

- Description:** S1401 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 with operating temperatures up to 120°C. S1401 can be used with Covalence 3 layer coating systems: HTLP80, HTLP60, DIRAX, ROCS60E, and HTLP-PP as the initial anti-corrosion layer or as wear cones in the PPS120 and DIRAX-PP system.  
For HTLP80, DIRAX, ROCS60E, HTLP-PP the epoxy primer needs to be applied on the steel surface only. For HTLP60 the epoxy needs to be applied onto the steel surface AND onto the line coating, when this line coating is PE, FBE or CTE.  
S1401 can also be used as repair coating for PP and FBE line coatings.

- Colour:** Grey
- Volume solids:** 100%
- Weight 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 sq.m/litre (21.52 sq.ft/litre) or 6.6 sq.m/US gallon (70.7 sq.ft/US gallon). This coverage is based on 300 microns or 12 mils average wet film thickness.
- Specific gravity:** Base: 1.8  
Hardener: 1
- Typical thickness:** 100-500 microns (4-20 mils)

**Shelf life:** 2 years 23°C (73°F), out of direct sunlight. Shelf life will be lesser at higher temperatures.

**Flash point:** Part A (Base): 252°C (485.6°F)  
Part B (Hardener): 257°C (494.6°F)

**Thinner:** Do not dilute

**Application**

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.

## Curing Chart:

S1401	10°C	20°C	30°C	40°C	50°C
Pot Life	19-21 minutes	13-15 minutes	10-12 minutes	7-9 minutes	5-7 minutes
Gel Time	20-22 minutes	17-20 minutes	16-19 minutes	14-17 minutes	10-13 minutes
Dry time	80-100 minutes	50-60 minutes	40-50 minutes	30-40 minutes	20-30 minutes
Shore D 70	30 -40 hours	20-25 hours	5-10 hours	2- 4 hours	1- 2 hours

## Ordering info:

### Epoxy kit:

#### **S1401-KIT-0.5L-0.13GAL/WA(C10)**

This kit only includes measured quantities of base resin and hardener. Order quantity should be multiples of 10. Epoxy accessories to mix and apply the epoxy should be ordered separately.

### Twin pack:

**S1401-TP-100ML-169GR(C100)**

**S1401-TP-150ML-252GR(C50)**

**S1401-TP-200ML-337GR(C50)**

**S1401-TP-250ML-421GR(C50)**

Minimum order quantities apply for epoxy twin packs. Special twin pack contents can be ordered for MOQ of 5000 pc.

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

Epoxy primer pads and safety gloves to apply the epoxy should be ordered separately.

### Bulk Epoxy:

Base : **S1401-PART-A-18L-4.75GAL**

Hardener: **S1401-PART-B-18L-4.75GAL**

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.

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