

**TABLE 1: EPOXY KITS**  
**EPOXY ON THE BARE STEEL AND ON THE LINE COATING**

S1239-EPOXY KITS		Sleeve width										
PIPE DIAMETER		10"	11"	17"	18"	20"	24"	26"	28"	30"	34"	36"
Inch	DN	260	286		464	514	616	667	718	768	870	921
2.375	50	1/5	1/5	1/5	1/5	1/5	1/5	1/5	1/5	1/5	1/5	1/5
2.875	65	1/5	1/5	1/5	1/5	1/5	1/5	1/5	1/5	1/5	1/5	1/5
3.500	80	1/5	1/5	1/5	1/5	1/5	1/5	1/5	1/5	1/5	1/4	1/4
4.000		1/5	1/5	1/5	1/5	1/5	1/5	1/5	1/5	1/4	1/4	1/4
4.500	100	1/5	1/5	1/5	1/5	1/5	1/5	1/4	1/4	1/4	1/3	1/3
5.000		1/5	1/5	1/5	1/5	1/5	1/4	1/4	1/4	1/3	1/3	1/3
5.563	125	1/5	1/5	1/5	1/5	1/5	1/4	1/3	1/3	1/3	1/3	1/2
6.625	150	1/5	1/5	1/4	1/4	1/4	1/3	1/3	1/3	1/2	1/2	1/2
7.625	175	1/5	1/4	1/4	1/3	1/3	1/2	1/2	1/2	1/2	1/2	
8.625	200	1/5	1/5	1/3	1/3	1/3	1/2	1/2	1/2	1/2	2/3	2/3
10.750	250	1/4	1/4	1/3	1/2	1/2	1/2	1/2	2/3	2/3	2/3	2/3
12.750	300	1/3	1/3	1/2	1/2	1/2	2/3	2/3	2/3	2/3	1	1
14.000	350	1/3	1/3	1/2	1/2	2/3	2/3	2/3	1	1	1	1
16.000	400	1/3	1/2	1/2	2/3	2/3	1	1	1	1	1	1
18.000	450	1/2	1/2	2/3	2/3	2/3	1	1	1	1	3/2	3/2
20.000	500	1/2	1/2	2/3	2/3	1	1	1	1	3/2	3/2	3/2
22.000	550	1/2	1/2	1	1	1	1	1	3/2	3/2	3/2	3/2
24.000	600	1/2	2/3	1	1	1	3/2	3/2	3/2	3/2	3/2	3/2
26.000	650	2/3	2/3	1	1	1	3/2	3/2	3/2	3/2	2	2
28.000	700	2/3	2/3	1	1	3/2	3/2	3/2	3/2	3/2	2	2
30.000	750	2/3	2/3	1	1	3/2	3/2	3/2	3/2	2	2	2
32.000	800	2/3	1	1	3/2	3/2	3/2	3/2	2	2	2	2
34.000	850	1	1	3/2	3/2	3/2	3/2	2	2	2	2	3
36.000	900	1	1	3/2	3/2	3/2	2	2	2	2	3	3
38.000	950	1	1	3/2	3/2	3/2	2	2	2	2	3	3
40.000	1000	1	1	3/2	3/2	3/2	2	2	2	3	3	3
42.000	1050	1	1	3/2	3/2	2	2	2	3	3	3	3
44.000	1100	1	1	3/2	3/2	2	2	2	3	3	3	3
46.000	1150	1	1	3/2	3/2	2	2	3	3	3	3	3
48.000	1200	1	3/2	3/2	2	2	3	3	3	3	3	3
50.000	1250	1	3/2	2	2	2	3	3	3	3	3	4
52.000	1300	3/2	3/2	2	2	2	3	3	3	3	4	4
54.000	1350	3/2	3/2	2	2	2	3	3	3	3	4	4
56.000	1400	3/2	3/2	2	2	3	3	3	3	3	4	4
58.000	1450	3/2	3/2	2	2	3	3	3	3	4	4	4
60.000	1500	3/2	3/2	2	2	3	3	3	3	4	4	4

**Note:** 1/5 means 1 kit is recommended for 5 sleeves, 2/3 means 2 kits for each 3 sleeves, etc.  
 Due to the limited pot life (30 minutes once kit components are mixed), it may be impractical to coat multiple joints.  
 For maintenance, use 1 kit per sleeve.

