

SELECTION & SPECIFICATION DATA

Generic Type	Polyamine-Epoxy
Description	A solvent-less, high gloss, smooth epoxy coating for the lining of gas transmission pipelines. It's hard, smooth surface aids in the flow of gas by reducing turbulence while protecting the interior surfaces from corrosion. It has excellent flow and wetting characteristics ideal for this type of application and use. Tested in accordance with API RP 5L2 for gas transmission pipelines.
Features	<ul style="list-style-type: none"> • Improves flow efficiency in gas pipes • Meets API RP5L2 requirements for gas transmission pipeline flow liner • Excellent flow and leveling • Single-coat application • Hard, smooth, glossy finish • Excellent abrasion resistance • Corrosion prevention during storage
Color	Red 0500
Gloss	70+ @ 60°
Finish	Gloss
Primer	Self-priming
Dry Film Thickness	2 - 6 mils (51 - 152 microns) per coat Higher mils are used when increased corrosion prevention is needed.
Physical Properties	Specific gravity of 1.50
Solids Content	By Volume 100%
Theoretical Coverage Rate	1604 ft ² /gal at 1.0 mils (39.4 m ² /l at 25 microns) 802 ft ² /gal at 2.0 mils (19.7 m ² /l at 50 microns) 267 ft ² /gal at 6.0 mils (6.6 m ² /l at 150 microns) Allow for loss in mixing and application.
VOC Values	As Supplied : 1 g/l (0.008)lbs./gal)
Dry Temp. Resistance	Continuous: 248°F (120°C)

SUBSTRATES & SURFACE PREPARATION

General	Surfaces must be clean and dry before abrasive blasting. Employ adequate methods to remove dirt, dust, oil and all other contaminants that could interfere with adhesion of the coating.
Steel	SSPC-SP6, NACE 3, Sa 2 Surface Profile: 1.2-2.5 mils (30-63 microns)

PERFORMANCE DATA

All test data was generated under laboratory conditions. Field testing results may vary.

Test Method	System	Results
API 5L2	One coat Polyclad 956	Pass

Polyclad 956

PRODUCT DATA SHEET



MIXING & THINNING

- Mixing** | Polyclad 956 is a two component product. Part A and B needs to be power mixed before use.
- Thinning** | Thinning is not recommended
- Ratio** | Mix ratio is 2:1 by volume
- Pot Life** | 27 minutes at 75°F (24°C)
6 minute at 130°F (54°C)

APPLICATION EQUIPMENT GUIDELINES

Listed below are general equipment guidelines for the application of this product. Job site conditions may require modifications to these guidelines to achieve the desired results.

- Conventional Spray** | Not recommended to be applied by conventional spray.
- Airless Spray** | Pump Ratio: 30:1 (min.)
Material Hose: 3/8" I.D. (min.)
Tip Size: .013"-.021"
Output PSI: 1800-2500
Filter Size: 60 mesh
PTFE packings are recommended and available from the pump manufacturer
- Plural Component Airless Spray** | Recommended for application by plural component airless spray. Use fixed ratio, 2:1 heated airless pump. Spray with part A and B at 130°F (54°C).
- Brush** | Recommended for small areas and repairs only. Use a high quality medium bristle brush, and apply a very light crisscross brush coat. Allow to dry for approximately 5 minutes. Normally, a film thickness of 1-2 mils (25-50 microns) can be obtained per coat by this method.

APPLICATION CONDITIONS

Condition	Material	Surface	Ambient	Humidity
Minimum	120°F (49°C)	50°F (10°C)	50°F (10°C)	0%
Maximum	140°F (60°C)	110°F (43°C)	120°F (49°C)	90%

This product simply requires the substrate temperature to be above the dew point. Condensation due to substrate temperatures below the dew point can cause flash rusting on prepared steel and interfere with proper adhesion to the substrate.

CURING SCHEDULE

Surface Temp.	Dry to Handle	Dry to Touch
50°F (10°C)	8.5 Hours	2 Hours
75°F (24°C)	3 Hours	1.25 Hours

CLEANUP & SAFETY

- Cleanup** | Use Thinner #2 or Acetone. In case of spillage, absorb and dispose of in accordance with local applicable regulations.
- Safety** | Read and follow all caution statements on this product data sheet and on the SDS for this product. Employ normal workmanlike safety precautions.

PACKAGING, HANDLING & STORAGE

Shelf Life	Part A & B: Min. 12 months at 75°F (24°C) When kept at recommended storage conditions and in original unopened containers.
Storage Temperature & Humidity	40° - 110°F (4° - 43°C) 0-100% Relative Humidity
Storage	Store Indoors.
Shipping Weight (Approximate)	15 Gallon Kit - 190 lbs (86 kg) 150 Gallon Kit - 1905 lbs. (864 kg)
Flash Point (Setaflash)	Part A: >200°F (93°C) Part B: >200°F (93°C)

WARRANTY

To the best of our knowledge the technical data contained herein is true and accurate on the date of publication and is subject to change without prior notice. User must contact Carboline Company to verify correctness before specifying or ordering. No guarantee of accuracy is given or implied. We guarantee our products to conform to Carboline quality control. We assume no responsibility for coverage, performance, injuries or damages resulting from use. Carbolines sole obligation, if any, is to replace or refund the purchase price of the Carboline product(s) proven to be defective, at Carbolines option. Carboline shall not be liable for any loss or damage. NO OTHER WARRANTY OR GUARANTEE OF ANY KIND IS MADE BY CARBOLINE, EXPRESS OR IMPLIED, STATUTORY, BY OPERATION OF LAW, OR OTHERWISE, INCLUDING MERCHANTABILITY AND FITNESS FOR A PARTICULAR PURPOSE. All of the trademarks referenced above are the property of Carboline International Corporation unless otherwise indicated.