

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.

Typical use

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

Approvals and certificates

Meets the requirements of API RP 5L2
Meets the requirements of ISO 15741

Additional certificates and approvals may be available on request.

Colours

red

Product data

| Property | Test/Standard | Description |
|------------------|-------------------|-------------|
| Solids by volume | ISO 3233 | 98 ± 2 % |
| Flash point | ISO 3679 Method 1 | 100 °C |
| Density | calculated | 1.5 kg/l |

| Region | Regulation | Test Standard | VOC Value |
|-----------|---|---------------------|-----------|
| US | CARB(SCM)2020 / SCAQMD rule 1113 | Calculated | 141 g/l |
| Hong Kong | Air Pollution Control (VOC) Regulation | Calculated | 141 g/l |
| EU | European Paint Directive 2004/42/CE | Calculated | 141 g/l |
| EU IED | Industrial Emission Directive 2010/75/EU | Calculated | 141 g/l |
| Korea | Korea Clean Air Conservation Act | Calculated | 141 g/l |
| China | GB 30981-2020 Limit of harmful substances of industrial protective coatings | GB/T 23985-2009 8.3 | 101 g/l |

The provided data is typical for factory produced products, subject to slight variation depending on colour.

Film thickness per coat

Typical recommended specification range

| | | |
|----------------------------|-----|-------------------|
| Dry film thickness | 100 | µm |
| Wet film thickness | 100 | µm |
| Theoretical spreading rate | 10 | m ² /l |

Exact film thickness requirements will be determined by the client/project specification.

Surface preparation

Surface preparation summary table

| Substrate | Surface preparation | |
|--------------|---|---|
| | Minimum | Recommended |
| Carbon steel | Sa 2½ (ISO 8501-1) Surface profile 35-50 µm, grade Fine G (ISO 8503-2) | Sa 2½ (ISO 8501-1) Surface profile 35-50 µm, grade Fine G (ISO 8503-2) |

Application

Application methods

The product can be applied by

Spray: Use two component heated plural spray unit or modified airless spray (with heating equipment).

Product mixing ratio (by volume)

| | |
|------------------------|-----------|
| Jotapipe FC 400 Comp A | 2 part(s) |
| Jotapipe FC 400 Comp B | 1 part(s) |

Thinner/Cleaning solvent

Cleaning solvent: Jotun Thinner No. 17

When thinners are used as a cleaning solvent, the use must be in accordance with prevailing local regulations.

Guiding data for airless spray

Nozzle tip (inch/1000): 18-24

Pressure at nozzle: 180-300 bar/2600-4300 psi

Drying and Curing time

| Substrate temperature | 10 °C | 23 °C | 40 °C |
|-------------------------|-------|-------|-------|
| Surface (touch) dry | 15 h | 6 h | 1.5 h |
| Dry to handle | 30 h | 12 h | 4 h |
| Dried/cured for service | 15 d | 7 d | 4 d |

Drying and curing times are determined under controlled temperatures and relative humidity below 85 %, and at average of the DFT range for the product.

Surface (touch) dry: The state of drying when slight pressure with a finger does not leave an imprint or reveal tackiness.

Dry to handle: Minimum time before the coated objects can be handled without physical damage.

Dried/cured for service: Minimum time before the coating can be permanently exposed to the intended environment/medium.

Induction time and Pot life

Packaging (typical)

| | Volume (litres) | Size of containers (litres) |
|------------------------|--------------------|--------------------------------|
| Jotapipe FC 400 Comp A | 10 / 20 / 200 | 20 / 20 / 200 |
| Jotapipe FC 400 Comp B | 5 / 20 / 200 | 5 / 20 / 200 |

The volume stated is for factory made colours. Note that local variants in pack size and filled volumes can vary due to local regulations.

Storage

The product must be stored in accordance with national regulations. Keep the containers in a dry, shaded, cool, well-ventilated space and away from sources of heat and ignition. Containers must be kept tightly closed. Handle with care.

Shelf life at 23 °C

| | |
|------------------------|-------------|
| Jotapipe FC 400 Comp A | 12 month(s) |
| Jotapipe FC 400 Comp B | 12 month(s) |

In some markets commercial shelf life can be dictated shorter by local legislation. The above is minimum shelf life, thereafter the paint quality is subject to re-inspection.

Caution

This product is for professional use only. The applicators and operators shall be trained, experienced and have the capability and equipment to mix/stir and apply the coatings correctly and according to Jotun's technical documentation. Applicators and operators shall use appropriate personal protection equipment when using this product. This guideline is given based on the current knowledge of the product. Any suggested deviation to suit the site conditions shall be forwarded to the responsible Jotun representative for approval before commencing the work.

Health and safety

Please observe the precautionary notices displayed on the container. Use under well ventilated conditions. Do not inhale spray 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.

Colour variation

When applicable, products primarily meant for use as primers or antifoulings may have slight colour variations from batch to batch. Such products and epoxy based products used as a finish coat may chalk when exposed to sunlight and weathering.

Colour and gloss retention on topcoats/finish coats may vary depending on type of colour, exposure environment such as temperature, UV intensity etc., application quality and generic type of paint. Contact your local Jotun office for further information.

Disclaimer

The information in this document is given to the best of Jotun's knowledge, based on laboratory testing and practical experience. Jotun's products are considered as semi-finished goods and as such, products are often used under conditions beyond Jotun's control. Jotun cannot guarantee anything but the quality of the product itself. Minor product variations may be implemented in order to comply with local requirements. Jotun reserves the right to change the given data without further notice.

Users should always consult Jotun for specific guidance on the general suitability of this product for their needs and specific application practices.

If there is any inconsistency between different language issues of this document, the English (United Kingdom) version will prevail.