

TYPE:	A POLYESTER GLASS FLAKE PIPE COATING , specifically for application using centrifugal pipe rolling techniques.
SUGGESTED USE:	Internal pipe coating for use in hydrocarbons, aqueous, marine and corrosive chemical service environments below 85°C.
LIMITATIONS:	Not suitable for protection against polar solvents, demineralised water and where pH conditions are below 1 or above 12. Refer to Chemical resistance chart.
HEALTH & SAFETY:	Before handling or using this product the material safety data sheet should be read and all precautions observed.
SURFACE PREPARATION:	Metals: Grit blast to ISO standard 8501-1 Sa 2½. SSPC-SP 10. (For full details refer to Corrocoat Surface Preparation SP1.) Concrete: refer to Corrocoat data sheet SP5.
APPLICATION EQUIPMENT:	Specialist pipe rolling equipment.
APPLICATION:	Is dependent on intended service but Polyglass Pipe Grade is normally applied in a single wet film at between 1000 & 2000 microns. Primer is not normally used. For further details obtain Corrocoat Pipe Rolling instructions or refer to the CC training manual.
RECOMMENDED DFT:	750 microns in marine conditions and up to 2500 microns in highly corrosive conditions, chemical or abrasive environments.
CATALYST TYPE:	Methyl Ethyl Ketone Peroxide, type P2
MIXING RATIO/MIXING:	98:2 base to hardener. For mixing instructions and inhibitor use refer to Polyglass Data Sheet 6.20A. Do not use inhibitor unless necessary and add before catalyst when used.
POT LIFE:	Typically 25-30 minutes at 20°C. May be adjusted with inhibitor or manufactured specifically to suit specific requirements.
THINNERS:	The performance of Polyglass Pipe Grade is adversely affected by the addition of solvent thinners and their use is prohibited. Thinning may be achieved by addition of not more than 5% styrene monomer to PPG by volume i.e. 1.00 litre styrene per 20 litres PPG.
PACKAGING:	20 litres base and catalyst is standard, 10 litres available.
STORAGE LIFE:	Base 12 months, hardener (catalyst) 6 months stored at temperatures below 24°C and away from heat sources and direct sunlight. Frequent temperature cycling will shorten storage life.
COLOUR AVAILABILITY:	Off white as standard.
THEORETICAL SPREADING RATE:	1.33m ² /litre at 750 microns.

VOLUME SOLIDS:	This material contains volatile liquid convertible to solids. Volume solids obtained will vary dependent upon polymerisation conditions. Nominally 99.% of the contents are convertible to solid.
PRACTICAL SPREADING RATE:	1.0m ² /litre at 750 microns. Note: This information is given in good faith but rate may vary significantly dependent upon environmental conditions, the geometry and nature of work undertaken and the skill and care of application. Corrocoat accept no responsibility for any deviation from these values.
SPECIFIC GRAVITY:	Polyglass PG base: 1.19 gms/cc Hardener: 1.07 gms/cc
FLASH POINT:	26°C
HARDNESS:	40 Barcol
TENSILE STRENGTH:	25.5 N/mm ² (3700 psi)
ELONGATION AT BREAK:	1.3% in aqueous immersion
THERMAL COEFFICIENT OF LINEAR EXPANSION:	13.968 x 10 ⁻⁶ /°C
DIELECTRIC STRENGTH:	18 - 25 x 10 ³ V/mm
THERMAL CONDUCTIVITY:	0.38 W/m ⁰ K
TEMPERATURE LIMITS:	85°C immersed. 120°C non-immersed. No known lower limit.
OVERCOATING:	Normally applied as a single coat but where necessary it should take place as soon as the previous coat has gelled and whilst still tacky. Maximum overcoating time is 48 hours at 20°C.
CURING TIME:	Without inhibitor, tack free 6 hours, full cure 3-4 days at 20°C, but may be immersed in many environments after 12 hours. Low level through pipe ventilation should be maintained during cure.
CLEANING SOLVENT:	Methyl Ethyl Ketone, Methyl Iso Butyl Ketone - before gel.

All values are approximate. Physical data is based on the product being in good condition before polymerisation, correctly catalysed and full cure being attained. Information regarding application of the product is available in the Corrocoat manual. Should further information be required, please consult Corrocoat Technical Services.

Reviewed: July 2011