

PRODUCT NUMBER: 7-1810

DESCRIPTION: Pipe Rehab Red

Introduction:

Nap-Gard[®] 7-1810 Pipe Rehab Red is 100% solids technologically advanced epoxy coating for use in the oil and gas industry. It has superior anti-corrosive properties on the exterior of steel pipelines for above and below ground.

- Formulated for coating of pipe, valves, and fittings; girth weld coatings; rehabilitation of existing pipelines; and tank linings.
- Resistant to Cathodic Disbonding up to 149°F (65°C).
- High build single coat application.
- Excellent adhesion to grit blasted steel surfaces, fusion bond epoxy, liquid epoxy, and urethane coatings.

PRODUCT PROPERTIES

Color:	Red	Theoretical Coverage: (Base & Hardener Mixed)	1629 sq.ft./mil/gal.
Components:	7-1810-1 (Lt Green Viscous Liquid) Base 7-1810-2 (Amber Liquid) Hardener	Mixing Ratio:	4.87 base:1 hardener by volume
Specific Gravity:		Shelf Life @ 25°C (77°F):	2 Years @ 50% RH
Base:	1.80 ± .03		
Hardener:	1.10 ± .02		
Base & Hardener Mixed:	1.68 ± .03		

TYPICAL PROPERTIES OF APPLIED FILM

Pot Life:	100 gm mass @ 104°F (40°C)	Volume Solids (50% R.H.):	100%
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Application Temperature: -50°F to 212°F (10°C to 100°C)

Applications at temperatures at or below dew point require preheating of the substrate.

Touch Dry Time: (ASTM D1640)	30 mil coating thickness @ 77°F (25°C)	4 hours
Dry Hard Time: (ASTM D1640)	30 mil coating thickness @ 77°F (25°C)	10 – 12 hours

Number of Coats: One

Film Thickness:

Wet or Dry: 20 to 50 mils (Minimum 20 mils recommended, average 25 mils)

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Impact Resistance:	@0°C (32°F)		Pass – 2.0 Joules
CSA Z245.20-M92	@25°C (77°F)		Pass – 4.0 Joules
Bending:			
CSA-Z245.M20-02	@25°C (77°F)	2.0°ppd	Pass
Tensile Adhesion to Steel (PSI)	@25°C (77°F)		> 2500
ASTM D4541 Type 1V			
Cathodic disbonding	@65°C (149°F)		< 10
CSA Z245.M20-02			
Hardness:			
ASTM D-2240 (Shore D)	@25°C (77°F)		70

APPLICATION GUIDELINES

- (1) **Surface Preparation:**
Cleanliness: Near White
Standards: NACE 2, Sa 2 ½ (Swedish Scale)
SSPC SP-10 (Steel Structures Painting Council)
Profile: 2.5 to 5.0 mils (62 to 125 microns)
- (2) **Application:**
Spray Grade: Airless Spray System Graco 56:1 or higher recommended
Reversible Tip is Suggested. Tip Size: .021 - .035.
Brush Grade: Brush or Roller
- (3) **Material Temperature for Airless Spray Application:**
Preheat Base and Hardener to 104°F (40°C) before mixing of the two components.
- (4) **Re-Coat Interval:**
@ 77°F (25°C) 4 hours maximum
@ 212°F (100°C) 20 minutes maximum

7-1810 Pipe Rehab Red is a single coat application product. However if repair is required and the maximum re-coat interval is exceeded, the surface must be blast roughened to a minimum surface profile of 2 mils to ensure inter-coat adhesion.

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