

COVALENCE[®] S1401 EPOXY

Description:	S1401 primer is a specially formulated 100% volume solids (solvent less) high temperature 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 120°C (248°F). S1401 can be used with Covalence 3 layer coating system: HTLP80, 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 onto the steel surface only. S1401 can also be used as repair coating for PP and FBE line coatings.
Colour:	Grey
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 or 70.7 sq.ft/US gallon. This coverage is based on 300 microns or 12 mils average wet film thickness.
Specific gravity:	Base: 1.8 - Hardener: 1
Typical thickness:	100-500 microns (4-20 mils)
Shelf life:	2 years when stored at temperatures between 5°C (40°F) and 40°C (104°F). 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
Storage and handling:	For optimum performance, store S1401 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 contaminates. 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. Minimum epoxy temperature for easy mixing: 30°C (86°F).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 min.	13-15 min.	10-12 min.	7-9 min.	5-7 min.
Gel Time	20-22 min.	17-20 min.	16-19 min.	14-17 min.	10-13 min.
Dry time	80-100 min.	50-60 min.	40-50 min.	30-40 min.	20-30 min.
Shore D70	30-40 hrs.	20-25 hrs.	5-10 hrs.	2-4 hrs.	1-2 hrs.

Properties

Properties	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
Adhesion to steel		ASTM D4541	> 2,000 psi	> 13,8 MPa

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: **S1401-TP-200ML-336GR(C25)**

Twin pack kit with EQ-PR-APPLICATOR-3 (white foam pad with felt) & safety gloves:

S1401-TP-200ML-336GR-KIT(C10)

Other twin pack sizes are made to order only with MOQ of 5000 pc. Min. size is 100 ml, max. size is 250 ml.

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

Bulk Epoxy:

Base: S1401-PART-A-18L-31.5KG

Hardener: S1401-PART-B-18L-18.7KG

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. For epoxy thickness >= 200 micron the use of EQ-PR-APPLICATOR-3 is recommended.

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.



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