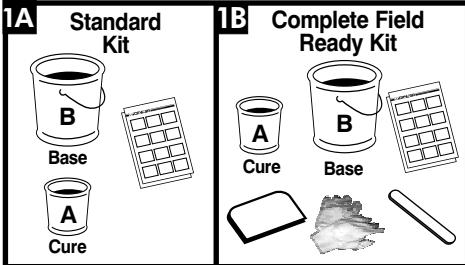


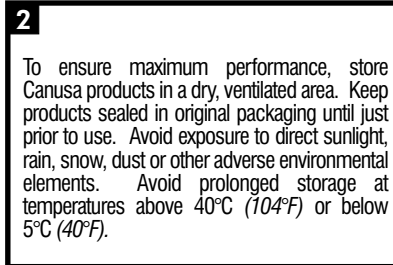
HBE-95 - Brush Grade

High Build Epoxy Coating

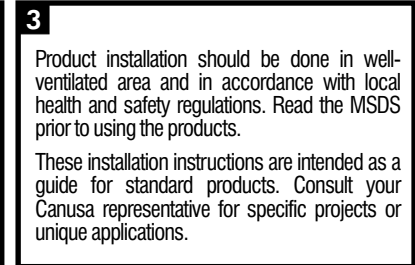
Kit Contents



Storage Guidelines

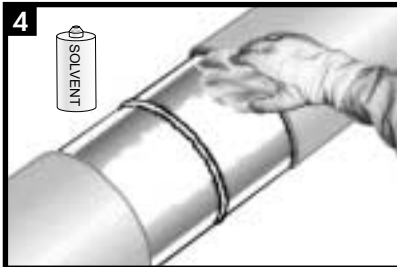


Safety Guidelines

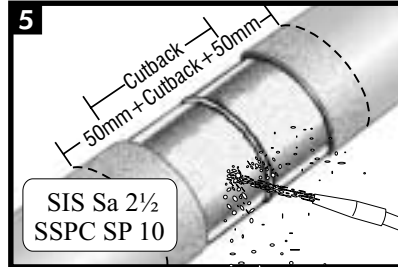


HBE-95 is a two part epoxy coating used for protection of pipeline valves, fittings and field joints. HBE-95 is supplied in kits containing pre-measured components of Part A-**HBE-95 Cure** (small container) and Part B-**HBE-95 Base** (large container). The "Standard Kit" only contains the HBE-95 components while the "Complete Field Ready Kit" also has a stir stick, scraper and gloves. Both kit styles have an Installation Guide and MSDS's.

Surface Preparation



Clean exposed steel and adjacent pipe coating with a non-oily solvent cleanser (ie. ethanol, MEK, etc.) to remove the presence of oil, grease, and other contaminants.

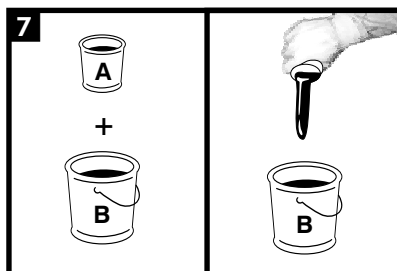


Ensure that the pipe is at least 3°C (5°F) above the dew point before cleaning. Thoroughly clean the cutback area to "near white metal" SIS Sa 2 1/2 (SSPC-SP10) or equivalent. Lightly abrade at least 50mm (2") of the line coating on each side of cutback area.



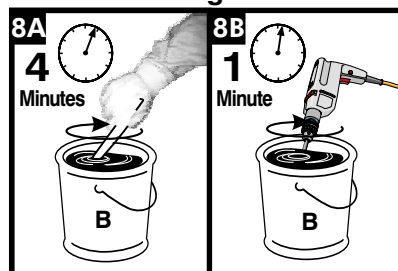
Wipe clean with a lint-free cloth or air blast the steel and pipe coating to remove foreign contaminants. Surface must be clean and dry prior to application of HBE-95.

HBE-95 Mixture



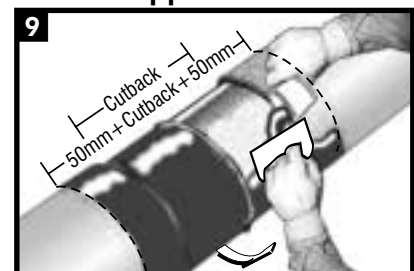
Components must be warmed to at least 20°C (68°F) prior to mixing. Pour Part A-**HBE-95 Cure** (small container) into Part B-**HBE-95 Base** (large container). Scrape walls and lids of both containers to ensure all product is used. When mixing, slow the mixer down at the surface of the liquid to prevent the introduction of air into the coating. Do not add solvent or other materials to the mixture.

HBE-95 Stirring



A. Begin mixing slowly. After initial mix has been achieved, a spatula or mixing stick should be used to remove any resin from the side of container.
B. Mix at such a speed that ensures a uniform mix, but does not create a vortex in the liquid. At temperatures between 20°C (68°F) and 40°C (105°F), mix for one (1) minute with a drill stirrer or four (4) minutes with a spatula, blending both parts to create one uniform colour with no streaks.

HBE-95 Application



Use a brush, roller or trowel to apply HBE-95 to the joint or patch area to a specified minimum thickness. Cover at least 50mm (2") of the mainline coating. Coating should only be applied at temperatures above 10°C (50°F) and when the ambient temperature is 3°C (5°F) above the dew point. See "Useful Application Information" for other application temperature criteria. *Note: Pipe substrate can be pre-heated to 85-95°C (180-200°F) in order to accelerate curing or to cure in cold conditions.*

Useful Application Information

- The ideal mixing and application temperature is between 20°C (68°F) and 40°C (105°F).
- The workable pot life after mixing is approximately 15 minutes at 20°C (70°C). Pot life will be extended at lower temperatures and shortened at higher temperatures.
- A variation on high build application technique: One successful approach has been to build a first coat of 15 - 20 mils (300-500 microns) around entire circumference, followed **immediately** by a second coat to achieve specified film thickness.

HBE-95 - Brush Grade

High Build Epoxy Coating



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