

COVALENCE[®] S1401-M EPOXY

Description:	S1401-M primer is a specially formulated 100% volume solids (solvent less) 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 95°C (203°F). S1401-M can be used with Covalence 3 layer coating system: HTLP80 as the initial anti-corrosion layer.
Colour:	Grey
Solids:	100% volume, 100% weight
Mixing ratio:	(by volume): 3.6 parts of base (part A) to 1 part of hardener (part B) (by weight) : 100 parts of base (part A) to 16 parts of hardener (part B)
Typical coverage:	2 sq.m/litre or 70.7 sq.ft/US gallon. This coverage is based on 300 microns or 12 mils average wet film thickness.
Specific gravity:	Base: 1.85 - Hardener: 1.03
Typical thickness:	100-500 microns (4-20 mils)
Pot life:	14 min at 25°C (77°F)
Shelf life:	2 years when stored at temperatures between 5°C (40°F) and 40°C (104°F).
Flash point:	Part A (Base) : 143°C (289°F) - Part B (Hardener): > 93°C (199.4°F)
Thinner:	Do not dilute
Storage and handling:	For optimum performance, store S1401-M 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 2. Pour hardener into base as per mixing ratio. Stir the mixture for approximately 1 minute to ensure a homogeneous mixture. 3. Carefully apply mixed epoxy primer as indicated in the product application guide.

Property	Condition	Test method	Typical value	
			US Imperial	Metric
Specific gravity	Mixed	ASTM D3289-D3	1.64	1.64
Hardness	Shore D	ASTM D2240	85	85
Dielectric strength	Oil	ASTM D149	690 V/mil	27 V/micron
Adhesion to steel		ASTM D4541	3,550 psi	24 MPa

Ordering info:	Bulk Epoxy: Base: S1401-M-PART-A-15.1L-28KG Hardener: S1401-M-PART-B-17.4L-18KG Always order in multiples of 4 pails of part A by 1 pail of part B Epoxy accessories to mix and apply the epoxy should be ordered separately. For epoxy thickness >= 200 micron the use of EQ-PR-APPLICATOR-3 is recommended.
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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 should be carried out by certified personnel.