



# Protal 7000 & 7200

## Field Application Instructions

1. Clean exposed steel and adjacent pipe coating with non-oily solvent cleaner (i.e., ethanol, MEK, etc.)
2. The substrate temperature range for application of Protal 7000 or 7200 is 50°F (10°C) to 185°F (85°C). The substrate temperature must be a minimum of 5°F (3°C) above the dew point temperature before proceeding with the coating operation. If the ambient temperature is below 50°F (10°C) the substrate shall be heated.

### PRE-HEATING:

**Propane Heating:** All surfaces to be coated shall be grit blasted to a near white finish (SSPC SP-10, NACE 2 or Sa 2 1/2). Edges of the existing coating shall be roughened by sweep blasting the coating for a distance of 1" (25 mm) minimum. Preheat the pipe with a propane tiger torch up to 200°F (93°C) or the desired temperature. The temperature can be checked with a magnet thermometer or Raytek Temperature Gun. Hot sticks are not recommended and shall not be used to check the temperature of the substrate. Once the desired temperature is achieved, the surface to be coated shall be sweep blasted to remove any contaminants.

**Induction Coil Heating:** All surfaces to be coated shall be grit blasted to a near white finish (SSPC SP-10, NACE 2 or Sa 2 1/2). Edges of the existing coating shall be roughened by sweep blasting the coating for a distance of 1" (25 mm) minimum. Place the induction coil around the pipe and heat to 185°F (85°C) or the desired temperature.

3. Wipe clean with a lint-free cloth or air blast the substrate. Surface must be clean and dry prior to the application of the Protal coating.
4. Mix separately with a stir stick Part A and B prior to mixing products together. Pour contents of Part B Hardener (small container) into Part A Resin (large container). Scrape walls and bottom of Part B to ensure all hardener has been used. All kits are pre-measured quantities therefore do not add additional Part B Hardener as this will effect the quality of the mixed coating. At no time shall thinner be added.

### MIXING:

**Stir Stick:** Begin mixing Part A and B together until a uniform color mix is achieved (approximately two minutes). During mixing, careful attention should be made to ensure the walls and bottom are scraped and mixed thoroughly. No streaks should be visible.

**Power Mixer:** Begin mixing Part A and B together at a speed that ensures a uniform color is achieved (approximately two minutes). Avoid moving paddle/mixing tip in an up and down motion, as this will introduce air into the product. During mixing, careful attention should be made to ensure the walls and bottom are scraped and mixed thoroughly. No streaks should be visible.

5. **Application shall take place immediately after mixing. POUR the product onto the surface and spread down and around with a brush, 1/4" nap roller or Denso applicator pad. DO NOT APPLY THE PRODUCT BY DIPPING THE BRUSH OR APPLICATOR INTO THE BUCKET.** Spread the coating in bands beginning from twelve o'clock to six o'clock on each side of the pipe while overlapping strokes at both top and bottom. The Protal coating shall be applied at the specified Dry Film Thickness (DFT) up to 40 mils. The average wet film thickness is typically applied 25-30 mils in one coat. Wet film measurements shall be taken during application to ensure close adherence to the specified thickness.

For detailed instructions please see "Protal Hand Application Specifications".



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