



KARUMEL PP100 is a phenolic based liquid coating designed for priming the inside diameter of pipe prior to applying high performance epoxy powder coatings PP100 designed for use at high temperatures and pressures.

| Physical Properties          |                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                               |                |
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| Finish and Color             | Red Brown                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                     |                |
| Specific gravity             | Approx. 1.30 kg/L                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                             |                |
| Solids by volume             | Approx. 53%                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                   |                |
| Spreading rate (Theoretical) | 10 m <sup>2</sup> /L in 30 microns dry film thickness on a smooth surface                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                     |                |
| Flash point                  | 26°C / 79°F (Closed Cup)                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                      |                |
| Application details          |                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                               |                |
| Method of application        | <ul style="list-style-type: none"><li>– Abrasive blasting to (Sa 2.5 – Sa 3) Near White Metal</li><li>Remove any rust, dust, grease, oil and other contaminants from surface to be coated.</li><li>– The surface must be completely cleaned and dried. Do not apply when relative humidity is above 85%.</li><li>The surface temperature must be at least 3°C (5°F) above dew point to prevent condensation. In confined areas, ventilate with clean air during application to assist solvent evaporation.</li><li>– Xylene, Methoxy propyl alcohol, Buty cellosolve, 1-Butanol can be used as a Thinner. Generally thinning rate is 5%</li><li>– Apply KARUMEL PP100 to substrate by air spraying with DFT of 12 ~ 25µm.</li><li>– Follow recommended post cure schedule as below.</li></ul> |                |
| Film thickness               | One coat with minimum DFT as low as 0.5 ~ 1 mil                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                               |                |
| Drying time                  | Heat primed steel to the recommended FBE powder application temperature. Holding time in the oven shall not exceed 4 hours at a maximum pre-heat temperature of 450°F                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                         |                |
| Recoating interval           | The following theoretical curing schedules are recommended to achieve maximum performance properties.                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                         |                |
|                              | Pipe Temperature                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                              | Post Cure Time |
|                              | 351~410°F (177~210°C)                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                         | 30 min         |
| Storage and package          |                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                               |                |
| Shelf life                   | 18 months @ 25°C                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                              |                |
| Storage                      | <p>Can of bottom composition should be turned regularly twice a month.</p> <p>Avoid prolonged breathing of solvent vapors.</p> <p>Use with adequate ventilation.</p> <p>Respiratory protection is recommended when applying this material in confined spaces or stagnant air.</p> <p>Keep away from sparks and open flames. Although this product air dry rapidly, it remain somewhat soft until exposed to heat over 200°C/392°F and may be susceptible to mechanical damage.</p> <p>If prolonged storage of primed items is required over 5 hours, open ends of the applied piping shall be</p>                                                                                                                                                                                             |                |

kept closed with plastic sheets.

| Remarks           |                                                                                                                                                                                                                                                                                                                                                                        |
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| <b>Note</b>       | <ul style="list-style-type: none"><li>– Read Material Safety Data Sheet for complete hazard and safety information.</li><li>– All data are based on laboratory testing and practical experience.</li><li>– The information is believed to be accurate, however without any obligation.</li><li>– Contact your KCC sales representative for more information.</li></ul> |
| <b>1'st issue</b> | 2012-01-01                                                                                                                                                                                                                                                                                                                                                             |
| <b>Revision</b>   |                                                                                                                                                                                                                                                                                                                                                                        |

Disclaimer : The information in this data sheet is believed to the best of our knowledge based on laboratory test and practical experience. However, there are many factors affecting the performance of product and the product quality itself, so we are not able to guarantee without the confirmation of the purpose of using the product from us in writing. We reserve the right to change the data without notice and you should check that this data sheet is current prior to using the product.