**TABLE 2: EPOXY KITS**  
**EPOXY ONLY ON THE BARE STEEL**

S1239 EPOXY KITS		Pipe cutback (only one pipe / one side of the joint)							
PIPE DIAMETER		3"	4"	5"	6"	7"	8"	9"	10"
Inch	DN	75	100	125	150	175	200	225	250
2.375	50	1/5	1/5	1/5	1/5	1/5	1/5	1/5	1/5
2.875	65	1/5	1/5	1/5	1/5	1/5	1/5	1/5	1/5
3.500	80	1/5	1/5	1/5	1/5	1/5	1/5	1/5	1/5
4.000		1/5	1/5	1/5	1/5	1/5	1/5	1/5	1/5
4.500	100	1/5	1/5	1/5	1/5	1/5	1/5	1/5	1/5
5.000		1/5	1/5	1/5	1/5	1/5	1/5	1/5	1/5
5.563	125	1/5	1/5	1/5	1/5	1/5	1/5	1/5	1/5
6.625	150	1/5	1/5	1/5	1/5	1/5	1/5	1/4	1/4
7.625		1/5	1/5	1/5	1/5	1/5	1/4	1/4	1/3
8.625	200	1/5	1/5	1/5	1/5	1/4	1/4	1/3	1/3
10.750	250	1/5	1/5	1/5	1/4	1/3	1/3	1/3	1/2
12.750	300	1/5	1/5	1/4	1/3	1/3	1/2	1/2	1/2
14.000	350	1/5	1/5	1/4	1/3	1/3	1/2	1/2	1/2
16.000	400	1/5	1/4	1/3	1/3	1/2	1/2	1/2	2/3
18.000	450	1/5	1/4	1/3	1/2	1/2	1/2	2/3	2/3
20.000	500	1/4	1/3	1/2	1/2	1/2	2/3	2/3	1
22.000	550	1/4	1/3	1/2	1/2	2/3	2/3	2/3	1
24.000	600	1/4	1/3	1/2	1/2	2/3	2/3	1	1
26.000	650	1/3	1/2	1/2	2/3	2/3	1	1	1
28.000	700	1/3	1/2	1/2	2/3	2/3	1	1	1
30.000	750	1/3	1/2	2/3	2/3	1	1	1	3/2
32.000	800	1/3	1/2	2/3	2/3	1	1	1	3/2
34.000	850	1/2	1/2	2/3	1	1	1	3/2	3/2
36.000	900	1/2	1/2	2/3	1	1	1	3/2	3/2
38.000	950	1/2	2/3	2/3	1	1	3/2	3/2	3/2
40.000	1000	1/2	2/3	1	1	1	3/2	3/2	3/2
42.000	1050	1/2	2/3	1	1	1	3/2	3/2	3/2
44.000	1100	1/2	2/3	1	1	3/2	3/2	3/2	3/2
46.000	1150	1/2	2/3	1	1	3/2	3/2	3/2	2
48.000	1200	1/2	2/3	1	1	3/2	3/2	3/2	2
50.000	1250	2/3	1	1	3/2	3/2	3/2	2	2
52.000	1300	2/3	1	1	3/2	3/2	3/2	2	2
54.000	1350	2/3	1	1	3/2	3/2	3/2	2	2
56.000	1400	2/3	1	1	3/2	3/2	2	2	2
58.000	1450	2/3	1	1	3/2	3/2	2	2	2
60.000	1500	2/3	1	3/2	3/2	3/2	2	2	3

**Note:** 1/5 means 1 kit is recommended for 5 sleeves, 2/3 means 2 kits for each 3 sleeves, etc.  
Due to the limited pot life (30 minutes once kit components are mixed), it may be impractical to coat multiple joints.  
For maintenance, use 1 kit per sleeve.

