

**PRODUCT DESCRIPTION****TWO COMPONENT SOLVENT BASED EPOXY COATING**

COPON EP2306 HF has been specifically developed as an internal lining for gas pipelines to provide maximum flow, which has been confirmed by independent testing.

COPON EP2306 HF 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 very significant contribution to increased gas flow and associated financial benefits.

The use of COPON EP2306HF 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 EP2306 HF conforms to all major international specifications for gas pipeline coatings, including British Gas spec. CM1/CM2 and API RP5L2.

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 CO ₂ mixtures.
Temperature resistance	Suitable for use up to 100°C in dry service conditions.

PHYSICAL CONSTANTS

Total Solids Content (Average) by volume	48%
Specific Gravity (Average Mixed)	1.14
V.O.C (As Supplied)	440g/litre
Note:	Thinning for spray application will increase the applied V.O.C
Film Thickness (Typical)	Wet 155 microns. Dry 75 microns
Note:	The actual thickness to be applied should be agreed between the specifier and the manufacturer dependant on operational performance criteria and may be higher or lower than the quoted typical value.
Theoretical Coverage Rate	6.4 sq metres per litre at 75 microns dft.

SURFACE PREPARATION

METHOD	Steel Surfaces - steel surfaces should be abrasive blasted to a minimum Standard of Sa2½ - BS 7079: Part A1 1989. The blast profile is generally specified by the client, a typical profile is 35 - 75 microns. 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.
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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
(by weight)	100 parts BAse component: 77 parts Activator component
Pot (Usable) Life	Approximately 8 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 HF can be applied by brush, roller, conventional or airless spray, with airless spray being the preferred method.

Typical airless spray settings are as follows :-

Airless Spray	Minimum 30: 1 pump ratio Tip Size 15-21 Thou orifice; Tip pressure minimum 2500 psi (175 bar)
Conventional Spray	Pressure Pot Needle Setup 1.4 - 1.8mm

Depending on prevailing conditions COPON EP 2306 HF may require thinning for spray application, where thinning is required no more than 2-5% COPON 1075 THINNERS should be added by volume.

For small areas good quality brushes and mohair rollers should be used.

Clean all equipment immediately after use with COPON 1075 THINNERS.

Note: When airless spray is being used, excessively high tip spraying pressures should be avoided. The minimum pressure at the pump conducive with good atomisation should be used.

DRYING AND CURE TIMES AT 20°C

Touch Dry	2 hours
Hard Dry	16 hours
Overcoating	min 4 hours max 7 days

HEALTH & SAFETY

1. In the wet state COPON EP 2306 HF is flammable.
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 Limited.

PACKAGING AND STORAGE

Supplied in either 5 and 20 litre packs, 200 litre & 1000 litre bulk 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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