

## SELECTION & SPECIFICATION DATA

<b>Generic Type</b>	Polyamine-Epoxy
<b>Description</b>	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.
<b>Features</b>	<ul style="list-style-type: none"> <li>• Improves flow efficiency in gas pipes</li> <li>• Meets API RP5L2 requirements for gas transmission pipeline flow liner</li> <li>• Excellent flow and leveling</li> <li>• Single-coat application</li> <li>• Hard, smooth, glossy finish</li> <li>• Excellent abrasion resistance</li> <li>• Corrosion prevention during storage</li> </ul>
<b>Color</b>	Red 0500
<b>Gloss</b>	70+ @ 60°
<b>Finish</b>	Gloss (70-85)
<b>Primer</b>	Self-priming
<b>Dry Film Thickness</b>	51 - 152 microns (2 - 6 mils) per coat Higher mils are used when increased corrosion prevention is needed.
<b>Physical Properties</b>	Specific gravity of 1.50
<b>Solids Content</b>	By Volume 100%
<b>Theoretical Coverage Rate</b>	39.4 m <sup>2</sup> /l at 25 microns (1604 ft <sup>2</sup> /gal at 1.0 mils) 19.7 m <sup>2</sup> /l at 50 microns (802 ft <sup>2</sup> /gal at 2.0 mils) 6.6 m <sup>2</sup> /l at 150 microns (267 ft <sup>2</sup> /gal at 6.0 mils) Allow for loss in mixing and application.
<b>VOC Values</b>	<b>As Supplied</b> : 1 g/l (0.008)lbs./gal)
<b>Dry Temp. Resistance</b>	Continuous: 120°C (248°F)

## SUBSTRATES & SURFACE PREPARATION

<b>General</b>	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.
<b>Steel</b>	SSPC-SP6, NACE 3, Sa 2 <b>Surface Profile:</b> 1.2-2.5 mils (30-63 microns)

## PERFORMANCE DATA

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	49°C (120°F)	10°C (50°F)	10°C (50°F)	0%
Maximum	60°C (140°F)	43°C (110°F)	49°C (120°F)	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
10°C (50°F)	8.5 Hours	2 Hours
24°C (75°F)	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 MSDS for this product. Employ normal workmanlike safety precautions.

**PACKAGING, HANDLING & STORAGE**

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

**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 to verify correctness before specifying or ordering. No guarantee of accuracy is given or implied. Carboline warrants our products to be free of manufacturing defects in accord with applicable Carboline quality control procedures. THIS WARRANTY IS NOT VALID WHEN THE PRODUCT IS NOT: (1) APPLIED IN ACCORDANCE WITH CARBOLINE'S SPECIFICATIONS, AND/OR (2) PROPERLY STORED, CURED, AND USED UNDER NORMAL OPERATING CONDITIONS. Carboline assumes no responsibility for coverage, performance, injuries, or damages resulting from use of the product. If this product is found not to perform as specified upon inspection by a Carboline representative during the warranty period, Carboline's sole obligation, if any, is to replace the Carboline product(s) proven to be defective or refund the purchase price thereof, at Carboline's sole option. Carboline shall not be liable for any other losses or damages. This warranty excludes (1) labor and costs of labor for the application or removal of any product, and (2) any incidental or consequential damages, whether based on breach of express or implied warranty, negligence, strict liability or any other legal theory. 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. The whole text of this Product Data Sheet, as well as the documents derived from it, have been written in English, and for legal purposes the English version shall prevail.