**TABLE 3: BULK EPOXY PART A  
EPOXY ON THE BARE STEEL AND ON THE LINE COATING**

for 1000 sleeves S1239 PART A (kg)		Sleeve width										
Pipe diameter Inch	DN	10" 260	11" 286	17" 438	18" 464	20" 514	24" 616	26" 667	28" 718	30" 768	34" 870	36" 921
2375	50	8.40	9.09	13.21	13.90	15.27	18.02	19.40	20.77	22.15	24.89	26.27
2875	65	10.17	11.00	15.99	16.82	18.49	21.81	23.48	25.14	26.81	30.14	31.80
3500	80	12.38	13.39	19.47	20.48	22.51	26.56	28.58	30.61	32.63	36.69	38.71
4000		14.14	15.30	22.25	23.41	25.72	30.35	32.67	34.98	37.30	41.93	44.24
4500	100	15.91	17.21	25.03	26.33	28.94	34.14	36.75	39.35	41.96	47.17	49.77
5000		17.68	19.13	27.81	29.26	32.15	37.94	40.83	43.73	46.62	52.41	55.30
5563	125	19.67	21.28	30.94	32.55	35.77	42.21	45.43	48.65	51.87	58.31	61.53
6625	150	23.43	25.34	36.85	38.76	42.60	50.27	54.10	57.94	61.77	69.44	73.28
7625		26.96	29.17	42.41	44.62	49.03	57.86	62.27	66.68	71.10	79.92	84.34
8625	200	30.50	32.99	47.97	50.47	55.46	65.44	70.44	75.43	80.42	90.40	95.40
10750	250	38.01	41.12	59.79	62.90	69.12	81.57	87.79	94.01	100.23	112.68	118.90
12750	300	45.09	48.77	70.91	74.60	81.98	96.74	104.12	111.50	118.88	133.64	141.02
14000	350	49.51	53.56	77.87	81.92	90.02	106.23	114.33	122.43	130.54	146.74	154.85
16000	400	56.58	61.21	88.99	93.62	102.88	121.40	130.66	139.92	149.19	167.71	176.97
18000	450	63.65	68.86	100.11	105.32	115.74	136.58	147.00	157.41	167.83	188.67	199.09
20000	500	70.72	76.51	111.24	117.03	128.60	151.75	163.33	174.91	186.48	209.63	221.21
22000	550	77.79	84.16	122.36	128.73	141.46	166.93	179.66	192.40	205.13	230.60	243.33
24000	600	84.87	91.81	133.48	140.43	154.32	182.10	196.00	209.89	223.78	251.56	265.45
26000	650	91.94	99.46	144.61	152.13	167.18	197.28	212.33	227.38	242.43	272.52	287.57
28000	700	99.01	107.11	155.73	163.84	180.04	212.45	228.66	244.87	261.07	293.49	309.69
30000	750	106.08	114.76	166.86	175.54	192.90	227.63	244.99	262.36	279.72	314.45	331.81
32000	800	113.15	122.41	177.98	187.24	205.76	242.81	261.33	279.85	298.37	335.41	353.93
34000	850	120.23	130.07	189.10	198.94	218.62	257.98	277.66	297.34	317.02	356.38	376.06
36000	900	127.30	137.72	200.23	210.65	231.48	273.16	293.99	314.83	335.67	377.34	398.18
38000	950	134.37	145.37	211.35	222.35	244.34	288.33	310.33	332.32	354.31	398.30	420.30
40000	1000	141.44	153.02	222.47	234.05	257.20	303.51	326.66	349.81	372.96	419.27	442.42
42000	1050	148.51	160.67	233.60	245.75	270.06	318.68	342.99	367.30	391.61	440.23	464.54
44000	1100	155.59	168.32	244.72	257.46	282.92	333.86	359.32	384.79	410.26	461.19	486.66
46000	1150	162.66	175.97	255.85	269.16	295.78	349.03	375.66	402.28	428.91	482.16	508.78
48000	1200	169.73	183.62	266.97	280.86	308.64	364.21	391.99	419.77	447.55	503.12	530.90
50000	1250	176.80	191.27	278.09	292.56	321.50	379.38	408.32	437.26	466.20	524.08	553.02
52000	1300	183.87	198.92	289.22	304.27	334.36	394.56	424.66	454.75	484.85	545.05	575.14
54000	1350	190.95	206.57	300.34	315.97	347.22	409.73	440.99	472.24	503.50	566.01	597.26
56000	1400	198.02	214.23	311.46	327.67	360.08	424.91	457.32	489.73	522.15	586.97	619.39
58000	1450	205.09	221.88	322.59	339.37	372.94	440.08	473.65	507.22	540.80	607.94	641.51
60000	1500	212.16	229.53	333.71	351.08	385.80	455.26	489.99	524.72	559.44	628.90	663.63

