MarineLINE®

TECHNICAL DATA SHEET

**This Technical Data Sheet supersedes those previously issued.*

DESCRIPTION

MarineLINE® is a high-performance, two-coat cargo tank coating system consisting of a base coat and top coat. Designed for chemical and product tankers requiring superior chemical resistance, cargo compatibility, and long-term asset protection, MarineLINE® is formulated with APC's patented high-functionality polymer technology. When heat cured, it forms a dense, three-dimensional crosslinked network that helps reduce cargo absorption, improve cleanability, and protect steel cargo tanks exposed to aggressive chemical and product cargoes.

TECHNICAL DATA



Color	Red, Grey
Solids Content, %	85% by volume
Finish	Gloss
VOC's	As supplied Grey 129 g/l (1.08 lb/gal) | Red 130 g/l (1.085 lb/gal) Thinned to max level Grey 176 g/l (1.47 lb/gal) | Red 177 g/l (1.48 lb/gal)
Pot Life	65 minutes at 68°F (20°C)

SUBSTRATE & SURFACE PREPARATION

General	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.
Steel Substrate	All surfaces to be coated shall be abrasively blasted to ISO 8501-1:2007 Sa 2½ with a 75 to 100 micron blast profile.

MIXING & THINNING

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.
Ratio	Five gallon kit Part A: 4.47 gallons (16.9 liters) | Part B: 0.53 gallons (1.99 liters)
Thinning	(if needed) Reduce with 0-5% (by volume) Toluene. Consult MarineLINE® Inspector prior to thinning.

APPLICATION GUIDELINES

Equipment Type	Coating should be applied via airless spray equipment, pump size 60:1 or greater, 3 gpm minimum. Recommended airless tip sizes .015 to .020 inch. 100 meter maximum hose length. *Contact APC Technical Service for additional information	
Dry Film Thickness (Total system thickness)	Average: 10-14 mils DFT (250-350 microns) Minimum: 8 mils DFT (200 microns) Maximum: 24 mils DFT (600 microns)	
Theoretical Coverage	at 1 mil: 1363 ft^2 / gallon (25 microns) at 10 mils: 136 ft^2 / gallon (250 microns) at 12 mils: 114 ft^2 / gallon (300 microns) at 14 mils: 98 ft^2 / gallon (350 microns) *Allow for loss in mixing and application	at 1 mil: 33.4 m^2 / liter (25 microns) at 10 mil: 3.34 m^2 / liter (250 microns) at 12 mils: 2.7 m^2 / liter (300 microns) at 14 mils: 2.4 m^2 / liter (350 microns) *Allow for loss in mixing and application
Re-coat Times	15ºC (59ºF) = minimum 16 hours, maximum 8 days 25ºC (77ºF) = minimum 12 hours, maximum 8 days 35ºC (95ºF) = minimum 8 hours, maximum 3 days	

APPLICATION CONDITIONS

Material	71ºF (22ºC) – 95ºF (35ºC)
Substrate	59ºF (15ºC) – 104ºF (40ºC)
Humidity	Blasting: 50% or lower | Coating: 55% or lower

CLEAN-UP & SAFETY

Clean-up	MarineLINE® can be cleaned up Acetone (preferred) or MEK.
Safety	Consult SDS

PACKAGING, HANDLING & STORAGE

Shelf Life	12 months
Storage	55ºF – 95ºF (13ºC - 35ºC) | 0 - 100% RH Consult SDS or contact APC Technical Service for more info.

Information on TDS documents represent typical data for the mixed coating formulation (part A + part B) using 'as supplied' materials as of the date hereof. All information is correct to the best of our knowledge. Values should not be construed as specifications. Please contact Advanced Polymer Coatings' Technical Service Team if you have any questions related to this data sheet or application.

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ADVANCED POLYMER COATINGS