

EPICOL 2000

INSTRUCTIONS FOR USE

Epicol 2000 is a factory applied epoxy for the lining of new ductile iron and cement lined pipes, valves and fittings.

SURFACE PREPARATION

- Steel:** This product is designed to be applied to a blast cleaned substrate only. Firstly degrease as per the requirements of SSPC-SP1 to remove all oil and grease etc. Abrasive blast clean to a minimum of standard of ISO 8501 : 1988 Sa2½ (peak to trough profile 50-100µm).
- Cement:** Requires removal of all dust, dirt and laitance. May require blast cleaning in extreme circumstances. All surfaces must be free from oil, grease and other contaminants. Ensure that the surface is dry and firm.

PRODUCT APPLICATION

- Airless Spray:** Hydracat system is preferred as mix ratio is 1 : 1 by volume but normal airless spray may be used if pot life is monitored closely.
Tip size 0.65-0.78mm (0.024"-0.028")
Pump ratio 60:1
Tip pressure 205-240 Bar (3000-3500 psi)
Paint temperature 15-35°C
Please note that the higher the temperature the shorter the pot life.
- Pot Life:** 1 hour at 20°C.
**** WARNING: AFTER 1 HOUR, ANY REMAINING MATERIAL BECOMES EXOTHERMIC, REACHING UP TO 80°C.**
- Film Build:** 150-200µm WFT / 150-200µm DFT
- Cure:** Allow 14 days cure at 15-20°C before commissioning

NOTE

These instructions should be read in conjunction with the Epicol 2000 Technical Data Sheet, available from Spencer Coatings Ltd. This product must be used in accordance with the Operational Guidelines Code of Practice (OGCP) for Epoxy Resins.