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| Description: | S1401-M 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 operating upto 95 ° C (203 ° F). S1401-M can be used with Covalence 3 layer coating system: HTLP80 as the initial anti-corrosion layer. |
| Colour: | Grey |
| Volume solids: | 100% |
| Weight solids: | 100% |
| Mixing ratio: | (by volume): 3.6 parts of base (part A) to 1 part of hardener (part B) (by weight) : 100 parts of base (part A) to 16 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: 1.85 Hardener: 1.03 |
| Typical thickness: | 100-500 microns (4-20 mils) |
| Pot life: | 14 min at 25°C (77°F) |
| Shelf life: | 2 years when stored at temperatures between 5°C (40°F) and 40°C (104°F). |
| Flash point: | Part A (Base): 143°C (289.4°F) Part B (Hardener): > 93°C (> 199.4°F) |
| Thinner: | Do not dilute |
| Storage and Handling: | For Optimum performance, store S1401-M 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.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. |

| Property | Condition | Test Method | Typical Value | |
|------------------------|-----------|----------------|---------------|-----------------|
| | | | US Imperial | Metric |
| Specific Gravity | Mixed | ASTM D-3289-03 | 1.64 | 1.64 |
| Hardness | Shore D | ASTM D-2240 | 85 | 85 |
| Dielectric Strength | Oil | ASTM D149 | 690 Volts/mil | 27 Volts/micron |
| Adhesion to Bare Steel | | ASTM D-4541 | 3,550 psi | 24 Mpa |

Ordering info:

Bulk Epoxy:

Base : **S1401-M-PART-A-15.1L-28KG**

Hardener: **S1401-M-PART-B-17.4L-18KG**

Always order in multiples of 4 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 \geq 200 micron the use of EQ-PR-APPLICATOR-3 is recommended.

Cartridge:

S1401-M-50ML-4:1-CRTG&2-MIXERS

50 ML cartridge delivered with 2 static mixers.



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