

## 18760 KANEPOX FLOWCOAT HB-760

## PRODUCT DESCRIPTION

**18760 KANEPOX FLOWCOAT HB-760** is an epoxy-polyamine based, two component, high built 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.

Complies with the requirements of LEED V4 – Low Emission Substances (substances with a maximum VOC content of 250 g/l)

## 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

<b>Finish:</b> Gloss	<b>Density (g/ml)</b> 1,45±0,10
<b>Colour:</b> Oxide Red	<b>Spreading Rate (m<sup>2</sup>/l)</b> 11,57 (70 microns DFT)
<b>Thinner:</b> –	<b>Flash Point</b> 47°C
<b>Mixing Ratio (by volume)</b> 4 Parts A Comp. + 1 Part B Comp.	<b>VOC ( Volatile Organic Content)</b> 136 g/l
<b>Mixed Product;</b> Volume Solids (%) 81±2	<b>Application Methods</b> Airless spray, Roller
	<b>Pot Life (20°C)</b> 45 minutes

## DRYING SCHEDULE(\*)

(70 microns/3 mils film thickness)

	Dry to Touch	Hard Dry	Dry to OverCoat Minimum
5°C	20 hours	40 hours	40 hours
15°C	9 hours	18 hours	18 hours
25°C	5 hours	10 hours	10 hours
35°C	3 hours	6 hours	6 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 **18760 KANEPOX FLOWCOAT HB-760** is 1000 l.

Four barrels of **18760 KANEPOX FLOWCOAT HB-760** component A is 800 l.

One barrel of **KANEPOX HARDENER 0364** 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 Steel Surfaces:** 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 25-50 microns in depth. Depending on ambient conditions, blasted surfaces must be primed in maximum 5 hours with **18760 KANEPOX FLOWCOAT HB-760**.

**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)

**18760 KANEPOX FLOWCOAT HB-760** is also supplied in a version 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 18760 : Curing Agent 0364  
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 5°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. Maximum coating interval is 7 days. Do not apply more than 200 microns (8 mils) WFT to prevent sagging. Roller and brush shall only be used for maintenance of small areas.

### CLEAN UP

**KANAT THINNER 0644, 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)	0.017-0.021

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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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