

COVALENCE[®] S1301-M EPOXY PRIMER

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	80.28	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.



Seal For Life Industries LLC
Franklin, MA, USA
Tel: +1 508 918 1600
Toll Free: +1 800 248 7659
Fax: +1 508 918 1905
franklin@sealforlife.com

Seal For Life Industries Mexico
S de R.L. de C.V.
Tijuana, Mexico
Tel USA: +1 858 633 9797
Fax USA: +1 858 633 9740
Tel Mx: +52 664 647 4397
Fax Mx: +52 664 607 9105
mexico@sealforlife.com

Seal For Life Industries
Stopaq B.V.
Stadskanaal, the Netherlands
Tel: +31 599 696 170
Fax: +31 599 696 177
info@sealforlife.com

Seal For Life Industries BVBA
Westerlo, Belgium
Tel: +32 14 722 500
Fax: +32 14 722 570
belgium@sealforlife.com

Seal For Life India Private Ltd.
Baroda, India
Tel: +91 2667 264 721
Fax: +91 2667 264 724
india@sealforlife.com

Anodefex® - Stopaq® - Polyken® - Covalence® - Powercrete® - Sealtaq® - Blockr® - Easy.Qote®

DISCLAIMER: Seal For Life Industries warrants that the product(s) represented within conform(s) to its/their chemical and physical description and is appropriate for the use as stated on the respective technical data sheet when used in compliance with Seal For Life Industries written instructions. Since many installation factors are beyond the control of Seal For Life Industries, the user is obligated to determine the suitability of the products for the intended use and assume all risks and liabilities in connection herewith. Seal For Life Industries liability is stated in the standard terms and conditions of sale. Seal For Life Industries makes no other warranty either expressed or implied. All information contained in the respective technical data sheet(s) should be used as a guide and is subject to change without notice. This document supersedes all previous revisions. Please see revision date on the left. Covalence® is a registered trademark of Seal For Life Industries.