

**COVALENCE<sup>®</sup> S1301-M EPOXY PRIMER**

<b>Description:</b>	S1301-M primer is a specially formulated 100% volume solids (solvent-less) 2 component epoxy.
<b>Recommended use:</b>	<p>As an epoxy primer in a 3-layer polyethylene coating system for superior corrosion protection of field welded joints of steel pipes. Can be used with Covalence 3-layer coating systems: HTLP80 (-HP), HTLP60-DCS, HTLP60-HP, DIRAX.</p> <p>For HTLP60-DCS and DIRAX the epoxy primer needs to be applied on the steel surface only. For HTLP80(-HP)* and HTLP60-HP* the epoxy needs to be applied onto the steel surface AND onto the 3LPE line coating when preheating cannot be done by induction coil. When the line coating is (D)FBE or CTE the epoxy needs to be applied on the line coating for all products.</p> <p><i>S1301-M can also be used as wear cones in the PPS120 and DIRAX-PP systems and as repair coating for PE, PP and FBE line coatings rated up to 65°C.</i></p> <p><i>* For certain 3LPE pipeline coatings it is not necessary to put epoxy on the line coating. Consult your SFL representative for more information.</i></p>
<b>Colour:</b>	Black
<b>Volume solids:</b>	100%
<b>Weight solids:</b>	100%
<b>Mixing ratio:</b>	(by volume) : 3 parts of base (part A) to 1 part of hardener (part B) (by weight) : 5 parts of base (part A) to 1 part of hardener (part B)
<b>Typical coverage:</b>	3.8 sq.m/litre. This coverage is based on 150 microns or 6 mils nominal wet film thickness, including drum and application scrap. For twin packs include 5% extra scrap.
<b>Specific gravity:</b>	Base: 1.65 Hardener: 1
<b>Typical thickness:</b>	100-200 microns (4-8 mils)
<b>Pot life:</b>	30 min at 23°C (73°F), 15 min at 40°C (104°F)
<b>Shelf life:</b>	3 years after manufacturing date when stored at temperatures between 5°C (40°F) and 40°C (104°F).
<b>Flash point:</b>	Part A (Base) : 143°C (289°F) Part B (Hardener): > 118°C (244°F)
<b>Thinner:</b>	Do not dilute.
<b>Application:</b>	<ol style="list-style-type: none"><li>1. Prepare the pipe surface as recommended in the product application guide.</li><li>2. Pour hardener into base as per mixing ratio. Stir the mixture (max 300 ml in 1 can) for approximately 1 minute to ensure a homogeneous mixture. For twin packs: remove the clip and roll the twin pack for min 1 minute, see detailed application guideline on the twin pack.</li><li>3. Carefully apply mixed epoxy primer as indicated in the product application guide.</li></ol>

**S1301 M Pot Life and Gel Time Chart:**

Temperature	Pot life	Gel time	Dry time	Shore D70
20°C	54 min	64 min	117 min	10 hr
25°C	29 min	59 min	105 min	8 hr 30 min
30°C	20 min	52 min	80 min	4 hr 30 min
35°C	13 min	46 min	62 min	3 hr
40°C	11 min	35 min	43 min	1 hr 50 min

**Note:**

1. Pot life data are obtained by mixing 600 g of Part A and 120 g of Part B. Part A and Part B temperature before mixing is as specified (20, 25, 30, 35 or 40 degrees C) and keep the mixture at the environment of that temperature after mixing.
2. Gel time, dry time and Shore D70 data are from 40-60 mils thin film.

**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: **S1301-M-TP-200ML-300GR(C18)**

Twin pack kit with EQ-PR-APPLICATOR-IN (foam pad with felt) & safety gloves:  
**S1301-M-TP-200ML-300G-KIT(C10)**

Other twin pack sizes are available on request, minimum size is 100 ml, maximum size is 200 ml, special size MOQ may apply.

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

**Bulk Epoxy:**

Base: S1301-M-PART-A-18L-29.7KG

Hardener: S1301-M-PART-B-18L-18KG

Always order in multiples of 3 pails of part A by 1 pail of part B.

For accessories to apply epoxy see PDS-ACCESSORIES. These need to be ordered separately.

**Information**

<b>Documentation</b>	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 <a href="mailto:info@sealforlife.com">info@sealforlife.com</a>
<b>Certified staff</b>	Application of the described coating system shall be carried out by certified personnel.



Seal For Life Industries - Stopaq B.V.  
Stadskanaal, the Netherlands  
Tel: +31 599 696 170

Seal For Life Industries BV  
Westerlo, Belgium  
Tel: +32 14 722 500

Seal For Life Industries US LLC  
San Diego, USA  
Tel: +1 858 633 9785

Seal For Life Industries Mexico  
S de R.L. de C.V.  
Tijuana, Mexico  
US Tel: +1 858 633 9785  
MX Tel: +52 664 647 4300

Seal For Life India Private Ltd.  
Baroda, India  
Tel: +91 2667 264 721

Further information is available on our website [www.sealforlife.com](http://www.sealforlife.com), or by sending an inquiry to [info@sealforlife.com](mailto:info@sealforlife.com)

DISCLAIMER: Seal For Life Industries warrants that the product conforms to its chemical and physical description and is appropriate for the use stated on the technical data sheet when used in compliance with Seal For Life Industries' written instructions. Because many installation factors are beyond the control of Seal For Life Industries, the user shall determine the suitability of the products for the intended uses and assume all risks and liabilities in connection herewith. Seal For Life's liability is stated in its General Terms and Conditions of Sale. Seal For Life Industries makes no other warranty either express or implied. All information contained in this document is to be used as a guide and is subject to change without notice. This technical data sheet supersedes all previous data sheets on this product.