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PRODUCT DATA SHEET

SP-1890 PRIMER FOR TWO-LAYER OR THREE LAYER POLYETHYLENE COATED PIPE

- DESCRIPTION** : Specialty Polymer Coatings, Inc.'s **SP-1890 Primer** is a two-component 100% solids modified epoxy polymer designed to provide superior adhesion between polyethylene and liquid epoxy weld coatings.
- ADVANTAGES** : - Provides outstanding adhesion to properly treated Polyethylene surfaces and Liquid Epoxy Weld coatings.
- 100% Solids (No VOCs)
- USES** : **SP-1890 Primer** is for use as an adhesion enhancer for liquid epoxy coatings when utilized on pipelines coated with two-layer and three-layer HDPE or HPCC.
- APPLICATION** : - Brush
- **Notes:** Both components are to be uniformly mixed together using a variable speed drill fitted with a mixing impeller. During mixing, care is to be taken to prevent the introduction of air into the product.
- MIXING RATIO** : - By Volume: 3.6 Parts Base to 1 Part Hardener
- By Weight: 100 Parts Base to 20.80 Parts Hardener
- RECOMMENDED
FILM THICKNESS** : 3 – 4 mils (75 – 100 microns)



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- SURFACE PREPARATION** : All surfaces to be treated or coated shall be free of grease, oil, moisture, soil, dust, abrasive material and all other contaminants. Prior to the application of **SP-1890 Primer**, the surface of the polyethylene shall be prepared using one of the following methods:
- Abrasive blast the polyethylene to thoroughly roughen the surface creating an anchor pattern of 3-4 mils (75-100 microns). Blasting the surface at an angle should be avoided as this will tend to make the surface full of “burrs” (carpet-like effect). Direct blasting at the surface will minimize this effect. **(Preferred Method.)**
 - Using a Scarifier, thoroughly abrade/roughen the surface of the polyethylene – Contact SPC.
 - Flame treat the surface of the polyethylene – Contact SPC.

HANDLING PROPERTIES:

- Pot Life** - 12 - 15 minutes @ 25°C (77°F)
- Application Temperature** - Minimum Application Temperature is 10°C (50°F).
- **Note:** To avoid the risk of condensation, the surface temperature must be 3°C (5°F) above the dew point.
- Dry Time for Re-Coat** - 2 Hours @ 25°C (77°F)
- 20 minutes @ 55°C (131°F)
- **Note:** Dry Time will decrease with higher temperatures
- Maximum Re-coat Interval** - 3 Hours @ 25°C (77°F). If the maximum re-coat time is exceeded, the cured primer must be removed by abrasive blasting or sanding. Remove all dust and other surface contaminants before applying new coat of primer.
- Storage/Shelf Life** Store in a cool, dry, well-ventilated area away from incompatible materials and all sources of ignition. Keep in a tightly sealed container. The Shelf Life is a minimum of 24 months in unopened containers.



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LIQUID PROPERTIES:

Appearance	- Off-White
Solids Content (%)	- 100%
Specific Gravity (ASTM D-792)	- 1.35 +/- 0.03 (Base) - 1.0 +/- 0.02 (Hardener)
Coverage (Theoretical – Base & Hardener Mixed)	- 1629 (ft ² /U.S. Gallon/mil) - 10 (m ² /Litre/100microns)

ADHESION: > 2000 PSI (ASTM D-4541 Type IV)

EFFECTIVE DATE: June 25, 2003