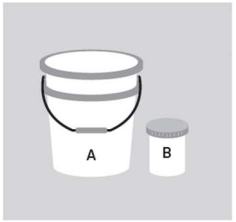

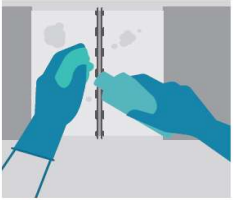
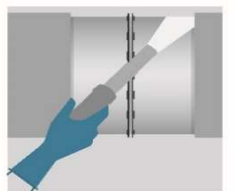
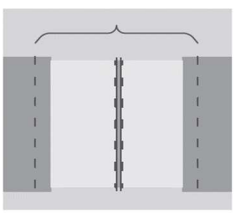
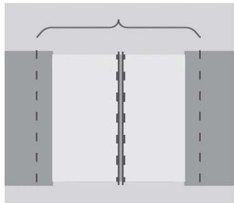
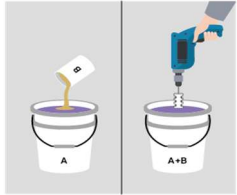
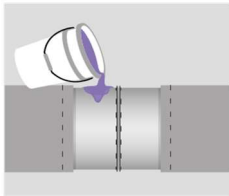
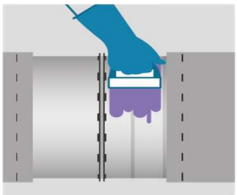
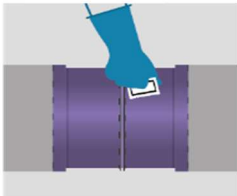
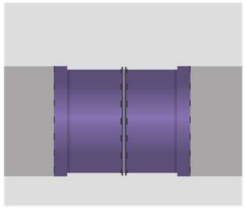


<p>1</p>	<p>Scope Powercrete® R65/F1 is a 100% Solids Epoxy used for corrosion and abrasion protection. This coating that is applied over clean, bare steel and adjacent FBE, Liquid Epoxies or CTE coatings. The application is fast and easy. Simply follow the guidelines</p> <p>The “Standard Kit” contains an installation guide, SDS and a 2-part epoxy coating supplied in pre-measured kits. Part A (large container) is the Base and Part B (small container) is the curing agent. (Figure. 1)</p>	 <p>Figure 1</p>
<p>2</p>	<p>The “Application Kit” contains a mask, Wet Film Gauge, Gloves, trowels, a PE stir stick, a PE mixing paddle and abrasive paper. (Figure. 2)</p>	 <p>Figure 2</p>
<p>3</p>	<p>Clean surfaces of grease, oil, salts and other contaminants using Acetone, MEK or other suitable solvent (consult SFL representative). Perform cleaning when pipe is 3°C (5°F) above dew point. (Figure.3)</p>	 <p>Figure 3</p>
<p>4</p>	<p>Abrade surfaces to a near white ISO Sa 2½ (SSPC-SP 10) or white ISO Sa 3 (SSPC-SP 5), by abrasive blasting with angular media. Sweep blast adjacent FBE coating. Surface profile of 2.5 – 4.5 mils (67.5 to 112 micron) is ideal. Burnishing or polishing must be avoided. Surface preparation shall be evaluated using ASTM D 4417 Method C. Dry surface and insure ideal surface preparation. (Figure. 4)</p>	 <p>Figure 4</p>
<p>5</p>	<p>The adjacent coating must be cleaned and abraded 50 mm (2”) to either side of the cutback (the bare steel area). Follow instructions of specification for overlap on the mainline coating. The use of masking tape to square edges is optional. Abrading the surface to remove all the gloss obtaining a minimum of 2 mils (50 µm) angular profile, is recommended, (Figure.5).</p>	 <p>Figure 5</p>

<p>6</p>	<p>While not always necessary, preheating can be useful to accelerate curing and eliminate moisture. The heating process is suggested to be done before abrasive blasting to reduce risk of contamination and flash rusting. Indirect heating sources are preferred if the process happens after abrasive blasting. To eliminate condensation, preheat the cutback area to approximately 40 °C (104 °F). To accelerate curing, preheat the cutback area to maximum 60 °C (140 °F).</p>	 <p>Figure 5</p>
<p>7</p>	<p>Warm parts A & B to a minimum of 20°C (68°F) and mix by pouring all of part B into part A. Thoroughly scrape container and lid of B. Mix in a way so as not introduce air in the mixture.</p>	 <p>Figure 6</p>
<p>8</p>	<p>Use a mixing speed that uniformly blends the 2 parts, but does not create a vortex in the mixture or spillage. mix for 2 to 3 minutes slow mixing Paddle. Blend both parts to create a uniform color with no streaks. (Figure.6)</p>	 <p>Figure 7</p>
<p>10</p>	<p>Use trowels, brush or roller (Figure. 2) to apply required minimum thickness of coating to the Field Joint. Cover at least 50 mm (2") of the adjacent coating. (Figure. 8, 9)</p> <p>Note: Tape may be applied to left & right 50mm (2") beyond cutback and later removed while the coating is still tacky to create a straight edge and neat appearance</p>	 <p>Figure 8</p>  <p>Figure 9</p>

12	Curing times	25 °C (77 °F)	10°C (50 °F)	 <p>Figure 10</p>
	Dry to touch	25 minutes	2.1 hour	
	Dry to Handle 65 Shore D	55 minutes	7 hours	
	Dry to Trench 75 Shore D	1.1 hours	10 hours	

11 Product Dry Film Thickness for manual application:
 Single coat: 20 mils (500 µm)
 Pot Life at 25 °C (77 °F) is 9 minutes
 Pot Life at 38 °C (100 °F) is 3 minutes

The curing rate* will vary according to pipe and ambient application temperature. Refer to curing rate chart for Powercrete R65/F1 (Hand Applied) to determine when to perform a Shore D check. (Figure 10)

Note: Powercrete R65/F1 may be applied and cured at colder environmental temperatures if the pipe is heated during the application and cure

STORAGE

For optimum performance, store Powercrete® Epoxy products in a dry, well-ventilated area. Maintain products in original packaging and sealed until just before use. Avoid exposure to direct sunlight, rain, snow, dust or other adverse environmental conditions or contaminants.

NOTE: Avoid prolonged storage at temperatures above 40°C (104°F) or below 5°C (40°F).

SAFETY GUIDELINES

Important: Read the MSDS prior to using the products. Product installation should be done in well-ventilated area and in accordance with local health and safety regulations. These application guidelines are intended as a guide for standard products. Consult your Seal For Life Representative.

DISCLAIMER

Seal For Life Industries warrants that the product(s) represented within conform(s) to its/their chemical and physical description and is appropriate for the use as stated on the respective technical data sheet when used in compliance with Seal For Life Industries written instructions. Since many installation factors are beyond the control of Seal For Life Industries, the user is obligated to determine the suitability of the products for the intended use and assume all risks and liabilities in connection herewith. Seal For Life Industries liability is stated in the standard terms and conditions of sale. Seal For Life Industries makes no other warranty either expressed or implied. All information contained in the respective technical data sheet(s) should be used as a guide and is subject to change without notice. This document supersedes all previous revisions. Please see revision date on the left. Powercrete® is a registered trademark of Seal For Life Industries.