

## Jotapipe IL 424

### Product description

This is a two component solvent free polyamine cured epoxy coating. It is a specially designed internal anti-corrosion pipe coating for diverse service. To be used as single coat system only.

### Typical use

To be used as high build corrosion-resistant internal lining for pipelines carrying sea water, raw water, sea water re-injection, desalinated water, sewage and water-contaminated sweet oil.

### Colours

grey

### 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

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

### Film thickness per coat

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

### Surface preparation

To secure lasting adhesion to the subsequent product all surfaces shall be clean, dry and free from any contamination.

#### 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 IL 424 Comp A 2 part(s)  
Jotapipe IL 424 Comp B 1 part(s)

### Thinner/Cleaning solvent

Cleaning equipment: Jotun Thinner No. 17

### Guiding data for airless spray

Nozzle tip (inch/1000): 19-25  
Pressure at nozzle (minimum): 175-300 bar/2500-4300 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 the typical DFT 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.

## Packaging (typical)

	Volume (litres)	Size of containers (litres)
Jotapipe IL 424 Comp A	200 / 10	200 / 20
Jotapipe IL 424 Comp B	200 / 5	200 / 5

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

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## Storage

The product must be stored in accordance with national regulations. Keep the containers in a dry, 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 IL 424 Comp A	12 month(s)
Jotapipe IL 424 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.

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## 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.

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## 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.

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## Colour variation

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

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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.

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