



Protal™ 7200

Plural Spray Application Specifications

1.0 Scope

- 1.1 This specification covers the external surface preparation and coating of pipelines for rehabilitation, welds, directional drill, fittings and fabrication.
- 1.2 All spray application personnel shall be trained by a Denso representative prior to application of Protal 7200. Additionally, all spray application personnel shall be trained in the proper spray pump operational procedures by the specific spray pump manufacturer.

2.0 Material and Storage

- 2.1 Material shall be Denso Protal 7200 liquid coating system as manufactured by Denso North America, 9747 Whithorn Drive, Houston, TX 77095 (Tel) 281-821-3355 (Fax) 281-821-0304 or 90 Ironside Crescent Unit 12, Toronto, Ontario, Canada M1X1M3 (Tel) 416-291-3435 (Fax) 416-291-0898. E-mail: info@densona.com.
- 2.2 Material shall meet the physical properties of the attached product data sheet.
- 2.3 Storage of the material shall be in a warm dry place, between 40°F (4°C) to 105°F (41°C). The containers shall be stored up right. Do not allow material to freeze.

3.0 Equipment

- 3.1 Graco XP70 Plural Component Sprayer designed to mix and atomize 100% solids epoxies. At a minimum the equipment shall consist of the following components:
 - 3:1 mix ratio set up with pressure relief valves and recirculation valving
 - 145cc: 48 cc displacement pump set up
 - 4 kW inline heaters
 - 25 gallon (94.6 L) heated tanks
 - 5:1 supply pumps in heated tanks
 - 45:1 Merkur solvent flush pump
 - Pressure monitor for ratio assurance (preferred)
 - 100' (30.4 m) heated hose bundle (1/2" / 12.7 mm resin, 3/8" / 9.5 mm hardener, 1/4" / 6.4 mm solvent)
 - 2 each 3/8" (9.5 mm) x 12 element static mixers (stainless steel preferred)
 - 1/4" (6.4 mm) whip hose (15' / 4.5 m to 25' / 7.6 m) with 1/4" (6.4 mm) static mixing tip
 - All hoses need to comply with pressure ratio limits @ 7200 PSI (49.6 MPa)
 - XTR Spray Gun
 - Tip size: .019 - .031

- 3.2 Part A should be heated to 140°F - 160°F (60°C - 71°C) and Part B heated to 100°F - 110°F (38°C - 43°C). Hose bundle shall be set at 140°F - 150°F (60°C - 65°C).

- 3.3 A solvent such as Xylene, MEK, Toluene, or a combination of the three is recommended to clean the equipment.

- 3.4 Wet film thickness gauges.

4.0 Surface Preparation

- 4.1 All contaminants shall be removed from the steel surface to be coated. Oil and grease should be removed in accordance with SSPC SP-1 using the solvent Xylene.

- 4.2 Material for abrasive cleaning shall be the appropriate blend of grit to produce an angular surface profile of 2.5 - 5 mils (0.063 - 0.125 mm).

- 4.3 All surfaces to be coated shall be grit blasted to a near-white finish (SSPC SP-10, NACE No. 2 or Sa 2 1/2). *Note: Near-white finish is interpreted to mean that all metal surfaces shall be blasted clean to remove all dirt, mill scale, rust, corrosion products, oxides, paint and other foreign matter. Very light shadow, very light streaks or slight discoloration's shall be acceptable; however, at least 95% of the surface shall have the uniform gray appearance of a white metal blast-cleaned surface as defined by Swedish Pictorial Surface Preparation Standard Sa 2 1/2 or SSPC VIS-1.*

- 4.4 Edges of the existing coating shall be roughened by power brushing or by sweep blasting the coating for a distance of 1" (25 mm) minimum.

- 4.5 The Contractor shall check the surface profile depth by using a suitable surface profile gauge (Press-O-Film Gauge or equal).

