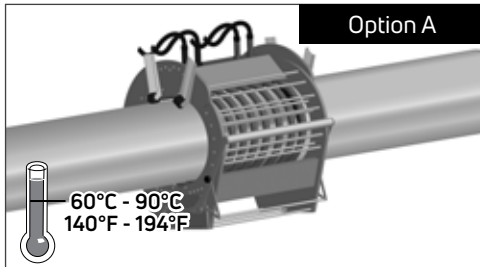


HBE-HT

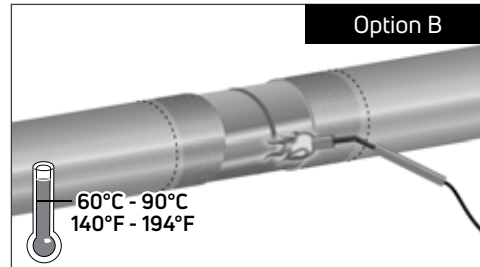
Expediting the Epoxy Cure Schedule

Expediting the epoxy cure schedule can be accomplished by pre-heating the substrate or post-heating the epoxy coating or a combination of both methods. Employing one or both methods can achieve a cured coating (>70 Shore D) within 30 minutes (back-fill ready). It is encouraged to force cure HBE-HT when possible and highly recommended to force cure HBE-HT when operating temperatures are above 100°C (212°F).

Pre-Heat

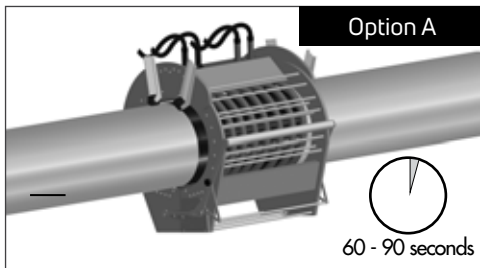


Pre-heat the pipe (by induction or torch or hot air gun) to temperatures of 60°C - 90°C (140°F -194°F).



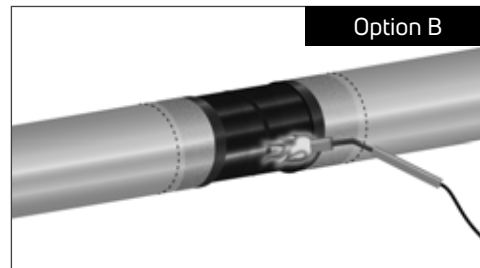
Pre-heat the pipe by torch or hot air tool to temperatures of 60°C - 90°C (140°F -194°F).

Post-Heat



Force curing of the localized HBE-HT coating can be achieved by induction coil. Generator power should be calibrated such that steel temperature rises to 100-110°C in 60 - 90 seconds.

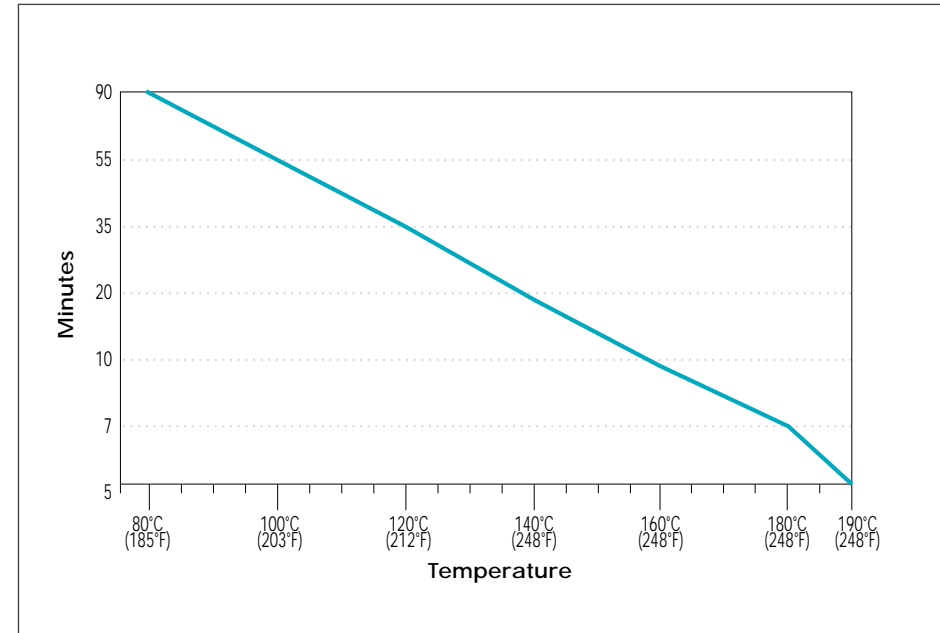
Allow the applied HBE-HT to cure for approximately 20 minutes to a gelled (tacky) state. Once a gelled state is achieved, heat the joint area to 90 - 100°C (194 - 212°F) by checking temperature on the adjacent coating. Shut the coil off for 60 seconds and hold temperature. After holding temperature for a minimum 60 seconds, continue to heat the joint area to 120 - 130°C (248 - 266°F). After holding temperature for a minimum 60 seconds, continue to heat the joint area to 160-170°C (320 - 338°F). After holding temperature for a minimum 60 seconds, continue to heat the joint area to 190°C (374°F).



Force curing of the localized HBE coating can be achieved by propane torch (low - moderate flame intensity), or hot air tool.

Dynamically heat the coating. Routinely use dry-to-touch coating checks for cure completion. Shore D Hardness testing should result in a value >70 after post-heating methods.

Cure Schedule- Time to Shore D 70



For HBE-HT force cure methods, please refer to the typical force cure schedule above.

Applications



FBE Repair & Rehab



Girth-Weld Joints

95°C Corrosion Protection		150°C Corrosion Protection		120°C Corrosion Protection for Force Curing Offshore		95°C Corrosion Protection for High Flex Applications		Pneumatic Spray Dispenser Method	Repair Applications for FBE and HBE
HBE-95		HBE-HT		HBE-OS		HBE-FLX		HBE-Atomizer Cartridge	HBE-REPAIR Cartridge (400mL)
Brush Grade	Spray Grade	Brush Grade	Spray Grade	Brush Grade	Spray Grade	Brush Grade	Spray Grade	Spray Grade	Brush Grade
Fast Cure (WG)	Fast Cure (SG)	Regular (slow) Cure		Fast Cure	Fast Cure	Fast Cure	Fast Cure	Fast Cure	Fast Cure
Medium Cure (XG)									
Slow Cure (RG)									
Kit Sizes	Bulk	Kit Sizes	Bulk	Kit Sizes	Bulk	Kit Sizes	Bulk	HBE-Atomizer Gun	400mL Cartridge Kit
0.5L	19L	0.5L	19L	0.5L	19L	0.5L	19L	HBE-Atomizer Mixing Tip	
1.0L	200L	1.0L	200L	1.0L	200L	1.0L	200L	HBE-95 Atomizer Cartridge (1.0L)	
1.5L		1.5L		1.5L		1.5L		HBE-OS Atomizer (1.0L)	
2.0L		2.0L		2.0L		2.0L		HBE-HT Atomizer (1.0L)	

Since 1967, Canusa-CPS has been a leading developer and manufacturer of specialty pipeline coatings for the sealing and corrosion protection of pipeline joints and other substrates. Canusa-CPS high performance products are manufactured to the highest quality standards and are available in a number of configurations to accommodate many specific project applications.

The technical information shown here is intended as a guide for standard products.

Consult your Canusa representative for specific projects or unique applications.

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system registered to
ISO 9001**

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TB_HBE-HT Expedited Cure_rev010