

- Description:** S1301-M 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 : HTLP80, HTLP60, HTLP60-HP, DIRAX, ROCS60E.
For HTLP80, DIRAX, ROCS60E the epoxy primer needs to be applied on the steel surface only. For HTLP60 and HTLP60-HP 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) : 3 parts of base (part A) to 1 part of hardener (part B)
(by weight) : 5 parts of base (part A) to 1 part of hardener (part B)
- Typical coverage:** 6.0 sq.m/litre (64.7 sq.ft/litre) or 22.7 sq.m/US gallon (244.5 sq.ft/US gallon). This coverage is based on 100-150 microns or 4-6 mils average thickness.
- Specific gravity:** Base : 1.65
Hardener: 1
- Typical thickness:** 100-150 microns (4-6 mils)
- Pot life:** 30 min at 23°C, 15 min at 40°C
- Shelf life:** 3 years 23°C (73°F), out of direct sunlight. Shelf life will be lesser at higher temperatures.
- Flash point:** Part A (Base) : 143°C (289°F)
Part B (Hardener): > 118°C (244°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 :
S1301-M-KIT-1.4SQM-15SQFT
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.
- Bulk Epoxy:
Base : S1301-M-PART-A-18L-4.75GAL
Hardener: S1301-M-PART-B-18L-4.75GAL
Always order in multiples of 3 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 HTLP80, DIRAX, ROCS60E

Assumption: 300 mm or 12" cut back, coverage 6.0 sq.m/litre

Pipe diameter		Quantity required		# Joints / US gallon	# Joints / Litre
DN	inches	Part A ml	Part B ml		
80	3.500	10.6	3.5	267	70
100	4.500	13.7	4.6	207	54
150	6.625	20.1	6.7	141	37
200	8.625	26.2	8.7	108	28
250	10.750	32.6	10.9	87	22

Pipe diameter		Quantity required		# Joints / US gallon	# Joints / Litre
		Part A	Part B		
300	12.750	38.7	12.9	73	19
350	14.000	42.5	14.2	66	17
400	16.000	48.6	16.2	58	15
450	18.000	54.6	18.2	51	13
500	20.000	60.7	20.2	46	12
550	22.000	66.8	22.3	42	11
600	24.000	72.8	24.3	38	10
650	26.000	78.9	26.3	35	9
700	28.000	85.0	28.3	33	8
750	30.000	91.1	30.4	31	8
800	32.000	97.1	32.4	29	7
850	34.000	103.2	34.4	27	7
900	36.000	109.3	36.4	25	6
950	38.000	115.3	38.4	24	6
1000	40.000	121.4	40.5	23	6

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

Assumption: 450 mm or 17.75" wide HTLP60 sleeve, epoxy width = sleeve width, coverage 6.0 sq.m/litre

Pipe diameter		Quantity required		# Joints / US gallon	# Joints / Litre
DN	inches	Part A ml	Part B ml		
80	3.500	15,7	5,2	180	47
100	4.500	20,2	6,7	140	37
150	6.625	29,7	9,9	95	25
200	8.625	38,7	12,9	73	19
250	10.750	48,3	16,1	58	15
300	12.750	57,2	19,1	49	13
350	14.000	62,8	20,9	45	11
400	16.000	71,8	23,9	39	10
450	18.000	80,8	26,9	35	9
500	20.000	89,8	29,9	31	8
550	22.000	98,7	32,9	28	7
600	24.000	107,7	35,9	26	6
650	26.000	116,7	38,9	24	6
700	28.000	125,7	41,9	22	5
750	30.000	134,7	44,9	21	5
800	32.000	143,6	47,9	19	5
850	34.000	152,6	50,9	18	4
900	36.000	161,6	53,9	17	4
950	38.000	170,6	56,9	16	4
1000	40.000	179,5	59,8	15	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 : 71.8 ml x 20/17.75 = 80.9 ml
 Part B : 23.9 ml x 20/17.75 = 26.9 ml

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Local Distributor / Representative:

For contact details of local Distributors / Representatives
 Please visit www.berrycpg.com.

Headquarters : Berry Plastics Tapes & Coatings Division, Franklin MA, USA

Franklin, MA, USA
 Tel: +1 508 918 1714
 US Toll Free: +1 800 248 0149
 Fax: +1 508 918 1910
 CPG@berrypastics.com

Houston, TX, USA
 Tel: +1 713 676 0085
 US Toll Free: 01 888 676 7202
 Fax: +1 713 676 0086
 CPGH@berrypastics.com

Tijuana, Mexico
 Tel US: +1 866 9 CORROSION
 Fax US: +1 619 424 4258
 Tel Mexico: +52 664 607 0926
 Fax Mexico: +52 664 623 6463
 CPGTJ@berrypastics.com

Aarschot, Belgium
 Tel: +32 16 55 36 00
 Fax: +32 16 55 36 74
 CPGE@berrypastics.com

Baroda, India
 Tel: +91 2667 264721
 Fax: +91 2667 264724
 CPGIN@berrypastics.com