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## PRODUCT DATA SHEET

## SP-1288 GP EPOXY

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**DESCRIPTION:** **SP-1288 GP Epoxy** is a two-component ambient cured epoxy based on novel leading edge technology. **SP-1288 GP Epoxy** can be used in applications where abrasive blasting is not possible or feasible. **SP-1288 GP Epoxy** exhibits excellent adhesion on metal substrates prepared as per SSPC SP-11 Surface Preparation Specification.

**ADVANTAGES:**

- 100% Solids - No VOCs.
- Isocyanate free.
- Excellent adhesion to SSPC SP-11 prepared steel surfaces, Fusion Bond Epoxy (FBE), and FRP.
- Resistant to cathodic disbonding at temperatures up to 65° C (149° F) with SSPC SP-11 Surface Preparation.
- Excellent impact resistance.

**USES:**

- Coating of pipelines, girth welds, and appurtenances.
- Coating of sewer lines and general piping.
- Coating of on-shore and offshore structures.
- Lining of tanks.

**APPLICATION:**

- Spray Grade: Graco Hydra-Cat - Tip Size: 0.019 - 0.031
- Brush Grade: Brush or Roller
- Cartridge: Manual Dispenser

**CLEANING MATERIALS:**

- SP-100 Equipment Wash
- SP-110 Tool Cleaner
- SP-120 Internal Storage Lubricant

All information, recommendations, and test performance results herein were obtained in a controlled environment and SPC makes no claim that the data and tests accurately represent all environments and specific project specification requirements. As application, environmental and design factors can vary significantly, due care should be exercised in the selection and use of the coating. SPC products are sold with the understanding that the purchaser or user is solely responsible for determining their suitability for any purpose, and that the purchaser or user assumes all risks and liability associated with the use of the product. No guarantee, either expressed or implied, is made with respect thereto or with respect to the infringement of any patent. The information herein is not to be copied, used in evidence, released for publication, or public distribution without written permission from Specialty Polymer Coatings.



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### **SURFACE PREPARATION:** **(Steel Substrate)**

**Cleanliness:** The surface to be coated shall be free of all visible oil, grease, dirt, mill scale, rust, paint, oxide, corrosion products, and any other foreign matter.

**Standards:**

- a) Surface Preparation: SSPC SP-11 (Steel Structures Paint Council)
- b) Abrasive Blasting: NACE 2, Sa 2½ (Swedish Scale, ISO 8501-1)  
SSPC SP-10 (Steel Structures Paint Council)

**Profile:** Minimum 25-38 microns (1.0-1.5 mils)

Flapper Wheel or Bristle Blaster recommended.

### **RECOMMENDED FILM THICKNESS:**

**Wet:** 0.50 mm minimum to 1.25 mm maximum  
(20 mils to 50 mils)

**Dry:** 0.50 mm minimum to 1.25 mm maximum  
(20 mils to 50 mils)

### **RE-COAT INTERVAL:**

@ 25° C (77° F) Maximum: 6 Hours

Sweep blasting of the surface is required to ensure inter-coat adhesion if the maximum re-coat interval is exceeded. Small areas ≤ 316 sq. cm (≤ 49 sq. in.) may be sanded using a medium grit (80-100) carborundum cloth. All dust from the sanding or blast roughening must be removed from the surface with a clean, dry cloth prior to the application of the coating.

### **MIXING RATIO:**

Brush Grade and Spray Grade (By Volume): 3 Parts Base to 1 Part Hardener.

Cartridge (By Volume): 2 Parts Base to 1 Part Hardener.

### **HANDLING PROPERTIES:**

Pot Life [100 gm mass @ 25° C (77° F)]..... 50 ± 5 Minutes

Dry Time (ASTM D-1640) [0.50 mm (20 mils) coating thickness @ 25° C (77° F)]

Touch Dry Time ..... 3 Hours

Dry Hard Time..... 6 Hours

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### HANDLING PROPERTIES (cont.):

- Ambient Temperature..... -30° to 105° C (-22° to 221° F)
- Substrate Temperature.... The acceptable substrate (metal surface) temperature range for the application of SP-1288 GP Epoxy is 10°C (50°F) to 100°C (212°F). Preheating of the substrate is required if the surface to be coated is below 10°C (50°F). The substrate temperature must be a minimum of 3°C (5°F) above the dew point temperature to avoid condensation before proceeding with the coating operation. Refer to the attached Curing Table.
- Storage / Shelf Life..... Store in a cool, dry, well-ventilated area at temperatures between 5° C (41° F) and 40° C (104° F). Keep the lids sealed. The Shelf Life is a maximum of 24 months in unopened containers.

### LIQUID PROPERTIES:

	<u>BASE</u>	<u>HARDENER</u>
Appearance .....	White Viscous Liquid.	Blue Liquid.
Volume Solids Content (%) .....	100	100
Specific Gravity (ASTM D-1475)...	1.55 ± 0.03	0.96 ± 0.03
Coverage (Theoretical).....	Base & Hardener Mixed:	39.0 m <sup>2</sup> /litre/25 microns [1604 ft <sup>2</sup> /U.S. gallon/mil]

### PHYSICAL PROPERTIES:

#### Adhesion to Steel:

Dry Adhesion (Pull-off Strength) [MPa (PSI)] (ASTM D-4541-95-A4)  
(Self-Alignment Adhesion Tester, Type IV) [25°C (77°F)]

Bristle Blaster.....	20.67 (3000)
Flapper Wheel....	22.05 (3200)

Wet Adhesion (Hot Water Soak) (CSA-Z245.20-06, Clause 12.14)  
[Modified to 28 Days @ 75°C ± 3° C (167°F ± 5° F)]

Bristle Blaster.....	Rating #1
Flapper Wheel....	Rating #1

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### PHYSICAL PROPERTIES (cont.):

Cathodic Disbonding Test, System 1A (CSA-Z245.20-06, Clause 12.8)

[Modified to 28 Days @ 65° C (149° F) @ 1.5 Volts] (Average Radius, mm)

Bristle Blaster	Flapper Wheel	Abrasive Blast
10.0	10.2	5.06

Acceptance criteria 20 mm maximum radius.

Flexibility (CSA-Z245.20-06, Clause 12.11)

Temperature	Bristle Blaster	Flapper Wheel
25 C (77°F)	Pass 2°PPD	Pass 2°PPD
0°C (32°F)	Pass 1°PPD	Pass 1°PPD
-20°C (-4°F)	Pass 0.5°PPD	Pass 0.5°PPD

Impact (CSA-Z245.20-06, Clause 12.12)

Temperature	Bristle Blaster	Flapper Wheel
25 C (77°F)	Pass 5 Joules	Pass 6 Joules
0°C (32°F)	Pass 3 Joules	Pass 4 Joules
-20°C (-4°F)	Pass 2 Joules	Pass 4 Joules

Hardness (Shore D) (ASTM D-2240-91) [25° C (77° F)]: 82±2

**SAFETY:** Read the Material Safety Data Sheets before use.

**EFFECTIVE DATE:** October 21, 2016

SPC / Product Data Sheet SP-1288 GP.doc

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