

Description:	S1301-M primer is a specially formulated 100% volume solids (solventless) 2 component epoxy
Recommended use:	<p>As a 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, HTLP60, HTLP60-HP, DIRAX, ROCS60E.</p> <p>For HTLP80, DIRAX, ROCS60E the epoxy primer needs to be applied on the steel surface only. For HTLP60 and HTLP60-HP the epoxy needs to be applied onto the steel surface AND onto the line coating, when this line coating is PE, FBE or CTE.</p>
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, 15 min at 40°C
Shelf life:	3 years 23°C (73°F), out of direct sunlight. Shelf life will be lesser 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 guide2. 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.
Ordering info:	<p>Epoxy kit : S1301-M-KIT-1.4SQM-15SQFT This kit includes measured quantities of base resin and hardener, a stirring stick, applicator pad and gloves. This kit contains sufficient primer for up to 1.4 SQM (15 sqft) of coverage.</p> <p>Bulk Epoxy: Base : S1301-M-PART-A-18L-4.75GAL Hardener: S1301-M-PART-B-18L-4.75GAL Always order in multiples of 3 pails of part A by 1 pail of part B For accessories to apply epoxy see DS-ACCESSORIES</p>

Epoxy usage on steel surface only for HTLP80, DIRAX, ROCS60E

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

Pipe diameter		Quantity required		# Joints / US gallon	# Joints / Litre
DN	inches	Part A ml	Part B ml		
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
Pipe diameter		Quantity required		# Joints / US gallon	# Joints / Litre
DN	inches	Part A ml	Part B ml		
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 (PE, FBE, CTE) for HTLP60 and HTLP60-HP

Assumption: 450 mm or 17.75" wide HTLP60 sleeve, epoxy width = sleeve width, coverage 6.0 sq.m/litre

Pipe diameter		Quantity required		# Joints / US gallon	# Joints / Litre
DN	inches	Part A ml	Part B ml		
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	80,8	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 data 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°C, 25°C, 30°C, 35°C or 40°C) and keep the mixture at the environment of that temperature after mixing.
- 2) Gel time, Dry time and Shore D70 data are from 40-60 mils thin film.



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