

# PIPESTOP 500

Two component epoxy paint for internal coating of gas pipelines

## NATURE AND USE

Pipestop 500 is an epoxy paint studied for the internal protection of pipelines to be used for gas transport. The product is technologically innovative and complies with present today's needs to reduce Organic Volatile Components emissions (VOC) during the spray application and combines excellent applicability characteristics with excellent corrosion protection and chemical resistances.

Pipestop 500 is the result of the long and proven Stoppani experience in the manufacturing of coatings for pipes protection, the cured film helps pigging operations, hydrostatic tests on the pipe and allows a significant improvement of the gas flow in service, avoiding the carried product to be contaminated by mill scales or scales deriving from chemical-physical degradation of the steel substrate of the pipe. The considerable long term advantages are referred to pumping costs of the product, and to a long term protection against corrosion.

**Product Qualified SNAM according to specification GASD C 9.11.01**  
**Complies with EN 10301 – ISO 15741 – API RP5 L2**

## TECHNICAL DATA



Type of Binder:		Epoxy
Viscosity @ +20°C:	s	Thixotropic
Specific Gravity A+B	Kg/l	1,38 ± 0,05 @ +20°C
Solids by Weight:	%	97 ± 2 % A+B
Solids by Volume:	%	95 ± 2 % A+B
Mixing Ratio by Weight:		75 parts of Base / 25 parts of Hardener
Mixing Ratio by Volume:		2.5 parts of Base / 1 part of Hardener
**Pot life @ +20°C:		~ 4 hours
Colour:		Oxide Red

## SUBSTRATE PREPARATION

The substrate should be cleaned, greases and contaminants free and perfectly dry. The substrate should be abrasive blasted to Swedish Standard of SA 2 ½ according to ISO 8501-1 with a medium roughness of about 40 - 50 µm Rz DIN (cut-off 2,5). Remove dust with dehumidified compressed air.

## PRODUCT PREPARATION

(Airless application) Mix the two components separately. Add component B to component A and stir until the complete homogenization is obtained.

Await 5 minutes before the application. However, the time indicated may increase or decrease according to the equipment used for the application.

\*\* The "POT LIFE" time of two components products (time within which it is possible to apply the paint mix of Base and Hardener), is exponentially dropped by the increase of product temperature.

Note: The use of a mix of paint (Base + Hardener) over the POT LIFE time is irreparably compromising all the properties of the coating film.\*\*

## APPLICATION DETAILS

### Application method:

Dual Feed Hot Airless Spray for two components (bi-mixer)  
Compression ratio 45:1 minimum  
Standard Airless Spray with compression ratio 60:1 minimum  
Pump pressure 4- 5 atm  
tip pressure about 240 – 300 atm.,  
tip size 15-28 Thou with different fan width depending on Ø of pipes to coat.

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Company with quality management system UNI EN 9001:2015 certified

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<b>Thinning:</b>	The product is supplied ready for use. If thinning is required in particular ambient conditions, up to 5% max of Thinner 555 can be added.
<b>Cleaning:</b>	Thinner for epoxy products type Epothinner or Thinner 555
<b>Defects repairing:</b>	Should a defect in the film appear, roughen the affected area. Clean it with solvent and repair the same by brush or spray Application until the suitable thickness is reached.
<b>Hardening &amp; Curing times:</b>	Touch dry 4-5 hours Through dry 12-18 hours Full cure 7-10 days Possibility of forced air drying at +40°C -/+65°C after flash period of 30 - 60 minutes at least.
<b>Overcoating @ +20°C:</b>	Min. 12 / Max. 24 hours
<b>Application temperature:</b>	Min. +8°C / Max. +40°C
<b>Suggested pre-heating temperature of the components (airless-bimixer):</b>	Base = +50 / +60°C Hardener = +40/+50 °C
<b>Temperature of the product before application (brush or traditional airless):</b>	+25/+35 °C (suggested)
<b>Temperature of the substrate:</b>	from +5°C to + 40°C; anyway always more than +3/5°C above the dew point
<b>Relative humidity:</b>	% ≤ 85 %
<b>Suggested thickness:</b>	70-90 µm dry ( DFT). Wet film 75-95 µm (WFT) Min. 60 – Max. 120 µm dry (DFT)
<b>Theoretical spreading rate:</b>	sqm/kg 8,6 at the thickness of 80 µm DFT
<b>More info by writing to <a href="mailto:sales@industriestoppipanipaints.com">sales@industriestoppipanipaints.com</a> or by calling +39 030 9745116</b>	

## HANDLING STORAGE AND SAFETY PRECAUTIONS

**Warning:** All handling and/or use activities of the material and its components must strictly refer to the given indications in the Safety Data Sheet (Base and Hardener). The following advices are stated by common sense and in good faith, they are uncompleted and do not substitute the content of each specific safety data sheet of the product.

**Handling:** The material must be used only by professional and qualified applicators suitably trained. All the operations involving the use of the product, must be carried on in compliance with all the relevant National Health, Safety & Environmental standards and regulations.

**Precautions:** When the product is used in enclosed areas (rooms, containers, vessels, etc.) it is imperative to use adequate means providing the necessary air circulation, to be granted during the whole application and coating polymerization time, also to avoid conditions open to potential explosion danger.

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All electrical installations must always be grounded. Where explosion hazards exist, the workmen should be required to use only non-ferrous tools and wear conductive non-sparking shoes and clothing. Explosion and flame-proof equipment too are required.

**Storage and transport:** Keep far from flames, sparks or heat sources. Do not leave exposed under direct solar action. Store under shelter in original unopened packaging, in cool, dry and ventilated areas, at temperatures between +5°C and +35°C.

**Shelf life:** **Base** 12 months in the suggested storage conditions (original unopened packaging)  
**Hardener** 12 months in the suggested storage conditions (original unopened packaging)

N.B.: **Product for professional use only**  
and exclusively for the uses not regulated under CE Directive 2004/42/CE.

Refer to Material Safety Data Sheet



Access catalogues, data sheets and company presentations