

COVALENCE[®] S1301-M EPOXY PRIMER

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| Description: | S1301-M primer is a specially formulated 100% volume solids (solvent-less) 2 component epoxy. |
| Recommended use: | As an epoxy primer in a 3 layer polyethylene coating system for superior corrosion protection of field welded joints of steel pipes. Can be used with Covalence 3 layer coating systems: HTLP80 (-HP), HTLP60 (-HP), DIRAX, ROCS60E. For HTLP80, DIRAX, ROCS60E the epoxy primer needs to be applied on the steel surface only. For HTLP80-HP and HTLP60 (-HP) the epoxy needs to be applied onto the steel surface AND onto the 3LPE line coating. When the line coating is FBE or CTE the epoxy need to be applied on the line coating for all products. |
| Colour: | Black |
| Volume solids: | 100% |
| Weight solids: | 100% |
| Mixing ratio: | (by volume) : 3 parts of base (part A) to 1 part of hardener (part B) (by weight) : 5 parts of base (part A) to 1 part of hardener (part B) |
| Typical coverage: | 6.0 sq.m/litre (64.7 sq.ft/litre) or 22.7 sq.m/US gallon (244.5 sq.ft/US gallon). This coverage is based on 100-150 microns or 4-6 mils average thickness. |
| Specific gravity: | Base: 1.65 Hardener: 1 |
| Typical thickness: | 100-150 microns (4-6 mils) |
| Pot life: | 30 min at 23°C (73°F), 15 min at 40°C (104°F) |
| Shelf life: | 3 years 23°C (73°F, 163°F), out of direct sunlight. Shelf life will be less at higher temperatures. |
| Flash point: | Part A (Base) : 143°C (289°F) Part B (Hardener): > 118°C (244°F) |
| Thinner: | Do not dilute. |
| Application: | <ol style="list-style-type: none">1. Prepare the pipe surface as recommended in the product application guide.2. Pour hardener into base as per mixing ratio. Stir the mixture for approximately 1 minute to ensure a homogeneous mixture. For twin packs: remove the clip and roll the twin pack for min 1 minute, see detailed application guideline on the twin pack.3. Carefully apply mixed epoxy primer as indicated in the product application guide. |

Epoxy usage on steel surface only:

Assumption: 300 mm or 12" cut back, coverage 6.0 sq m/litre

| Pipe diameter | | Quantity required (ml) | | # Joints/ US gallon | # Joints/ litre |
|---------------|--------|------------------------|--------|------------------------|--------------------|
| DN | inches | Part A | Part B | | |
| 80 | 3.500 | 10.6 | 3.5 | 267 | 70 |
| 100 | 4.500 | 13.7 | 4.6 | 207 | 54 |
| 150 | 6.625 | 20.1 | 6.7 | 141 | 37 |
| 200 | 8.625 | 26.2 | 8.7 | 108 | 28 |
| 250 | 10.750 | 32.6 | 10.9 | 87 | 22 |
| 300 | 12.750 | 38.7 | 12.9 | 73 | 19 |
| 350 | 14.000 | 42.5 | 14.2 | 66 | 17 |
| 400 | 16.000 | 48.6 | 16.2 | 58 | 15 |
| 450 | 18.000 | 54.6 | 18.2 | 51 | 13 |
| 500 | 20.000 | 60.7 | 20.2 | 46 | 12 |
| 550 | 22.000 | 66.8 | 22.3 | 42 | 11 |
| 600 | 24.000 | 72.8 | 24.3 | 38 | 10 |
| 650 | 26.000 | 78.9 | 26.3 | 35 | 9 |
| 700 | 28.000 | 85.0 | 28.3 | 33 | 8 |
| 750 | 30.000 | 91.1 | 30.4 | 31 | 8 |
| 800 | 32.000 | 97.1 | 32.4 | 29 | 7 |
| 850 | 34.000 | 103.2 | 34.4 | 27 | 7 |
| 900 | 36.000 | 109.3 | 36.4 | 25 | 6 |
| 950 | 38.000 | 115.3 | 38.4 | 24 | 6 |
| 1000 | 40.000 | 121.4 | 40.5 | 23 | 6 |

Epoxy usage on steel surface and line coating:

