Specialty Polymer Coatings, Inc.

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PRODUCT DATA SHEET — SP-8888®

DESCRIPTION : **SP-8888®** Pipe Coating is based on the latest Zero VOC Novalac Technology. Product cures to a highly cross-linked coating for high temperature services in the Oil and Gas Industry (Cathodic Disbondment up to 150°C / 302°F). **SP-8888®** is available in Brush grade and spray Grade. **SP-8888®** is also available in Cartridges for coating repairs.

ADVANTAGES :
- 100% Solids - No VOCs
- Isocyanate free.
- Excellent resistance to high temperature cathodic disbonding up to 150°C (302°F).
- Excellent adhesion to grit blasted steel surfaces, Fusion Bond Epoxy and FRP.
- Excellent impact resistance.
- Good flexibility.

USES : Exterior coatings for pipe, valves and fittings used in buried or immersed services.

APPLICATION :
- Spray Grade: Graco Hydra-Cat - Tip Size: .019 - .031
- Brush Grade: Brush or Roller
- Cartridge: Manual Dispenser

CLEANING MATERIALS :
- SP-10® Equipment Wash
- SP-11® Tool Cleaner
- SP-12® Internal Storage Lubricant

FILM THICKNESS : Minimum – 35 to 45 mils *

* Consult with your SPC Representative.

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SURFACE PREPARATION (Steel Substrate)

- **Cleanliness** : Near White
- **Standards** : NACE 2, Sa 2½ (Swedish Scale, ISO 8501-1)
  : SSPC SP-10 (Steel Structures Painting Council)
- **Profile** : 2.5 mils to 5.0 mils (62 microns to 125 microns)

TEMPERATURE PARAMETERS DURING APPLICATION :

Substrate temperatures must be above 10°C (50°F) and at least 3°C (5°F) above the dew point. If the surface to be coated is below 10°C (50°F), preheating of the substrate is recommended (not to exceed 100°C / 212°F) prior to the application of **SP-8888®**. Refer to the Time Vs. Temperature Chart.

RE-COAT INTERVAL :

@ 25°C (77°F) - Maximum: 4 Hours
@ 100°C (212°F) - Maximum: 5 Minutes

- If the maximum re-coat interval is exceeded, the surface must be blast roughened to a minimum surface profile of 2.5 mils. Small areas (≤250 sq. cm.) may be sanded using medium grit (80-100) carborundum cloth. Prior to the re-coat application of the coating, the surface must be wiped free of all dust using a clean dry cloth.

MIXING RATIO :

- Brush Grade & Spray Grade - By Volume: 3 Parts Base to 1 Part Hardener.
- Cartridge - By Volume: 2 Parts Base to 1 Part Hardener.

HANDLING PROPERTIES:

Pot Life	- 100 gm mass @ 25°C (77°F)	30 minutes
Accept to Touch Time	- 30 mil coating thickness @ 25°C (77°F)	60 minutes
Tack Free Time	- 30 mil coating thickness @ 25°C (77°F)	2 hours
Dry Hard Time	- 30 mil coating thickness @ 25°C (77°F)	5 hours

Shelf Life

- Store in a dry, well-ventilated area at temperatures between 5°C (41°F) and 40°C (104°F). Keep the lids sealed. The Shelf Life is a minimum of 24 months.

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LIQUID PROPERTIES:		BASE	HARDENER
Appearance	-	Red Viscous Liquid	Amber Liquid
Solids Content (%)	-	100	100
Specific Gravity (ASTM D-792)	-	1.60 ± 0.03	1.08 ± 0.02
Specific Gravity (ASTM D-792)	-	Base & Hardener Mixed:	1.48 ± 0.03
Coverage (Theoretical)	-	Base & Hardener Mixed:	1629 (ft^2/U.S. Gallon/mil) 1.0 (m^2/Litre/mm)

PHYSICAL / MECHANICAL / ELECTRICAL PROPERTIES:

Hardness (Shore D) (25°C / 77°F) (ASTM D-2240)	88
Tensile Adhesion to Steel (ASTM D-4541-95 A4) (PSI) (25°C / 77°F) (Self-Alignment Adhesion Tester Type IV)	3995
Wet Adhesion (95°C / 203°F) (CSA-Z245.20-98, Clause 12.12, 28 Days)	Rating #1
Cathodic Disbondment (mm) (120°C / 248°F) (CSA-Z245.20-M98, 28 Days)	4.7 (1)(2)
Cathodic Disbondment (mm) (150°C / 302°F) (CSA-Z245.20-M98, 28 Days)	9.7 (1)(3)
Impact (CSA-Z245.20-98, Clause 12.12) @ 21°C ± 3°C (70°F ± 5°F)	Pass 1.5 Joules
Impact (CSA-Z245.20-98, Clause 12.12) @ 0°C ± 3°C (32°F ± 5°F)	Pass 1.5 Joules
Impact (CSA-Z245.20-98, Clause 12.12) @ -30°C ± 3°C (-22°F ± 5°F)	Pass 1.5 Joules
Flexibility (CSA-Z245.20-98, Clause 12.11) @ 21°C (70°F)	Pass 1.74°PPD
Flexibility (CSA-Z245.20-98, Clause 12.11) @ 0°C (32°F)	Pass 1.03°PPD
Flexibility (CSA-Z245.20-98, Clause 12.11) @ -30°C (-22°F)	Pass 1.02°PPD

(1) Test modified using an autoclave.
(2) Test Pressure: 50 psi
(3) Test Pressure: 100 psi

CHEMICAL RESISTANCE (One week immersion @ ambient temperatures):

Nitric acid, 10% solution	No change observed.
Sulfuric acid, 5% solution	No change observed.
Acetic acid, 5% solution	No change observed.
Sodium hydroxide, 10% solution	No change observed.
Sodium chloride, 10% solution	No change observed.
Toluene	No change observed.
Ethyl acetate	No change observed.
Ethanol, 50% solution	No change observed.
Mineral Oil	No change observed.

Effective Date: December 20, 2002