

POLYKEN[®] 1619 LIQUID ADHESIVE

Product Information

Product description: The Polyken #1619 is a thermally activated pipeline liquid adhesive designed for use with Polyken's 1600 HT High Temperature Coating Systems. The liquid adhesive consists of a synthetic thermoplastic elastomer blended with heat-activated polymeric resins dissolved in an organic solvent system. When the pipe is heated the result is a cross-linked bonding between liquid adhesive, coating, and pipe which yields excellent soil stress resistance, adhesion, shear resistance, cathodic disbondment resistance and anti-corrosion protection.

Polyken #1619 liquid adhesive is recommended for machine or hand application to abrasive cleaned pipe surfaces and conforms to local and national standards.

Caution:

- Store away from heat source. Read all label instructions prior to use.
- Properly stored, all Polyken[®] liquid coating systems have a shelf life of 3 years. Please request an application specification and storage guideline from Seal For Life.
- Polyken[®] liquid adhesive systems are FLAMMABLE MIXTURES.

Features:

- Excellent adhesion
- Excellent cathodic disbondment resistance
- Conforms to local and national standards

Benefits:

- Ensures permanent bond of coating system
- Provides long term corrosion prevention

Product properties

Property	Typical values
Base	Thermoplastic elastomer and thermally activated synthetic resins
Solvent	Toluene
Total Solids	11.4 %
Weight/Gallon	7.51 lb
Weight/Liter	0.9 kg
Viscosity	Thin Syrup
Flash Point	4°C (39.2°F)
VOC	0.718 kg/l (6.00 lb/gal)
Shelf Life	3 years
Coverage rate (estimated/varies)	200 ft ² /gallon (hand application)
	4.92 m ² /liter (hand application)
	250 ft ² /gallon (spray application)
	6.15 m ² /liter (spray application)

Product selection guide

Max. operating temperature	121°C (250°F)
Additional mechanical layer	Subsequent Polyken coating systems
Compatible line coatings	Carbon steel, PE, FBE, PP,CTE, Tape,
Recommended pipe preparation	SSA-ST2 (SSPC-SP3) or SSA-SA 2 (SSPC-SP6) 1 – 3 mil anchor profile (25 – 76 micron anchor profile)

Product construction

	1619
Adhesive color	Clear

Ordering information

Description
1619-LIQUID ADH 1 GAL-3.8L
1619-LIQUID ADH-5 GAL-18.9L

For other ordering options please contact your Seal For Life representative.

Application instruction: Job preparation	
Tools, equipment and auxiliaries	Temperature gauge, DFT/WFT gauge Primer application equipment/agitator,
Additional coating materials	Subsequent Polyken coating systems, 931, 939
High humidity	Polyken® 1619 can be applied in a humid atmosphere. The substrate should be free from condensing water which can be reached by keeping the temperature at least 5°F (3°C) above dew point.
Work area and substrate	The substrate surface should be dry, clean and protected against negative weather influences.
Product conditions	The Polyken® 1619 shall be stored and/or transported in a dry, ventilated location. Storage temperature shall be a minimum of 60°F (16°C) and a maximum of 125°F (52°C). The minimum primer temperature for application will be 60°F (16°C).

Application instruction: Surface preparation	
General	The area to be coated has to be clean, dry, and free from oil, grease and dust. All contamination including mill-scale has to be removed.
Degreasing	Degrease surfaces with Toluene or Heptane and e.g. a lint-free cloth.
Preventing condensation of water	Prior to and during the application, the temperature of the substrate(s) must be at least 5°F (3°C) above the dew point.
Substrate temperature	Temperature of the substrate should preferably be between +68°F and +104°F (+20°C / +40°C). Preheating may be required.

Application instruction: Brief version	
Step 1	Clean substrate to SSA-ST2, SSPC-SP3 (power wire brush) or SSA-SA 2, SSPC-SP6 (commercial blast). Surface (anchor) profile depth shall be no less than 1.0 mils (25 micron) and no greater than 3 mils (76 micron).
Step 2	Uniform primer application achieving 2 to 3 mil WFT. Primer should be "dry to touch" before application of inner layer.

* For further detailed information, please view the corresponding Application Guideline *

Handling and commissioning	
Exposure to loads	Objects coated with Polyken® 1619 should not be exposed to loads e.g. from supports- or lifting equipment.
Backfill	Backfill is possible immediately after completion of the coating application and after the subsequent Polyken coating system has been applied. Consult application guidelines for specific instructions. Backfill should be clean and not contain any foreign items that can cause damage to the coating system.

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



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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. Becc 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 Te 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 c sheets on this product.