- 4.6 Metal areas that develop flash rust due to exposure to rain or moisture shall be given a sweep blast to return them to their original blasted condition.

5.0 Application

- 5.1 The surface shall have no condensation, precipitation or any other forms of contamination on the blasted surface prior to coating.

- 5.2 The substrate temperature range for application of Protal is 50°F (10°C) to 212°F (100°C). The substrate

temperature must be a minimum of 5°F (3°C) above the dew point temperature before proceeding with the coating operation. Ambient temperature may be lower than 50°F (10°C) if the substrate is heated. Preheating may be accomplished with a propane torch or induction coil prior to abrasive blasting.

- 5.3 Using the prescribed equipment (Sect. 3.0), Protal shall be applied using a wet on wet spray technique to the specified Dry Film Thickness (DFT). Protal 7200 can be applied in a single coat from 20 to 60 mils (508 - 1524 microns) WFT.
- 5.4 The thickness of Protal should be checked continuously by wet film gauge to achieve the minimum/maximum film thickness specified. Notification to the applicator of any inadequately coated sections must be made immediately and repaired.

6.0 Inspection

- 6.1 The finished coating shall be smooth and free of runs, sags and/or holidays. All surfaces shall have the required minimum/maximum DFT. In general, the surface of the coating shall be no rougher than the base or substrate material.
- 6.2 After the Protal has cured to a hard cure condition, the owner's representative and/or contractor's inspector should measure the film thickness by magnetic gauge and notify the applicator of their acceptance.
- 6.3 For most applications, backfill can be accomplished when the coating reaches a Shore D of 70. The "thumb nail test" can also be used. The thumb nail test is defined by when one can no longer make a permanent indentation in the coating using one's thumb nail.
- 6.4 An acceptable field test to check to see if the coating has a full chemical cure, a solvent such as Xylene, MEK or Toluene can be rubbed on to the coating. If the gloss/sheen is removed the coating is not fully cured.
- 6.5 Spark testing shall be performed to ensure proper film thickness and for holiday inspection. The voltage used for testing weld joints and field applications shall be equal to that used for testing the mainline coating in the field or 125 volts/mil (4,920 V/mm).
- 6.6 Denso and/or the owner's representative immediately upon completion of the work shall make final inspection of the completed application. Notification of all defects must be made within a reasonable time frame from completion of the work to allow for all repairs within the allowed time frame for the project.
- 6.7 Recoating: If a second coat is required and passes the cure test as described in section 6.3, the surfaces shall be roughened by sweep blasting. If the coating is soft, no surface preparation is required.

7.0 Repairs

- 7.1 Pinhole repairs may be repaired by using Protal Repair Cartridges. Areas shall be roughened a minimum 1

in. around holiday using Carborundum cloth or 80 grit sandpaper and wiped clean with a cloth or brush prior to patching. Hot melt sticks may be used for repairs during lowering in, if approved by owner.

- 7.2 Areas larger than 0.15 sq. in. (0.3 sq. cm.), but less than 1.0 sq. ft. (100 sq. cm.) shall be repaired using a Protal Repair Cartridges. The surface to be coated shall be clean and dry prior to applying the coating. Surfaces below 40°F (4°C) shall be pre-heated in accordance with Section 5.2. Areas requiring repair shall be prepared with a surface grinder or by grit blasting prior to application of the coating. All edges of the surrounding area should be feathered prior to performing the repair.
- 7.3 Refer to "7200 Accelerated Cure Specifications for Repairs" for additional information.

8.0 Safety Precautions

- 8.1 Follow the guidelines detailed in the Safety Data Sheets (SDS).
- 8.2 Keep containers closed when not in use. In case of spillage, absorb with inert material and dispose of in accordance with applicable regulations.
- 8.3 No open flames, smoking or welding will be allowed in the immediate vicinity during the spray application of Protal 7200 liquid coatings.
- 8.4 Always refer to project specifications as they may supercede Denso specifications.



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