

- Description:** S1239 primer is a specially formulated 100% volume solids (solventless) 2 component epoxy
- Recommended use:** As a epoxy primer in a 3 layer polyethylene coating system for superior corrosion protection of field welded joints of steel pipes. Can be used with Covalence Raychem* 3 layer coating systems : HTLP60, DIRAX, ROCS60E.
For DIRAX, ROCS60E the epoxy primer needs to be applied on the steel surface only. For HTLP60 the epoxy needs to be applied onto the steel surface AND onto the line coating, when this line coating is PE, FBE or CTE.
- Colour:** Black
- Volume solids:** 100%
- Weight solids:** 100%
- Mixing ratio:** (by volume) : 100 parts of base (part A) to 60 part of hardener (part B)
(by weight) : 100 parts of base (part A) to 40 part of hardener (part B)
- Typical coverage:** 6.14 sq.m/litre (66 sq.ft/litre) or 23.2 sq.m/US gallon (249.8 sq.ft/US gallon). This coverage is based on 100-150 microns or 4-6 mils average thickness.
- Specific gravity:** Base : 1.39
Hardener: 0.93
- Typical thickness:** 100-150 microns (4-6 mils)
- Pot life:** 100 min at 23°C, 25 min at 40°C
- Shelf life:** 5 years 23°C (73°F), out of direct sunlight. Shelf life will be lesser at higher temperatures.
- Flash point:** Part A (Base) : >132°C (270°F)
Part B (Hardener): 33°C (91.4°F)
- Thinner:** Do not dilute
- Application**
1. Prepare the pipe surface as recommended in the product application guide
 2. Pour hardener into base as per mixing ratio. Stir the mixture for approximately 1 minute to ensure a homogeneous mixture.
 3. Carefully apply mixed epoxy primer as indicated in the product application guide.
- Ordering info:** Epoxy kit :
S1239-PRIMER-KIT-252(C10)
This kit includes measured quantities of base resin and hardener, a stirring stick, applicator pad and gloves. This kit contains sufficient primer for up to 1.4 SQM (15 sqft) of coverage. The kits are packed per 10 pieces in a UN approved box.
- Bulk Epoxy:
Part A : S1239-PART-A-14.7L or S1239-PART-A-14.7L(EUR)
Part B: S1239-PART-B-17L or S1239-PART-B-17L(EUR)
Always order in multiples of 2 pails of part A by 1 pail of part B
For accessories to apply epoxy see DS-ACCESSORIES-REV-5-0506

Epoxy usage on steel surface only for DIRAX, ROCS60E

Assumption: 300 mm or 12" cut back, coverage 6.14 sq.m/litre

Pipe diameter		Quantity required		# Joints / US gallon	# Joints / Litre
		Part A	Part B		
DN	inches	ml	ml		
80	3.500	8.7	5.2	273	72
100	4.500	11.1	6.7	212	56
150	6.625	16.4	9.8	144	38
200	8.625	21.4	12.8	110	29
250	10.750	26.6	16.0	88	23

Pipe diameter		Quantity required		# Joints / US gallon	# Joints / Litre
		Part A	Part B		
300	12.750	31.6	18.9	74	19
350	14.000	34.7	20.8	68	18
400	16.000	39.6	23.8	59	15
450	18.000	44.6	26.7	53	14
500	20.000	49.5	29.7	47	12
550	22.000	54.5	32.7	43	11
600	24.000	59.4	35.7	39	10
650	26.000	64.4	38.6	36	9
700	28.000	69.3	41.6	34	9
750	30.000	74.3	44.6	31	8
800	32.000	79.2	47.5	29	7
850	34.000	84.2	50.5	28	7
900	36.000	89.1	53.5	26	7
950	38.000	94.1	56.4	25	6
1000	40.000	99.0	59.4	23	6

Epoxy usage on steel surface and line coating (PE, FBE, CTE) for HTLP60

Assumption: 450 mm or 17.75" wide HTLP60 sleeve, coverage 6.14 sq.m/litre

Pipe diameter		Quantity required		# Joints / US gallon	# Joints / Litre
		Part A	Part B		
DN	inches	ml	ml		
80	3.500	12.8	7.7	184	48
100	4.500	16.5	9.9	143	37
150	6.625	24.3	14.6	97	25
200	8.625	31.6	19.0	74	19
250	10.750	39.4	23.6	60	15
300	12.750	46.7	28.0	50	13
350	14.000	51.3	30.8	46	12
400	16.000	58.6	35.2	40	10
450	18.000	65.9	39.6	35	9
500	20.000	73.2	43.9	32	8
550	22.000	80.6	48.3	29	7
600	24.000	87.9	52.7	26	7
650	26.000	95.2	57.1	24	6
700	28.000	102.5	61.5	23	6
750	30.000	109.9	65.9	21	5
800	32.000	117.2	70.3	20	5
850	34.000	124.5	74.7	18	5
900	36.000	131.8	79.1	17	4
950	38.000	139.2	83.5	16	4
1000	40.000	146.5	87.9	16	4

For other sleeve widths, divide by 17.75 and multiple by new sleeve width in inches

Example: 20" (508 mm) sleeve width on a DN400 diameter pipe

Part A : 58.6 ml x 20/17.75 = 66.1 ml

Part B : 35.2 ml x 20/17.75 = 39.7 ml

Berry Plastics warrants that the product conforms to its chemical and physical description and is appropriate for the use stated on the technical data sheet when used in compliance with Berry Plastics written instructions. Since many installation factors are beyond the control of Berry Plastics, the user shall determine the suitability of the products for the intended use and assume all risks and liabilities in connection herewith. Berry Plastics liability is stated in the standard terms and conditions of sale. Berry Plastics makes no other warranty either expressed or implied. All information contained in this technical data sheet is to be used as a guide and is subject to change without notice. This technical data sheet supersedes all previous data sheets on this product.



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