

PRODUCT DESCRIPTION

TWO COMPONENT SOLVENT BASED EPOXY COATING

COPON EP 2306 is designed for use as a V.O.C. compliant high performance protective coating on the internal surfaces of gas pipelines.

COPON EP 2306 combines good application characteristics with excellent corrosion protection and chemical resistance. The cured coating withstands hydrostatic testing and pigging operations in service and makes a significant contribution to improved gas flow in service.

The use of COPON EP 2306 on gas pipelines has been the subject of numerous presentations and papers and the cost savings achieved with this coating have been reproduced worldwide.

COPON EP 2306 conforms to all major international specifications for gas pipeline coatings, including British Gas spec. CM1/CM2 and API SRL2.

Standard Colour Availability Manufactured only in a Red Oxide colour.

GENERAL PROPERTIES

Adhesion	Excellent to both blast cleaned and mechanically scraped surfaces.
Corrosion Resistance	Excellent even under aggressive immersion conditions.
Chemical Resistance	Unaffected by crude oil, natural gas, H ₂ S and SO ₂ mixtures.
Temperature Resistance	Suitable for use up to 100°C in dry service conditions.

PHYSICAL CONSTANTS

Total Solids Content (Average) by Volume	52%
Specific Gravity (Average Mixed)	1.18
V.O.C. (As Supplied)	415 gms/litre
NOTE:	Thinning for spray application will increase the applied V.O.C.
Film Thickness (Typical)	Wet 125 microns Dry 65 microns
	When product is thinned appropriate adjustment to wet film thickness should be made.
	Note: The thickness to be applied should be agreed between the specifier and the manufacturer dependent on operational performance criteria and may be higher or lower than the quoted typical value.
Theoretical Coverage Rate	8 m ² /litre at 65 microns dft

SURFACE PREPARATION

METHOD	Steel Surfaces should be abrasive blasted to a minimum Standard of Sa2½ - BS 7079: Part A1 1989 or equivalent.
	Where blast cleaning cannot be carried out the surface should be mechanically scraped to remove all loose scale and produce a surface which is clean, dry and free from rust or dust.

MIXING

Number of Components	Supplied in two parts: Base component and Activator component.
Mixing Ratio (by volume)	1 parts Base component. 1 part Activator component
Pot (Usable) Life	Approximately 12 hours at 20°C
Method of Mixing	Stir the contents of the Base component, continue stirring and gradually add the total contents of the Activator component, continue stirring until a homogeneous mix is obtained.

APPLICATION

METHOD	COPON EP2306 can be applied by brush, roller conventional or airless spray, with spray being the preferred method.
Typical airless spray settings are :-	
Airless Spray	Minimum 32:1 pump ratio Needle setup 1.4 - 1.8mm Tip pressure minimum 2,000 p.s.i.
Conventional Spray	Pressure Pot Needle setup 1.4 - 1.8 mm COPON EP2306 may require thinning for spray application, where thinning is required up to 10% COPON SA65 THINNERS may be added by volume. Good quality brushes and mohair rollers should be used for these methods of application.
Cleaning Note	Clean all equipment immediately after use with COPON SA65 THINNERS. When airless spray is being used, excessively high tip spraying pressures should be avoided, the minimum pressure at the pump conducive to good atomisation should be used.

DRYING AND CURE TIMES AT 20°C

Touch Dry	1 hour
Hard Dry	4 hours
Overcoating	min 2 hours max 7 days
Full Cure	7 days

HEALTH & SAFETY

1. In the wet state COPON EP 2306 is highly inflammable.
 2. Adequate ventilation must be provided during use
 3. Undue contact with the skin should be avoided.
- NOTE:** Full Health & Safety Data is available from E Wood Ltd.

PACKAGING AND STORAGE

Supplied in either 5 and 20 litre packs or the Base and Activator supplied separately in 20 and 200 litre containers.

Use within 2 years of purchase. Store in original sealed containers at temperatures between 5°C and 30°C.

Copon System Recommendations take precedence over individual Copon Product Data Sheets and are available on request.



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