NAP-GARD®
FBE Powder Coatings

Technical Information Sheet

PRODUCT NUMBER: 7-1812
DESCRIPTION: Rehab Pipe

Introduction:

Nap-Gard® Product No. 7-1812 is a range of surface coatings based on "State of the Art" epoxy chemistry. Nap-Gard® Product No. 7-1812 has the benefit of being a pure 100% epoxy. The cathodic disbanding performance of Nap-Gard® Product No. 7-1812 is excellent at temperatures up to 80°C (176°F). Nap-Gard® Product No. 7-1812 is available in Brush Grade and Spray Grade. 7-1812 is also available in cartridges for coating repairs.

LIQUID PROPERTIES

Color:
Base: Red Viscous Liquid
Hardener: Clear Amber Liquid

Specific Gravity: (ASTM D-792)
Base: 1.68 ± .03
Hardener: 1.06 ± .02
Mixed: 1.52 ± .03

Pot Life:
100 gm mass @ 25°C (77°F) 12 minutes

Storage/Shelf Life: Minimum of 24 months
Store in a dry, well-ventilated area at temperatures between 5°C(41°F) and 40°C(104°F).

Theoretical Coverage: 1629 Ft^2/U.S. Gallon/mil
1.0m^2/Litre/mm

Tack Free Time:
30 mil coating thickness @ 25°C (77°F) 90 minutes

Dry Hard Time:
30 mil coating thickness @ 25°C (77°F) 2.5 hours

TYPICAL PROPERTIES OF APPLIED FILM

Recommended Film Thickness:
Wet: 20 – 50 mils
Dry: 20 – 50 mils

Impact Resistance:
CSA Z245.20-M92
@ 0°C (32°F) Pass – 2.7 Joules
@ -30°C (-22°F) Pass – 2.3 Joules

Cathodic Disbonding:
CSA Z245.20-M92
28 days, 80°C (176°F) 7.66 mm

Water Vapor Permeability:
ASTM D-1434 ‹ 0.003 perm-in

Hardness:
Shore D, ASTM D2240-74 *86*

Bending:
CSA-Z245.20-M92 @ 0°C (32°F) 1°ppd

Tensile Adhesion to Steel:
PATTI JR.
25°C (77°F) › 4000 PSI

Water Absorption:
ASTM D-570 0.1%, 24^h, r.t.

Revised 08/24/2004

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TYPICAL ELECTRICAL PROPERTIES

Dielectric Strength:	400 volts/10-^{3} in	**Dielectric Constant:**	4.2 @ 60 cycles
ASTM D149-97		ASTM D150	

GENERAL APPLICATION PARAMETERS

Application Temperature: **-25**°C to 100°C (-13°F to 212°F)
Applications at temperatures at or below dew point require preheating of the substrate.

Surface Preparation: **Cleanliness:** **Near White**
(Steel Substrate) **Standards:** **NACE 2, Sa 2 ½ (Swedish Scale)**
SSPC SP-10 (Steel Structure Painting Council)
Profile: **2.5 mils to 5.0 mils (62 microns to 125 microns)**

Mixing Ratio: By Volume:
Brush & Spray Grade: 3 Parts Base:1 Part Hardener
Cartridges: 2 Parts Base: 1 Part Hardener

Temperature Parameters During Application: **To avoid risk of condensation, application should be done only when the temperature of the steel is at least 3**°C (5°F) higher than the dew point. Application temperatures below 1°C (33°F) must be watched carefully since ice crystals could be present in the surface pores of the steel resulting in poor adhesion and reduce corrosion protection. If the surface to be coated is below 10°C (50°F), preheating of the substrate is recommended (not to exceed 100°C, 212°F) prior to the application of *Nap-Gard® Product No.* 7-1812.

Re-Coat Interval:
@ 25°C (77°F) Maximum 2 Hours
@ 100°C (212°F) Maximum 15 Minutes

If the maximum re-coat interval is exceeded, the surface must be blast roughened to minimum surface profile of 2 mils.

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