**Note:** One drum of part A contains 20 kg (14,7 L)

**TABLE 4: BULK EPOXY PART B  
EPOXY ON THE BARE STEEL AND ON THE LINE COATING**

for 1000 sleeves S1239 PART B (kg)		Sleeve width										
Pipe diameter		10"	11"	17"	18"	20"	24"	26"	28"	30"	34"	36"
Inch	DN	260	286	438	464	514	616	667	718	768	870	921
2375	50	3.35	3.63	5.28	5.55	6.10	7.20	7.75	8.30	8.85	9.95	10.50
2875	65	4.06	4.39	6.39	6.72	7.39	8.72	9.39	10.05	10.72	12.05	12.72
3500	80	4.95	5.35	7.78	8.19	9.00	10.62	11.43	12.24	13.05	14.67	15.48
4000		5.65	6.12	8.89	9.36	10.28	12.14	13.06	13.99	14.91	16.77	17.69
4500	100	6.36	6.88	10.01	10.53	11.57	13.65	14.70	15.74	16.78	18.86	19.90
5000		7.07	7.65	11.12	11.70	12.86	15.17	16.33	17.49	18.64	20.96	22.12
5563	125	7.86	8.51	12.37	13.02	14.30	16.88	18.17	19.46	20.74	23.32	24.61
6625	150	9.37	10.13	14.73	15.50	17.04	20.10	21.64	23.17	24.70	27.77	29.31
7625		10.78	11.66	16.96	17.84	19.61	23.14	24.90	26.67	28.43	31.96	33.73
8625	200	12.19	13.19	19.18	20.18	22.18	26.17	28.17	30.17	32.16	36.16	38.15
10750	250	15.20	16.44	23.91	25.16	27.64	32.62	35.11	37.60	40.09	45.07	47.56
12750	300	18.03	19.51	28.36	29.84	32.79	38.69	41.64	44.60	47.55	53.45	56.40
14000	350	19.80	21.42	31.14	32.76	36.00	42.49	45.73	48.97	52.21	58.69	61.93
16000	400	22.63	24.48	35.59	37.44	41.15	48.56	52.26	55.97	59.67	67.08	70.78
18000	450	25.45	27.54	40.04	42.12	46.29	54.63	58.79	62.96	67.13	75.46	79.63
20000	500	28.28	30.60	44.49	46.81	51.44	60.70	65.33	69.96	74.59	83.85	88.48
22000	550	31.117	33.66	48.94	51.49	56.58	66.77	71.86	76.95	82.05	92.23	97.33
24000	600	33.94	36.72	53.39	56.17	61.72	72.84	78.39	83.95	89.51	100.62	106.18
26000	650	36.77	39.78	57.84	60.85	66.87	78.91	84.93	90.95	96.97	109.00	115.02
28000	700	39.60	42.84	62.29	65.53	72.01	84.98	91.46	97.94	104.42	117.39	123.87
30000	750	42.43	45.90	66.74	70.21	77.16	91.05	97.99	104.94	111.88	125.78	132.72
32000	800	45.26	48.96	71.19	74.89	82.30	97.12	104.53	111.93	119.34	134.16	141.57
34000	850	48.09	52.02	75.64	79.57	87.44	103.19	111.06	118.93	126.80	142.55	150.42
36000	900	50.91	55.08	80.09	84.25	92.59	109.26	117.59	125.93	134.26	150.93	159.27
38000	950	53.74	58.14	84.54	88.93	97.73	115.33	124.13	132.92	141.72	159.32	168.11
40000	1000	56.57	61.20	88.98	93.62	102.88	121.40	130.66	139.92	149.18	167.70	176.96
42000	1050	59.40	64.26	93.43	98.30	108.02	127.47	137.19	146.92	156.64	176.09	185.81
44000	1100	62.23	67.32	97.88	102.98	113.16	133.54	143.72	153.91	164.10	184.47	194.66
46000	1150	65.06	70.38	102.33	107.66	118.31	139.61	150.26	160.91	171.56	192.86	203.51
48000	1200	67.89	73.44	106.78	112.34	123.45	145.68	156.79	167.90	179.02	201.2	212.36
50000	1250	70.72	76.50	111.23	117.02	128.60	151.75	163.32	174.90	186.48	209.63	221.20
52000	1300	73.55	79.56	115.68	121.70	133.74	157.82	169.86	181.90	193.94	218.01	230.05
54000	1350	76.37	82.62	120.13	126.38	138.88	163.89	176.39	188.89	201.39	226.40	238.90
56000	1400	79.20	85.69	124.58	131.06	144.03	169.96	182.92	195.89	208.85	234.78	247.75
58000	1450	82.03	88.75	129.03	135.74	149.17	176.03	189.46	202.89	216.31	243.17	256.60
60000	1500	84.86	91.81	133.48	140.43	154.32	182.10	195.99	209.88	223.77	251.56	265.45