Assumption: 450 mm or 17.5" wide HTLP60 sleeve, epoxy width = sleeve width, coverage 6.0 sq m/litre

| Pipe diameter | | Quantity required (ml) | | # Joints/ US gallon | # Joints/ litre |
|---------------|--------|------------------------|--------|------------------------|--------------------|
| DN | inches | Part A | Part B | | |
| 80 | 3.500 | 15.7 | 5.2 | 180 | 47 |
| 100 | 4.500 | 20.2 | 6.7 | 140 | 37 |
| 150 | 6.625 | 29.7 | 9.9 | 95 | 25 |
| 200 | 8.625 | 38.7 | 12.9 | 73 | 19 |
| 250 | 10.750 | 48.3 | 16.1 | 58 | 15 |
| 300 | 12.750 | 57.2 | 19.1 | 49 | 13 |
| 350 | 14.000 | 62.8 | 20.9 | 45 | 11 |
| 400 | 16.000 | 71.8 | 23.9 | 39 | 10 |
| 450 | 18.000 | 80.3 | 26.9 | 35 | 9 |
| 500 | 20.000 | 89.8 | 29.9 | 31 | 8 |
| 550 | 22.000 | 98.7 | 32.9 | 28 | 7 |
| 600 | 24.000 | 107.7 | 35.9 | 26 | 6 |
| 650 | 26.000 | 116.7 | 38.9 | 24 | 6 |
| 700 | 28.000 | 125.7 | 41.9 | 22 | 5 |
| 750 | 30.000 | 134.7 | 44.9 | 21 | 5 |
| 800 | 32.000 | 143.6 | 47.9 | 19 | 5 |
| 850 | 34.000 | 152.6 | 50.9 | 18 | 4 |
| 900 | 36.000 | 161.6 | 53.9 | 17 | 4 |
| 950 | 38.000 | 170.6 | 56.9 | 16 | 4 |
| 1000 | 40.000 | 179.5 | 59.8 | 15 | 4 |

For other sleeve widths, divide by 17.75 and multiple by new sleeve width in inches.

Example: 20" (508 mm) sleeve width on a DN400 diameter pipe

Part A: 71.8 ml x 20/17.75 = 80.9 ml

Part B: 23.9 ml x 20/17.75 = 26.9 ml

S1301 M Pot Life and Gel Time Chart:

| Temperature | Pot life | Gel time | Dry time | Shore D70 |
|-------------|----------|----------|----------|-------------|
| 20°C | 54 min | 64 min | 117 min | 10 hr |
| 25°C | 29 min | 59 min | 105 min | 8 hr 30 min |
| 30°C | 20 min | 52 min | 80 min | 4 hr 30 min |
| 35°C | 13 min | 46 min | 62 min | 3 hr |
| 40°C | 11 min | 35 min | 43 min | 1 hr 50 min |

Note:

1. Pot life date are obtained by mixing 600 g of Part A and 120 g of Part B. Part A and Part B temperature before mixing is as specified (20, 25, 30, 35 or 40 degrees C) and keep the mixture at the environment of that temperature after mixing.
2. Gel time, dry time and Shore D70 date are from 40-60 mils thin film.

Ordering info:

Twin packs:

The twin packs are available as single twin packs or as a kit with applicator pad and 1 pair of nitrile safety gloves.

Single twin pack: **S1301-M-TP-200ML-300GR(C18)**

Twin pack kit with EQ-PR-APPLICATOR (grey foam pad) & safety gloves:

S1301-M-TP-200ML-300GR-KIT(C10)

Twin pack kit with EQ-PR-APPLICATOR-3 (white foam pad with felt) & safety gloves:

S1301-M-TP-200ML-300GR-KT3(C10)

Other twin pack sizes are made to order only with MOQ of 5000 pc. Min. size is 75 ml, max. size is 300 ml.

Order quantity should be multiples of box quantity xxx indicated in the product description (Cxx).

Bulk Epoxy:

Base : S1301-M-PART-A-18L-29.7KG

Hardener: S1301-M-PART-B-18L-18KG

Always order in multiples of 3 pails of part A by 1 pail of part B.

For accessories to apply epoxy see DS-ACCESSORIES. These need to be ordered separately.

| Information | |
|------------------------|---|
| Documentation | Extensive information is available on our web-site. Application instructions and other documentation can be obtained by contacting our head office, from our local distributor or by sending an email to info@sealforlife.com |
| Certified staff | Application of the described coating system shall be carried out by certified personnel. |



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