

HPP FAST SET ANNULUS FILL

#650

SOLVENT-FREE EPOXY
RESIN



**HUNT PIPELINE
PRODUCTS, LLC**

Hunt Pipeline Products

PRODUCT DATA SHEET

HPP #650 is based on pure **liquid** epoxy polymers and proprietary polyamine curing agents. It is formulated with *no* volatile solvents and is so completely tolerant of water that it may be applied to damp or wet surfaces yet still function well as a reinforcing annulus filler. Applications are easily made by pouring or pumping. Odor during application is almost completely absent so there are no requirements for artificial ventilation.

The **HPP #650** formulation has been successfully tested against ASTM E-84, 24' tunnel test, and generated zero flame or smoke.

HPP #650 can be shipped by Ground "Non-Regulated" by USDOT. When shipped by Air or Ocean **HPP #650** base is classified UN3082, PGIII unless shipped in approved containers of <5L, (<1.32 gallons), individual capacity.

RECOMMENDED USES

Annulus filler – recommended for use where a medium fast set is required in applications of less than about 5 gallons. In larger applications where an excessive exotherm may be generated the slower curing **HPP Slow Set #670** may be appropriate.

TECHNICAL INFORMATION

COMPOSITION :	Vehicle Type.....	Epoxy/Polyamines
	Pigmentation.....	None
	Solids by Volume.....	100%
	Flash Point	Over 212°F
	VOC	Essentially Zero
APPEARANCE:	Gloss	Full gloss
	Color.....	Clear, slightly amber
APPLICATION:	Methods	Install by pumping or pouring
	Mixing Ratio	Base 1.77 / Cure 1.00 by volume
	Consumption, (theor.)	1 gallon occupies 231 cubic inches
	Induction Time	Not Required - may be used immediately after mixing
	Pot Life.....	Approx. 45' @ 77°F, (25°C)
	Curing Time	24 hours firm cured @77°F, (25°C) "Full curing" in 5 days @ 77°F, (25°C)
STORAGE:	Shelf Life.....	24 months under normal storage conditions

APPLICATION NOTES

MIXING PROCEDURE: **HPP #650** is supplied in premeasured kits of epoxy base and curing agent. Kits are sized according to the volume of the annulus filling in order to assure convenient mixing with minimum wastage. A "Jiffy" type mixer with a high torque motor is recommended for proper blending of larger kits, standard paint mixers work well for smaller kits of 2-gallons or less. When mixing pour the curing agent into the base and mix for about 2 minutes taking care to stir in all base material from the edges and base of the plastic pail, *unmixed material will never harden*. No induction or "sweat-in" time is required and the mixed material may be used immediately.

Pot life and reaction time is heavily dependent on temperature, as a general guide figure that each 18°F, (10°C), variation in temperature above or below 77°F, (25°C), will respectively halve or double the pot life and cure times.

INSTALLATION: Install the mixed **HPP #650** resins by simply pouring or by injection through ports as appropriate. The **HPP #650** is low viscosity, similar to 30 weight motor oil, and will flow easily to completely fill the annulus.

A slight exotherm, or heat generation, may be noticed during curing however this will have no detrimental effect on the final product. The slower curing a slight exotherm will be noticed When large installations are required the slower curing **HPP #670** is available, this product is designed to cure much more slowly in order to minimize exotherm in a large mass.

CURING BEFORE SERVICE: **HPP #650** will cure to a hard resin within 24 hours. Allow at least three (3) days at 77°F/25°C before subjecting to aggressive chemical service from industrial solvents and similar materials.

WE URGE YOU TO READ THE MATERIAL SAFETY DATA SHEET (MSDS) BEFORE USING PRODUCT AND TO CALL THIN FILM TECHNOLOGY, INC. AS NECESSARY FOR ADVICE OR INFORMATION BEFORE ANY ACTUAL OR CONTEMPLATED APPLICATION.



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SAFETY: This is a hazardous material if misused. Read and understand the Material Safety Data Sheet (MSDS) before use.

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