

Jotapipe PR 460

Product description

This is a single component phenolic coating. Specially designed for use with internal fusion-bonded epoxy linings.

Typical use

Specially designed for application onto the internal surface of steel pipes prior to coating with Jotapipe IL fusion-bonded epoxy coatings.

Colours

red

Product data

Property	Test/Standard	Description
Solids by volume	ASTM D2369	34 ± 2 %
Flash point	ISO 3679 Method 1	12 °C
Density	calculated	0,98-1,01 kg/l

The provided data is typical for factory produced products, subject to slight variation depending on colour.

Viscosity: Zahn #2 Cup: 20-25 seconds at 23 °C (73 °F)

Film thickness per coat

Typical recommended specification range

Dry film thickness	15 - 20 μm
Theoretical spreading rate	16,5 - 12,4 m ² /l

Exact film thickness requirements will be determined by the client/project specification.

Surface preparation

To secure lasting adhesion to the subsequent product all surfaces shall be clean, dry and free from any contamination.

Remove all contaminants such as grease, oil, salt etc. that may present on the pipe surface by industry approved methods, followed by thorough blast cleaning.

Surface preparation summary table

Substrate	Surface preparation	
	Minimum	Recommended
Carbon steel	Cleanliness minimum Sa 2½ corresponding to ISO 8501-1	Cleanliness minimum Sa 2½ corresponding to ISO 8501-1

Application

Application methods

The product can be applied by

Spray: Use conventional spray.

Prior to application of a uniform layer of Jotapipe PR 460 primer by conventional spray, ensure that the product has been homogenised. Allow for sufficient flash-off time after primer application prior to the primed part entering the pre-heating oven. Typical pre-heating and cure schedules should be matched with those of the respective Jotapipe IL fusion-bonded epoxy coating.

Indicative flash-off time prior to pre-heating: 10 minutes at 30 °C (86 °F).
Maximum pre-heat time before FBE applicaiton shall not exceed 4 hours at 180 °C (356 °F).

Thinner/Cleaning solvent

n-butanol, isopropanol

Additional information

For specific data on the FBE coating, refer to the respective Jotapipe IL Technical Data Sheet. Please refer to the relevant Application Guide for guidelines on the factory application of this product.

Packaging (typical)

	Volume (litres)	Size of containers (litres)
Jotapipe PR 460	18.9	20

The volume stated is for factory made colours. Note that local variants in pack size and filled volumes can vary due to local regulations.

Storage

The product must be stored in accordance with national regulations. Keep the containers in a dry, cool, well ventilated space and away from sources of heat and ignition. Containers must be kept tightly closed. Handle with care.

When stored at a maximum 25 °C (77 °F), a shelf life of 12 months is obtained from the date of manufacture.

Shelf life at 23 °C

In some markets commercial shelf life can be dictated shorter by local legislation. The above is minimum shelf life, thereafter the paint quality is subject to re-inspection.

Caution

This product is for professional use only. The applicators and operators shall be trained, experienced and have the capability and equipment to mix/stir and apply the coatings correctly and according to Jotun's technical documentation. Applicators and operators shall use appropriate personal protection equipment when using this product. This guideline is given based on the current knowledge of the product. Any suggested deviation to suit the site conditions shall be forwarded to the responsible Jotun representative for approval before commencing the work.

Health and safety

Please observe the precautionary notices displayed on the container. Use under well ventilated conditions. Do not inhale spray mist. Avoid skin contact. Spillage on the skin should immediately be removed with suitable cleanser, soap and water. Eyes should be well flushed with water and medical attention sought immediately.

Colour variation

When applicable, products primarily meant for use as primers or antifoulings may have slight colour variations from batch to batch. Such products may fade and chalk when exposed to sunlight and weathering.

Disclaimer

The information in this document is given to the best of Jotun's knowledge, based on laboratory testing and practical experience. Jotun's products are considered as semi-finished goods and as such, products are often used under conditions beyond Jotun's control. Jotun cannot guarantee anything but the quality of the product itself. Minor product variations may be implemented in order to comply with local requirements. Jotun reserves the right to change the given data without further notice.

Users should always consult Jotun for specific guidance on the general suitability of this product for their needs and specific application practices.

If there is any inconsistency between different language issues of this document, the English (United Kingdom) version will prevail.
