

Jotapipe IL 6001 120S

PRODUCT DESCRIPTION

This product is a fusion-bonded epoxy coating designed as an anti-corrosion coating for the internal surface of line pipe used to transport potable water up to 85 °C (185 °F).

This product is WRAS approved to BS 6920 for potable hot and cold water, and certified by NSF International to NSF/ANSI Std. 61 for pipe with diameter equal to or greater than 8". This product is applied without the use of a primer.

POWDER PROPERTIES

| Property | Standard | Result |
|--------------------------------|---|--|
| Gel time | ISO 8130-6 200 °C | 100-145 seconds |
| Moisture content | CSA-Z245.20 (12.4B) | Below 0.50 % (at time of manufacture) |
| Particle size | CSA-Z245.20 (12.5) | 2.0 % max retained on 150 µm (100 mesh) 0.2 % max retained on 250 µm (60 mesh) |
| Density | CSA-Z245.20 (12.6) | 1520 ± 50 g/l |
| Thermal characteristics | CSA-Z245.20 (12.7)* Inflection point | T _{g1} = 54-70 °C (129-158 °F) T _{g2} = 105-115 °C (221-239 °F) ΔH = 35-65 J/g |

* Powder DSC heating cycles, 20 °C/min: 30-70 °C, 30-300 °C under inert gas, (T_{g1} and ΔH), 30-140 °C (T_{g2}). Cured film DSC heating cycles, 20 °C/min: 30-120 °C and hold 1.5 min, 30-285 °C (T_{g3}), 30-140 °C (T_{g4}).

These are typical results and should not be viewed as a product specification.

Storage

When stored at a maximum 25 °C (77 °F), a shelf life of 12 months is obtained from the date of manufacture.

APPLICATION

Powder application

Surface preparation meeting Sa 2½ to Sa 3 with a surface profile of 40-100 µm is recommended.

Pre-heat time depends on factors such as plant configuration and pipe characteristics.

| Application conditions | Typical application temperature | Typical film thickness |
|----------------------------|---------------------------------|-------------------------|
| Typical application | 200-230 °C (392-446 °F) | 350-625 µm (14-25 mils) |

Coated items shall be post cured at a temperature of 200-230 °C (392-446 °F) for minimum of 35 minutes. Optimum duration of post cure for different wall thicknesses shall be determined by the applicator and full cure shall be confirmed by a DSC cure test.

Please refer to the relevant Application Guide for guidelines on the factory application of this product.

PERFORMANCE

| Property | Standard | Result |
|----------------------------|---|---|
| Flexibility | CSA-Z245.20 (12.11) 3.0° PPD at 0 °C (32 °F) | Pass / No cracking |
| Adhesion | CSA-Z245.20 (12.14) 28 days, 50 °C (122 °F) 28 days, 75 °C (167 °F) | Rating 1 Rating 1 |
| Appearance | AWWA C-213 (5.3.2.4) | Smooth, glossy finish |
| Impact resistance | AWWA C-213 (5.3.2.5) | > 11.3 J |
| Abrasion resistance | AWWA C 213 (5.3.2.9) CS-17 wheel, 1 kg load, 5000 cycles | 165 mg weight loss |
| Water soak test | AWWA C 213 (5.3.2.9) 24 hours, 95 °C (203 °F) | Rating 1 |
| Cure test* | CSA-Z245.20 (12.7) | ΔT_g of ± 3 °C is considered as full cure |

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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.

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