*Note: One drum of part B contains 16 kg (17 L)*

**TABLE 5: BULK EPOXY PART A  
EPOXY ONLY ON THE BARE STEEL**

S1239 EPOXY KITS PIPE DIAMETER		Pipe cutback (only one pipe / one side of the joint)							
Inch	DN	3" 75	4" 100	5" 125	6" 150	7" 175	8" 200	9" 225	10" 250
2.375	50	1/5	1/5	1/5	1/5	1/5	1/5	1/5	1/5
2.875	65	1/5	1/5	1/5	1/5	1/5	1/5	1/5	1/5
3.500	80	1/5	1/5	1/5	1/5	1/5	1/5	1/5	1/5
4.000		1/5	1/5	1/5	1/5	1/5	1/5	1/5	1/5
4.500	100	1/5	1/5	1/5	1/5	1/5	1/5	1/5	1/5
5.000		1/5	1/5	1/5	1/5	1/5	1/5	1/5	1/5
5.563	125	1/5	1/5	1/5	1/5	1/5	1/5	1/5	1/5
6.625	150	1/5	1/5	1/5	1/5	1/5	1/5	1/4	1/4
7.625		1/5	1/5	1/5	1/5	1/5	1/4	1/4	1/3
8.625	200	1/5	1/5	1/5	1/5	1/4	1/4	1/3	1/3
10.750	250	1/5	1/5	1/5	1/4	1/3	1/3	1/3	1/2
12.750	300	1/5	1/5	1/4	1/3	1/3	1/2	1/2	1/2
14.000	350	1/5	1/5	1/4	1/3	1/3	1/2	1/2	1/2
16.000	400	1/5	1/4	1/3	1/3	1/2	1/2	1/2	2/3
18.000	450	1/5	1/4	1/3	1/2	1/2	1/2	2/3	2/3
20.000	500	1/4	1/3	1/2	1/2	1/2	2/3	2/3	1
22.000	550	1/4	1/3	1/2	1/2	2/3	2/3	2/3	1
24.000	600	1/4	1/3	1/2	1/2	2/3	2/3	1	1
26.000	650	1/3	1/2	1/2	2/3	2/3	1	1	1
28.000	700	1/3	1/2	1/2	2/3	2/3	1	1	1
30.000	750	1/3	1/2	2/3	2/3	1	1	1	3/2
32.000	800	1/3	1/2	2/3	2/3	1	1	1	3/2
34.000	850	1/2	1/2	2/3	1	1	1	3/2	3/2
36.000	900	1/2	1/2	2/3	1	1	1	3/2	3/2
38.000	950	1/2	2/3	2/3	1	1	3/2	3/2	3/2
40.000	1000	1/2	2/3	1	1	1	3/2	3/2	3/2
42.000	1050	1/2	2/3	1	1	1	3/2	3/2	3/2
44.000	1100	1/2	2/3	1	1	3/2	3/2	3/2	3/2
46.000	1150	1/2	2/3	1	1	3/2	3/2	3/2	2
48.000	1200	1/2	2/3	1	1	3/2	3/2	3/2	2
50.000	1250	2/3	1	1	3/2	3/2	3/2	2	2
52.000	1300	2/3	1	1	3/2	3/2	3/2	2	2
54.000	1350	2/3	1	1	3/2	3/2	3/2	2	2
56.000	1400	2/3	1	1	3/2	3/2	2	2	2
58.000	1450	2/3	1	1	3/2	3/2	2	2	2
60.000	1500	2/3	1	3/2	3/2	3/2	2	2	3

