

COVALENCE[®] S1401-BLK EPOXY

Description:	S1401-BLK primer is a specially formulated 100% volume solids (solvent less) high temperature two component epoxy.
Recommended use:	As an epoxy primer in a 3 layer coating system for superior corrosion protection of field welded joints of steel pipes operating up to 120°C (248°F). S1401-BLK can be used with Covalence 3 layer coating system HTLP-PP as the initial anti-corrosion layer or as wear cones in the PPS120 and DIRAX-PP systems. For HTLP-PP the epoxy primer needs to be applied onto the steel surface only. S1401-BLK can also be used as repair coating for PP and FBE line coatings.
Colour:	Black
Solids:	100%
Mixing ratio:	(by volume): 5 parts of base (part A) to 1 part of hardener (part B) (by weight) : 100 parts of base (part A) to 12 parts of hardener (part B)
Typical coverage:	2.5 sq.m/litre This coverage is based on 200 microns or 8 mils nominal wet film thickness, including drum and application scrap. For twin packs include 5% extra scrap.
Specific gravity:	Base: 1.7 - Hardener: 1
Typical thickness:	200-300 microns (8-12 mils)
Shelf life:	2 years when stored at temperatures between 5°C (40°F) and 40°C (104°F). Shelf life will be less at higher temperatures.
Flash point:	Part A (Base) : > 93°C (199°F) Part B (Hardener): > 100°C (212°F)
Thinner:	Do not dilute
Storage and handling:	For optimum performance, store S1401-BLK 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. Recommended storage temperatures between +5°C (40°F) and + 40°C (104°F).
Application:	<ol style="list-style-type: none">1. Prepare the pipe surface as recommended in the product application guide. Minimum epoxy temperature part A and B for easy mixing: 30°C (86°F).2. Follow mixing instructions in the product application guideline. Typically part A and B have to be mixed for about 1 min to get a homogenous mix.3. Carefully apply mixed epoxy primer as indicated in the product application guide.

Curing Chart

S1401	20°C	30°C	40°C	50°C
Pot Life	17-20 min.	14-16 min.	11-13 min.	8-10 min.
Gel Time	27-32 min.	23-26 min.	15-18 min.	9-12 min.
Dry time	110-135 min.	55-75 min.	40-50 min.	35-40 min.
Shore D70 at 25°C	60 hrs.	24 hrs.	18 hrs.	10 hrs.

Properties

Properties	Condition	Test method	Typical value	
			US Imperial	Metric
Specific gravity	Mixed	ASTM D3289-D3	1.65-1.7	1.65-1.7
Hardness	Shore D	ASTM D2240, after 72 hrs at 25°C	85	85
Adhesion to steel		ASTM D4541, 7 days after coating	> 2,000 psi	> 13,8 MPa

Ordering info:

Twin pack :

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: **S1401-TP-200ML-317GR-BLK**

Twin pack kit with EQ-PR-APPLICATOR-IN (foam pad with felt) & safety gloves: **S1401-TP-200ML-317G-BLK-KIT**

Twin pack sizes are made to order only. Other twin pack sizes are available on request, minimum order quantities apply, typically min 3000 pc minimum size is 100 ml, maximum size is 250 ml.

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

Bulk Epoxy:

Base: S1401-PART-A-18L-30.6KG-BLK

Hardener: S1401-PART-B-18L-18KG-BLK

Always order in multiples of 5 pails of part A by 1 pail of part B.

Epoxy accessories to mix and apply the epoxy should 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.



Seal For Life Industries - Stopaq B.V.
Stadskanaal, the Netherlands
Tel: +31 599 696 170

Seal For Life Industries BV
Westerlo, Belgium
Tel: +32 14 722 500

Seal For Life Industries US LLC
San Diego, USA
Tel: +1 858 633 9785

Seal For Life Industries Mexico
S de R.L. de C.V.
Tijuana, Mexico
US Tel: +1 858 633 9785
MX Tel: +52 664 647 4300

Seal For Life India Private Ltd.
Baroda, India
Tel: +91 2667 264 721

Further information is available on our website www.sealforlife.com, or by sending an inquiry to info@sealforlife.com

DISCLAIMER: Seal For Life Industries warrants that the product conforms to its chemical and physical description and is appropriate for the use stated on the technical data sheet when used in compliance with Seal For Life Industries' written instructions. Because many installation factors are beyond the control of Seal For Life Industries, the user shall determine the suitability of the products for the intended uses and assume all risks and liabilities in connection herewith. Seal For Life's liability is stated in its General Terms and Conditions of Sale. Seal For Life Industries makes no other warranty either express or implied. All information contained in this document is to be used as a guide and is subject to change without notice. This technical data sheet supersedes all previous data sheets on this product.