

Description:	S1401 primer is a specially formulated 100% volume solids (solvent less) two component epoxy
Recommended use:	As an epoxy primer in a 3 layer polyethylene coating system for superior corrosion protection of field welded joints of steel pipes. S1401 can be used with Covalence Raychem* 3 layer coating systems: HTLP80, HTLP60, DIRAX-60E, and HTLP-PP as the initial anti-corrosion layer or as wear cones in the PPS120 and DIRAX-PP system. For HTLP80, DIRAX-60E, HTLP-PP 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. S1401 can also be used as repair coating for PP and FBE line coatings.
Colour:	Grey
Volume solids:	100%
Weight solids:	100%
Mixing ratio:	(by volume): 5 parts of base (part A) to 1 part of hardener (part B) (by weight) : 100 parts of base (part A) to 12 parts of hardener (part B)
Typical coverage:	2 sq.m/litre (21.52 sq.ft/litre) or 6.6 sq.m/US gallon (70.7 sq.ft/US gallon). This coverage is based on 300 microns or 12 mils average wet film thickness.
Specific gravity:	Base: 1.8 Hardener: 1
Typical thickness:	300 microns (12mils)
Pot life:	20 min at 23°C (73°F)
Shelf life:	2 years 23°C (73°F), out of direct sunlight. Shelf life will be lesser at higher temperatures.
Flash point:	Part A (Base): 252°C (485.6°F) Part B (Hardener): 257°C (494.6°F)
Thinner:	Do not dilute
Application	<ol style="list-style-type: none">1. Prepare the pipe surface as recommended in the product application guide2. 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.

Curing Chart:

S1401	0°C	10°C	20°C	30°C	40°C	50°C	60°C
Pot Life	34 minutes	25 minutes	12 minutes	8 minutes	4 minutes	2 minutes	2 minutes
Gel Time	45 minutes	30 minutes	15 minutes	14 minutes	12 minutes	10 minutes	7 minutes
Dry time	9 hours	4 hours	1 hour	48 minutes	30 minutes	28 minutes	20 minutes
Shore D 70	9 hours	4 hours	2 hours	1hour 30min.	1hour 10min.	1 hour	50 minutes

Ordering info:

Epoxy kit: S1401-KIT-0.5L-0.13GAL/WA(C10)

This kit only includes measured quantities of base resin and hardener. Order quantity should be multiples of 10.

Epoxy accessories to mix and apply the epoxy should be ordered separately.

Bulk Epoxy:

Base : S1401-PART-A-18L-4.75GAL

Hardener: S1401-PART-B-18L-4.75GAL

Always order in multiples of 5 pails of part A by 1 pail of part B

Epoxy accessories to mix and apply the epoxy should be ordered separately.

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.



CORROSION PROTECTION GROUP

www.berrycpg.com

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@berryplastics.com

Houston, TX, USA

Tel: +1 713 676 0085
US Toll Free: 01 888 676 7202
Fax: +1 713 676 0086
CPGH@berryplastics.com

Tijuana, Mexico

Tel USA 858 633 9797
Fax US: +858 633 9740
Tel Mexico: +52 664 647 4397
Fax Mexico: +52 664 647 4370
CPGTJ@berryplastics.com

Aarschot, Belgium

Tel: +32 16 55 36 00
Fax: +32 16 55 36 74
CPGE@berryplastics.com

Baroda, India

Tel: +91 2667 264721
Fax: +91 2667 264724
CPGIN@berryplastics.com