**Note:** One drum of part A contains 20 kg (14,7 L)

**TABLE 6: BULK EPOXY PART B  
EPOXY ONLY ON THE BARE STEEL**

for 1000 sleeves S1239 PART B (kg)		Pipe cutback (only one pipe / one side of the welded joint)							
Pipe diameter		3"	4"	5"	6"	7"	8"	9"	10"
Inch	DN	75	100	125	150	175	200	225	250
2375	50	1.65	2.19	2.74	3.29	3.84	4.39	4.94	5.49
2875	65	1.99	2.66	3.32	3.99	4.65	5.32	5.99	6.65
3500	80	2.43	3.24	4.05	4.86	5.67	6.48	7.29	8.10
4000		2.77	3.70	4.63	5.55	6.48	7.40	8.33	9.26
4500	100	3.12	4.16	5.20	6.25	7.29	8.33	9.37	10.41
5000		3.47	4.63	5.78	6.94	8.10	9.26	10.41	11.57
5563	125	3.86	5.15	6.44	7.72	9.01	10.30	11.59	12.87
6625	150	4.60	6.13	7.66	9.20	10.73	12.27	13.80	15.33
7625		5.29	7.06	8.82	10.59	12.35	14.12	15.88	17.65
8625	200	5.99	7.98	9.98	11.98	13.97	15.97	17.97	19.96
10750	250	7.46	9.95	12.44	14.93	17.42	19.91	22.40	24.88
12750	300	8.85	11.80	14.75	17.71	20.66	23.61	26.56	29.51
14000	350	9.72	12.96	16.20	19.44	22.68	25.93	29.17	32.41
16000	400	11.11	14.81	18.52	22.22	25.93	29.63	33.33	37.04
18000	450	12.50	16.66	20.83	25.00	29.17	33.33	37.50	41.67
20000	500	13.89	18.52	23.15	27.78	32.41	37.04	41.67	46.30
22000	550	15.28	20.37	25.46	30.56	35.65	40.74	45.84	50.93
24000	600	16.66	22.22	27.78	33.33	38.89	44.45	50.00	55.56
26000	650	18.05	24.07	30.09	36.11	42.13	48.15	54.17	60.19
28000	700	19.44	25.93	32.41	38.89	45.37	51.86	58.34	64.82
30000	750	20.83	27.78	34.72	41.67	48.61	55.56	62.51	69.45
32000	800	22.22	29.63	37.04	44.45	51.86	59.26	66.67	74.08
34000	850	23.61	31.48	39.35	47.23	55.10	62.97	70.84	78.71
36000	900	25.00	33.33	41.67	50.00	58.34	66.67	75.01	83.34
38000	950	26.39	35.19	43.98	52.78	61.58	70.38	79.18	87.97
40000	1000	27.78	37.04	46.30	55.56	64.82	74.08	83.34	92.60
42000	1050	29.17	38.89	48.61	58.34	68.06	77.79	87.51	97.23
44000	1100	30.56	40.74	50.93	61.12	71.30	81.49	91.68	101.86
46000	1150	31.95	42.60	53.25	63.90	74.55	85.19	95.84	106.49
48000	1200	33.33	44.45	55.56	66.67	77.79	88.90	100.01	111.13
50000	1250	34.72	46.30	57.88	69.45	81.03	92.60	104.18	115.76
52000	1300	36.11	48.15	60.19	72.23	84.27	96.31	108.35	120.39
54000	1350	37.50	50.00	62.51	75.01	87.51	100.01	112.51	125.02
56000	1400	38.89	51.86	64.82	77.79	90.75	103.72	116.68	129.65
58000	1450	40.28	53.71	67.14	80.56	93.99	107.42	120.85	134.28
60000	1500	41.67	55.56	69.45	83.34	97.23	111.13	125.02	138.91

*Note: One drum of part B contains 16 kg (17 L)*