

PROTEGALINE TPL50

DESCRIPTION

A two component polyamide cured epoxy coating.

PRODUCT FEATURES AND RECOMMENDED USES

- ◆ Approved to Transco specification CM2 for application to internal pipelines.
- ◆ Approved to Corus group for application to internal pipelines.
- ◆ The glossy film gives improved flow characteristics and reduced pumping costs.
- ◆ Suitable for the internal coating of all types of gas lines, including service pipes.

TECHNICAL DATA

Volume solids 55 ± 2% mixed (ISO 3233).

Weight solids 68 ± 2%.

Specific gravity 1.38 – 1.42 (mixed).

Product code

Base	4 parts by volume	3377 346
Hardener	1 part by volume	4065 001
Composite		4871 346

Pot life 6 hours @23°C

Recommended film thicknesses and theoretical coverage

Recommended film thicknesses		Theoretical coverage
dry	wet	
50 µm	91 µm	11 m ² /l
100 µm	182 µm	5.5 m ² /l

Practical coverage depends on the application method, painting conditions and the shape and roughness of the surface to be coated.

Drying time

DFT 50 µm		+ 10 °C	+ 23 °C	+ 35 °C
Dust dry		2 h	1 h	30 min
Hard dry		5 h	2 h	1 h
Overcoating	Min	12 h	8 h	6 h
	Max	7 d	5 d	3 d

Drying and recoating times are related to the film thickness, temperature, the relative humidity of the air and ventilation.

Finish Gloss

Colours Red Oxide.

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APPLICATION DETAILS

Surface preparation Degrease steel where necessary to SSPC-SP1 solvent cleaning to remove weld flux and general contamination prior to blasting. All sharp edges should be ground and weld spatter removed.
Blast clean to Swedish Standard SIS 05 5900 Sa 2½ or British Standard 7079 equivalent by dry or wet blasting techniques. Maximum profile 75 microns.
Surface should be clean dry and free from all grease, oil and general contamination.

Application conditions Only apply in conditions of good ventilation which should be maintained during drying. Do not apply when rain, mist, sleet or snow are imminent. During application and drying time of the paint coating, the surface should be dry, the Relative Humidity should not exceed 85% and the steel temperature should remain at least 3°C above the dew point.

Mixing Mix only in the proportions stated, mixing each component individually then together using a mechanical agitator. Ensure complete homogeneity before using.

Application

Method	Airless spray	Automatic Spray	Conventional Spray	Brush	Roller
Output Fluid Pressure	2500 – 3000 p.s.i.	No	Yes, any suitable equipment	Yes	Yes
Tip Size	15 – 21 thou				

Refer to Protega epoxy application/curing notes.

Induction Period: allow 30 minutes @23°C after mixing prior to application, @ 10°C allow 1 hour.

Maintain product at 20 – 25°C for best application properties.

Application by brush or roller will result in reduced film thickness.

Thinner 1031 Thinner.

Cleaning of equipment Remove remaining paint from equipment, flush thoroughly with 1031 Thinner until solvent appears uncontaminated.

FLASH POINT Below 21°C

STORAGE Store in dry, cool conditions and protect from frost.

VOC Volatile Organic Compound content: 448 ± 20 gm/lit.

HEALTH AND SAFETY Containers are provided with safety labels, which should be observed. Further information about hazardous influences and protection are detailed in individual health and safety data sheets.
A health and safety data sheet is available on request from Protega Coatings Ltd.

PRODUCT NOTES Do not apply or cure below 10°C.
The drying times quoted are dependant on the degree of ventilation through the pipes. Product will chalk on external applications, the degree to which is subject to atmospheric conditions.
Low flash material – ventilate to keep solvent vapour levels below minimum explosive limit. Observe low flash regulations.