



TECHNICAL DATA

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PIPE MATE PW (20068) EPOXY REPAIR – ANSI/NSF STANDARD 61

Product Description

A two component, high-solids, epoxy-polyamide for use as repair / touch-up material for PROTEC II PW in potable water immersion.

Features

- Meets ANSI/NSF Standard 61 requirements.
- Meets FDA CFR21 175.300 for food contact.
- Low VOC
- Hard, smooth easily cleaned surface with good abrasion resistance.
- Outstanding resistance to water and water vapor permeation up to 120°F (49°C).

Recommended Uses

As a repair coating for PROTEC II PW in potable water immersion service.

Primers

None required.

Typical Properties

Solids by Volume	67% ± 2
Volatile Organic Compounds	2.4 lb/gal (288 g/l)
Theoretical Coverage	1075 ft ² @ 1 mil (2.5 m ² @ 1 mm)
Recommend DFT	5 – 10 mils (125 – 250µ)
Number of Coats	1 or 2
Mix Ratio (by volume)	2”A” : 1”B”
Flash Point (PMCC)	80°F (27°C)
Shelf Life @ 60-90°F (16-32°C)	1 year
Color	Gray

Specification Data

Abrasion Resistance ASTM D 4060 CS 17 / 1000 g / 1000 cycles	30 mg loss
Hardness – ASTM D 2240	75 Shore “D”
Dielectric Strength ASTM G 62	40 volts/mil
Thermal Shock Resistance 10 Cycles; -40°F to 280°F	Passes No checking or loss of adhesion.
Temperature Resistance (Dry)	Continuous 210°F (100°C) Intermittent 280°F (138°C)

Ordering Information

Packaging:	3 gal & 15 gal kits
Shipping Weight:	11.5 lb/gal (5.2 kg/gal)

APPLICATION INFORMATION

PIPE MATE PW

Surface Preparation

Remove all oil, grease or other contaminants from the surface to be coated in accordance with SSPC-SP 1.

PROTEC II PW: Abrade areas by sweep-blast or mechanical sanding/grinding to dull any gloss and leave a visible scratch.

STEEL: Abrasive blast to a Near White Blast in accordance with SSPC-SP 10 and obtain a 2-3-mil angular anchor pattern. Feather into existing coating.

Mixing

Power mix each component separately, then combine at a ratio of 2 "A" to 1 "B" by volume and power mix to a smooth consistency.

Thinning

Normally not required.

Pot Life

Material Temperature	Time
60°F (15°C)	4 hours
75°F (24°C)	3 hours
90°F (32°C)	2 hours

Application Conditions

	Normal	Minimum	Maximum
Material	75-90°F (24-32°C)	50°F (10°C)	95°F (35°C)
Surface	75-90°F (24-32°C)	50°F (10°C)	110°F (43°C)
Ambient	75-90°F (24-32°C)	50°F (10°C)	110°F (43°C)
Humidity	30-50%	0%	85%

Surface temperature must be 5°F (3°C) above the dew point.

Application Equipment

Airless:

Pump Ratio	30:1 min	Tip Size	.015-.021"
Material Hose*	3/8" ID min 100' max	Tip Pressure psi	2400-2800

Brush: Use a short bristle brush using full strokes. Avoid re-brushing

Roller: Use a short nap roller using full strokes. Avoid re-rolling.

Clean Up

Use MEK or a 1:1 blend of MEK and Toluol.

Cure Time

These times are based on a 30-50% RH. Excessive film thickness, cooler temperatures or inadequate ventilation will require longer cure times and could result in premature failure.

	<u>Surface Temperature</u>		
	50-69°F (10-21°C)	70-89°F (21-32°C)	90-110°F (32-43°C)
Surface dry	8 hours	2 hours	1½ hours
Hard Film	24 hours	16 hours	12 hours
Recoat (min)	8 hours	6 hours	4 hours
Recoat (max)	4 days	3 days	2 days
Full cure	10 days	7 days	5 days

- If the material has exceeded its maximum recoat time by less than 24 hours wipe with MEK and recoat within 10 minutes.
- If the maximum recoat time has been exceeded by more than 24 hours' contact ITW Futura Coatings for recommended recoat procedures.

Safety Information

- Read the Material Safety Data Sheet (MSDS) and container labels for detailed health and safety information.
- Do not apply material in enclosed areas without adequate air exchange and ventilation.
- All application personnel must use respirators rated for organic vapors, or in confined spaces wear fresh air respirators or fresh air hoods.
- Wear protective clothing, gloves and eye protection.
- Breathing fumes or contact with the skin may cause severe allergic reactions.
- This product contains flammable solvents! Keep away from all sparks, flames and hot surfaces.
- **This product is intended for industrial use by properly trained professional applicators only.**

Storage Conditions

- Urethane coatings need to be protected from moisture contamination. Store drums and pails in a dry location at 55-80°F (11-27°C).
- Materials **must** be kept above 50°F (10°C).

ITW FUTURA COATINGS, 1685 GALT INDUSTRIAL BLVD., ST LOUIS, MO, (314) 733-1110

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