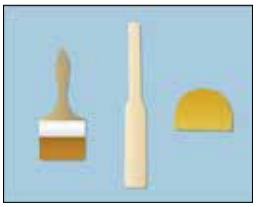
RR&C Rapid Set Epoxy
Application Guide

APPLICATION INSTRUCTIONS

1. **Product**
The 2-component epoxy coating is supplied in premeasured kits. Part A is the base and Part B is the hardener. Store in a dry location between 5°C (40°F) and 40°C (104°F) in original, unopened containers until ready for use.

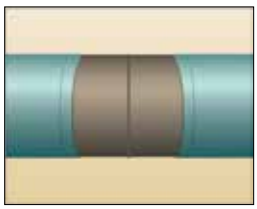
2. **Application Kit**
The application kit contains a paint brush, stir stick and trowel.



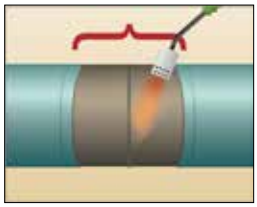
3. **Clean Surface**
When the pipe is at least 3°C (5°F) above the dew point, clean the surface to remove grease, oil, salts and other contaminants, using acetone, MEK or other suitable solvents if necessary.

4. **Abrade Steel**
Using suitable media, blast clean the bare steel cutback area to ISO-8501, NACE no. 2, SA-2 ½ (SSPC SP-10) near-white metal or better, leaving a 2.5- to 4-mil (64 - 101 micron) surface profile with sharp angularity. Surface profile tape may be used to control the surface profile. Avoid burnishing or polishing the bare steel.

5. **Abrade Adjacent Coating**
Sweep blast to clean and degloss the FBE or CTE coating surfaces that are within 50 mm (2 inches) of the edges of the bare steel area.

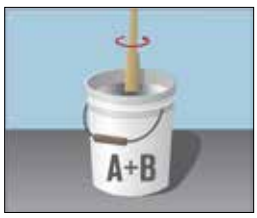


6. **Optional: Preheat Surface**
To drive off surface moisture or accelerate curing, preheat the area to be coated immediately before applying the coating as follows:
– To remove surface moisture, preheat to about 40°C (104°F).
– To speed coating cure, preheat to about 90°C (194°F).



7. **Combination**
Warm parts A and B to 20°C (68°F) and mix by pouring all of part B into part A, thoroughly scraping the part B container and lid.

8. **Mixing**
Mix with stir stick for 3 minutes, thoroughly scraping the sides and bottom of the container.



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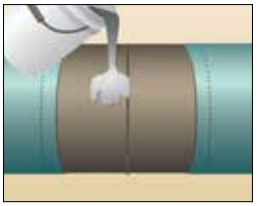
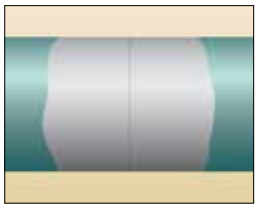
9. **Application: Step 1**
Reconfirm that the substrate temperature is above 10°C (50°F) and at least 3°C (5°F) above the dew point. For neat edges around the repair, apply masking tape over the existing coating, 50 mm (2 inches) away from the bare steel, outside the dotted lines shown. Slowly pour mixed epoxy onto pipe.



10. **Application: Step 2**
Use a trowel, brush or roller to apply required minimum thickness of coating to the field joint. Cover at least 50 mm (2 inches) of the adjacent mainline coating.

11. **Application: Step 3**
Use a wet film gauge to measure that the desired minimum thickness has been achieved. Double check around the weld to ensure minimum desired thickness. If masking tape was used, remove it while the coating is still tacky.

12. **Application: Step 4**
The cure time will vary with the pipe and ambient application temperature.



Temperature	Minimum Recoat	Maximum Recoat	Return to Service Hydrocarbon Immersion
50°F (10°C)	1 hour	24 hours	24 hours
77°F (25°C)	30 minutes	2 hours	4 hours
95°F (35°C)	15 minutes	45 minutes	3 hours

Return-to-service varies with cargo. Consult with your Sherwin-Williams representative for guidance.

Pot Life	35 minutes at 41°F (5°C)
	25 minutes at 59°F (15°C)
	17 minutes at 77°F (25°C)
	9 minutes at 95°F (35°C)
Pot life is shorter at higher temperatures. A larger volume of mixed material will have a shorter pot life than a smaller volume.	

SCAN TO ACCESS PRODUCT INFORMATION

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