

## 18640 KANEPOX FLOWCOAT

### PRODUCT DESCRIPTION

**18640 KANEPOX FLOWCOAT** is an epoxy-polyamine based, two component flow coating. It is formulated in accordance with API RP 5L2, ISO 15741 and BS EN 10301 standards.

### RECOMMENDED USE

It is used as a one coat paint inside of dry and sweet natural gas pipes to decrease friction of flowing gas by smoothening the surface. It has superior corrosion protection even at low dry film thickness.

### CERTIFICATES

Suitability to use in natural gas pipes has been tested by SGS-UK according to;

- API RP 5L2 (4th Edition),
- ISO 15741:2016(E)
- BS EN 10301:2003(E).

### PRODUCT CHARACTERISTICS

Finish: Semi-Matt	Density (g/ml) 1,43±0,10
Colour: Oxide Red	Spreading Rate (m <sup>2</sup> /l) 10,00 (50 microns DFT)
Thinner: –	Flash Point 34°C
Mixing Ratio (by volume) 4 Parts A Comp. + 1 Part B Comp.	VOC ( Volatile Organic Content) 435 gr/ltr
Mixed Product; Volume Solids (%) 50±2	Application Methods Airless spray, Roller
	Pot Life (20°C) 3 hours

### DRYING SCHEDULE(\*)

(50 microns/2 mils film thickness)

	Dry to Touch	Hard Dry
5°C	6 hours	14 hours
15°C	4 hours	9 hours
25°C	2 hours	4 hours
35°C	1 hours	2 hours

Drying values are valid for defined dry film thickness and below 85% relative humidity

Fully Cured: 7 days (20°C)

(\*) Drying time depends on temperature, humidity and film thickness.

### PACKAGING

One kit of **18640 KANEPOX FLOWCOAT** is 1000 l.

4 barrels of **18640 KANEPOX FLOWCOAT** component A is 800 l.

One barrel of **KANEPOX HARDENER 0382** component B is 200 l.

### SHELF LIFE

Part A – 12 months, Part B – 12 months when the material is stored in a cool and dry place in unopened original containers.

### HEALTH/SAFETY PRECAUTIONS

Refer to the MSDS sheet prepared according to EU directives before use.

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### SURFACE PREPARATION

Surfaces must be dry, clean, free of oil, grease and other foreign material.

**New Surfaces:** Steel – Surfaces should be blasted to near-white metal surface cleanliness according to SSPC-SP10 or ISO 8501-1 Sa 2½. Blast profile on steel should be min.25 - max 50 microns in depth. Depending on ambient conditions, blasted surfaces must be primed in maximum 5 hours with **18640 KANEPOX FLOWCOAT**.

**Touch up:** Remove all dust, dirt, and other foreign material and keep dry. Clean the surface to St 2 - St 3 level mechanically according to ISO 8501-1 and complete the touch up application as soon as possible.

### APPLICATION PROCEDURES (Plural airless spray)

**18640 KANEPOX FLOWCOAT** is supplied suitable to be used with plural airless spray equipment based on volumetric mixing. A and B components are Supplied in separate drums per 200 litres. Other packaging options are available on request.

### MIXING RATIO

Base 18640 : Curing Agent 0382  
4 : 1 by volume

### MIXING PROCEDURE

Homogenize A and B components separately by mixing. Temperature of A and B component shall be minimum 20°C and maximum 60°C. Homogenized A and B components shall be pumped to metering unit to provide constant volumetric mixing.

### APPLICATION CONDITIONS

For the best results;

Temperature must be more than 0°C during the application and/or the curing process.

**Surface temperature:** At least 3°C above dew point.

**Relative humidity:** 85% maximum.

Good ventilation is required during application.

### APPLICATION

Application of coating above maximum or below minimum recommended spreading rate may adversely affect coating performance. 4 hours drying is recommended before the second coat for best results. Maximum coating interval is 7 days. Do not apply more than 250 microns (8 mils) WFT to prevent sagging. Roller and brush shall only be used for maintenance of small areas.

### CLEAN UP

**KANAT THINNER 0644 CLEANING, KANAT THINNER 0620, KANAT THINNER 0625**

### APPLICATION EQUIPMENT

(The table is a guide for 20°C)

Application Equipment	Airless Spray
Thinner maximum	-
Pressure minimum (bar)	175
Nozzle(inch)	0,015-0,021

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### PRECAUTIONS

- It is strongly recommended to keep A and B component at 20-25°C during application to avoid risks of slow drying at low temperatures.
- Recoating interval depends on temperature, humidity and film thickness. If maximum recoating time is exceeded abrade surface, if the surface is highly contaminated apply pressurized fresh water cleaning before recoating.
- Do not apply heavy coats beyond the specification otherwise solvent popping may occur.
- Condensation forming on the coating during early times of curing may result in longer cure times, solvent entrapment, premature failure, discoloration, or a surface haze or blush that must be removed before recoating.
- High temperatures decrease resistance properties of epoxy based products. Epoxy based products also have a tendency to yellowing, chalking and have limited gloss retention on exterior surfaces.

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