

Technical Data

Jotapipe FC 400



Product description

This is a two component solvent free polyamine cured epoxy coating. It is a specially designed internal pipe coating, reducing friction in gas pipes. To be used as single coat system only.

Recommended use

Specially designed as an internal flow efficiency coating for gas transmission pipelines for non-corrosive service.

For details see the "Application Guide for Internal Flow Efficiency Coating - Jotapipe FC 400".

Film thickness and spreading rate

	Minimum	Maximum	Typical
Film thickness, dry (μm)	90	120	100
Film thickness, wet (μm)	90	120	100
Theoretical spreading rate (m^2/l)	11,1	8,3	10

Approvals

1. API RP 5L2
 2. ISO 15741
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Physical properties

Colour	Red
Solids (vol %)*	98 \pm 2
Flash point	>100°C (Setaflash)
VOC	0,83 lbs/gal (100 gms/ltr) USA-EPA Method 24 40 gms/ltr UK-PG6/23(97). Appendix 3
Gloss	Glossy
Flexibility	Good

*Measured according to ISO 3233:1998 (E)

Surface preparation

All surfaces should be clean, dry and free from contamination. The surface should be assessed and treated in accordance with ISO 8504.

Bare steel

Cleanliness: Blast cleaning to Sa 2½ (ISO 8501-1:2007). Roughness: using abrasives suitable to achieve grade Fine to Medium G (30-50 µm, Ry5) (ISO 8503-2).

Other surfaces

The coating may be used on other substrates. Please contact your local Jotun office for more information.

Condition during application

The temperature of the substrate should be at least 3°C above the dew point of the air, temperature and relative humidity measured in the vicinity of the substrate. Relative humidity in the air should not exceed 85% prior to application. Recommended steel temperature: 30-40°C.

Application methods

Spray Use two component heated plural spray unit or modified airless spray (with heating equipment). Contact your local Jotun office for further recommendations.

Application data

Mixing ratio (volume)	2:1
Mixing	2 parts Comp. A (base) to be mixed thoroughly with 1 part Jotapipe FC 400, Comp. B (curing agent).
Pot life (23°C)	1 hour (reduced at higher temperature).
Cleaner	Use Jotun Thinner No. 17 for cleaning equipment after application.
Guiding data airless spray	
Pressure at nozzle	18 - 30 MPa (2600 - 4300 psi)
Nozzle tip	0.46 mm - 0.60 mm (0.018" - 0.024")
Spray angle	60° - 120°
Filter	Filters with a minimum 100 mesh are recommended. Check to ensure that filters are clean.

Drying time

Drying times are generally related to air circulation, temperature, film thickness and number of coats, and will be affected correspondingly. The figures given in the table are typical with:

- * Good ventilation (Outdoor exposure or free circulation of air)
- * Typical film thickness
- * One coat on top of inert substrate

Substrate temperature	10°C	23°C	40°C
Surface dry	15 h	6 h	1.5 h
Through dry	30 h	12 h	4 h
Cured	15 d	7 d	4 d

The given data must be considered as guidelines only. The actual drying time/times before recoating may be shorter or longer, depending on film thickness, ventilation, humidity, underlying paint system, requirement for early handling and mechanical strength etc. A complete system can be described on a system sheet, where all parameters and special conditions could be included.

Typical paint system

Jotapipe FC 400 1 x 100 microns (Dry Film Thickness)

Other systems may be specified, depending on area of use

Storage

The product must be stored in accordance with national regulations. Storage conditions are to keep the containers in a dry, cool, well ventilated space and away from source of heat and ignition. Containers must be kept tightly closed.

Handling

Handle with care.

Packing size

15 litre unit: 10 litres Comp. A (Base) in a 20 litre container and 5 litres Jotapipe FC 400, Comp. B (curing agent) in a 5 litre container.

Also available on special order in 200 litre drums and 1000 litre IBC containers. Please contact Jotun for further information.

Health and safety

Please observe the precautionary notices displayed on the container. Use under well ventilated conditions. Do not breathe or inhale mist. Avoid skin contact. Spillage on the skin should immediately be removed with suitable cleanser, soap and water. Eyes should be well flushed with water and medical attention sought immediately.

For detailed information on the health and safety hazards and precautions for use of this product, we refer to the Material Safety Data Sheet.

DISCLAIMER

The information in this data sheet is given to the best of our knowledge based on laboratory testing and practical experience. However, as the product can be used under conditions beyond our control, we can only guarantee the quality of the product itself. We also reserve the right to change the given data without notice. Minor product variations may be implemented in order to comply with local requirements.

If there is any inconsistency in the text the English (UK) version will prevail.

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