

	www.teknos.com		
PRODUCT NAME 02 01/2017	TEKNOPOX 3297-00 Next Generation Flow Coat		
PRODUCT DESCRIPTION	TEKNOPOX 3297-00 is a two component, almost solvent-free epoxy coating.		
INTENDED USE	TEKNOPOX 3297-00 is a friction reduction coating for the inner surface of pipelines used for the transport of non-corrosive gas. The allowed temperature range for the natural gas pipes that have been coated with TEKNOPOX 3297-00 is between -40°C and 120°C. Resistance to dry heat up to 120°C continuous, approx. 250°C short term		
SPECIAL CHARACTERISTICS OF THE COATING	TEKNOPOX 3297-00 results in a very smooth and mechanically robust coating, with excellent corrosion protection which is applied directly to blast cleaned steel surfaces. TEKNOPOX 3297-00 offers fast curing and is tolerant to adverse drying conditions. TEKNOPOX 3297-00 meets stringent requirements regarding solvent emissions. The coating meets the requirements according to: <ul style="list-style-type: none"> - API Standard RP 5L2: Internal of line pipe for non-corrosive gas transmission service - DIN EN 10301: Steel tubes and fittings for on- and offshore pipelines – Internal coatings for the reduction of friction for conveyance of noncorrosive gas - ISO 15741: Paints and Varnishes – Friction-reduction coatings for the interior of on- and offshore steel pipelines for non-corrosive gases - CTO Gazprom 2-2.2-180-2007: Technical requirements for the internal coating of pipes for construction of main gas pipelines 		
TECHNICAL DATA			
Mixing ratio	TEKNOPOX 3297-00 (Comp. A): TEKNOPOX HARDENER 7582 (Comp B):	3,5 by vol. 1 by vol. Mixing tolerance 5%	5,3 by weight 1 by weight Mixing tolerance 5%
Pot life at 20°C Pot life at 40°C	approx. 45 min approx. 15 min Pot life may vary depending on conditions of application		
Solid content	98±2 by weight.-% 97±2 by volume.-%		
Volatile organic compound (VOC)	approx. 20 g/l		
Recommended film thickness and theoretical spreading rate	dry film (µm)	wet film (µm)	Theoretical spreading rate m ² /kg m ² /l
	80	85	8,3 12,2
	100	105	6,7 9,8
	As many of the paint's properties will change if too thick coats are applied, it is not recommended that the product is applied to a film thickness that is more than double of the thickest recommended film.		
Practical spreading rate	The values depend on application technique, surface conditions, overspray, etc.		
Drying time, +23°C / 50 % RH (dry film thickness 100 µm)			
<ul style="list-style-type: none"> - dust dry (ISO 9117-3) - touch dry (DIN 53150) - dry to touch (ASTM D 1640) - dry to handle (ASTM D 1640) - through dry (ISO 9117-1) - forced drying conditions 	3 h 5 h 5 h 7 h 16 h 60°C – 1h (dry for further handling)		

Overcoatable, 50 % RH (dry film thickness 100 µm) with itself			
	Surface temperature	min.	max.
	+23°C	After 16 h	After 7 days
	+60°C	After 1 h	After 7 days
	The given values of drying time and overcoatability can change due to film thickness and drying conditions.		
Diluent / thinner	TEKNOSOLV 6720 (typically not necessary, otherwise contact our technical department)		
Cleaning of equipment	TEKNOSOLV 6720		
Gloss	glossy		
Colour shades	Red brown		
SAFETY MARKINGS	See Material safety data sheet		
DIRECTION FOR USE			
Surface preparation	<p>Remove from the surface any contaminants that might be detrimental to surface preparation and coating. Remove also water-soluble salts by using appropriate methods. The surface should be prepared as follows:</p> <p>STEEL SURFACES: remove mill scale and rust by abrasive blast cleaning to preparation grade Sa 2 ½ according to ISO 8501-1.</p> <p>Surface profile shall preferably correspond to $R_z = 25-60 \mu\text{m}$ or according to specification.</p> <p>The place and time of the preparation are to be chosen so that the prepared surface will not get dirty or damp before the subsequent treatment.</p>		
Mixing of the components	<p>Take into consideration the pot life of the mixture when estimating the amount to be mixed at a time. Before painting the base and hardener are mixed in right proportion. Stir thoroughly down to the bottom of the vessel. Inadequate stirring or incorrect mixing ratio results in imperfect curing and impaired film properties.</p> <p>For this coating system we recommend the usage of dual-feed, hot airless equipment. Please also consider appropriate cleaning intervals.</p>		
Application conditions	<p>The surface to be painted must be dry and the relative air humidity below 80%. During the application and drying period the temperature of the ambient air and the surface shall be at least above 10°C and the temperature of the paint must be at least 3°C above the dew point of the ambient air.</p>		
Application	<p>Before use stir the paint thoroughly.</p> <p>Apply preferably by airless spraying as only this method provides the recommended film thickness in a single operation. Use airless spray nozzle 0,015-0,031 inch. Brush can be used for touching up and small areas.</p> <p>Alternatively TEKNOPOX REPAIR 3296 can be used for spot-repair.</p> <p>Wash the painting equipment with TEKNOSOLV 6720 immediately after use.</p> <p>For details please request the "Application recommendation TEKNOPOX 3297-00"</p>		
ADDITIONAL INFORMATION	<p>The storage stability is shown on the label. Store in a cool place and in a tightly closed can.</p>		

The information on this data sheet is normative and based on laboratory tests and practical experience. Teknos guarantees that the product quality conforms to our quality system. Teknos accepts, however, no liability for the actual application work, as this is to a great extent dependent on the conditions during handling and application. Teknos accepts no liability for any damage resulting from misapplication of the product. This product is intended for professional use only. This implies that the user possesses sufficient knowledge for using the product correctly with regard to technical and working safety aspects. The latest version of Teknos data sheets, material safety data sheets and system sheets are on our homepage www.teknos.com.