

## COATING DATA

### DESCRIPTION:

A two-component, high solids, chemical and corrosion resistant modified polyamidoamine epoxy formulated for excellent protection of steel pipe in severe environments. This product uses a special modified polyamidoamine curing agent which imparts the best properties of both amines and conventional polyamides. This product may be topcoated with Induron Indurethanes.

This product meets the requirements of the Food Safety and Inspection Service of the U. S. Department of Agriculture as chemically acceptable for use in areas where there may be a possibility of incidental food contact.

### Pipe Liner Semi-Gloss Epoxy

Complies with U.S. EPA National Volatile Organic Compound (VOC) Emission Standards for industrial maintenance coatings effective September 13, 1999.

### USE:

To protect steel pipe from chemical and corrosion attack. Use in severe environments which include abrasion, moisture, corrosive fumes, chemical contact, and immersion. These industrial environments include chemical processing plants, power plants, offshore oil and gas equipment, laboratories, pulp and paper mills, structural steel, and others.

### LIMITATIONS:

Not recommended for immersion in concentrated solutions of mineral acids or organic acids. *Not for potable water.*

### SURFACE PREPARATION:

**Steel (Non-Immersion)**—For best results, SSPC-SP 6 Commercial Blast and remove all surface contaminants. **Steel (Immersion)**—For water immersion use SSPC-SP 10 Near White Blast and remove all surface contaminants. Other recommended immersion SSPC-SP 5 White Metal Blast. Vacuum after blasting and recoat all blasted area the same day.

### COVERAGE:

Theoretical—962 ft<sup>2</sup> per gallon at 1.0 mil dry film thickness.

### DRY FILM THICKNESS:

2.0 to 6.0 mils per coat.

### WET FILM THICKNESS:

3.5 to 10 mils.

## APPLICATION DATA

### BLEND RATIO:

One part Perma-Clean II Activator to four parts Perma-Clean II Semi-Gloss Epoxy Base. Power agitate until components are thoroughly mixed. Allow mixed components to stand fifteen minutes prior to application.

### POT LIFE:

Six hours at 80°F, decreasing at higher temperature.

### APPLICATION:

**Airless Spray**—Use .017-.021 tip; 60 mesh filter; 30:1 pump ratio at 60-100 psi operating air pressure.

**Conventional Spray**—Follow instructions of equipment manufacturer for the application of epoxy paints.

**Roll**—Use lambswool cover. Additional coats may be required to achieve desired film thickness. **Brush**—Use natural bristle brush. Additional coats may be required to achieve desired film thickness.

### THINNING:

If required, thin up to 10% with K-1066 Reducer. Clean equipment with K-1066 Reducer.

### CLIMATE:

Use this product only if the substrate temperature and ambient air temperature is above 40°F and is expected not to decrease for at least two hours after application. Also, the substrate temperature must be 5°F above the dewpoint for a period of at least two hours after application to avoid condensation occurring on wet paint.

### DRY TIME:

TO HANDLE—7 hours at 80°F.

TO RECOAT—50°F or higher, over-night; 40°F to 50°F, second day.

**Note:** High film thickness, low temperature and/or poor ventilation will retard dry time.

**Note:** E-60 Accelerator may be used to increase the normal curing rate of reaction to provide a rapid low temperature cure. See E-60 Technical Data Sheet for more information.

### PHYSICAL DATA:

VOLUME SOLIDS: 60% ± 1%

SOLIDS BY WEIGHT: 74% ± 1%

WEIGHT PER GALLON: 10.6 ± .2 lbs per gallon

VOLATILE ORGANIC CONTENTS:

Mixed unthinned - < 2.5 lbs/gallon;

### SAFETY DATA:

See individual product label for safety and health data information. Individual Material Safety Data Sheets are available upon request.