steel: 12 mils (300 microns)
- Finish \_\_\_\_\_ Gloss
- Theoretical Coverage \_\_\_\_\_ 1 coat = 3.2 m<sup>2</sup>/liter @ 150 microns DFT (w/20% loss factor)
- Application Method \_\_\_\_\_ Airless spray, brush, roller
- Shelf Life \_\_\_\_\_ 12 months

## SURFACE PREPARATION

All surfaces to be coated should be clean, dry, and free from all contamination. All oil, grease, and other contaminants must be removed according to SSPC-SP 1 Solvent Cleaning prior to high pressure fresh water washing. All steelwork shall be prepared in accordance with "NACE SP0178 Section 5: Surface Finish Practices." Grind all edges to a minimum 3mm radius. Grind all welds in accordance with NACE SP0178-2007 C Grade. All intermittent or skip welds shall be continuously welded. All weld undercuts and blow holes are to be filled with weld material. Any defects revealed by abrasive blasting are to be appropriately repaired in consultation with the owners representatives prior to beginning coating application. All surfaces to be coated shall be abrasively blasted to ISO 8501-1:2007 Sa 2½ with a 75 to 100 micron blast profile.

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## APPLICATION INFORMATION

**2-Component-Kit** – MarineLINE® 784 is supplied in one- and five-gallon kits that contain the proper ratio of components. Always mix complete kits. Splitting of kits to make smaller quantities are under no circumstances allowed.

**Mixing** – Mechanically agitate Component A (resin) for 1-2 minutes. Slowly add Component B (catalyst) to the resin and mix thoroughly for 3-5 minutes using a high shear (SSPC recommended) mechanical mixer. The mixture must be homogeneous and uniform in consistency.

**Thinner** – Toluene may be used only as needed at a maximum of 5% by volume. Consult MarineLINE® Inspector prior to thinning.

**Spray Equipment** – Airless spray pumps 60:1 or higher. 3 gpm minimum. Recommended airless tip sizes .015 to .020 inch. 100 meter maximum hose length.

**Brush** – Recommended only for stripe coat and touch up/repair.

**Cleanup Thinner** – Acetone (preferred) or MEK.

**Recommended Total System Film Thickness (2 coats)** – 300 microns.

**Recoat Time** – 15°C (59°F) = minimum 16 hours, maximum 8 days

25°C (77°F) = minimum 12 hours, maximum 8 days

35°C (95°F) = minimum 8 hours, maximum 3 days

**Pot Life** – approximately 75 minutes @ 20°C (68°F).

*Please see the MarineLINE® 784 Application Procedures for detailed application instructions. For product recommendations and technical, application and heat curing information contact Advanced Polymer Coatings' customer service. Contact +1 440-937-6218.*

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