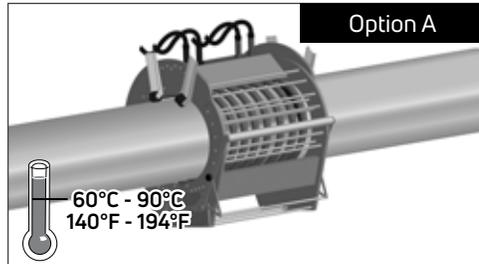


HBE-HT

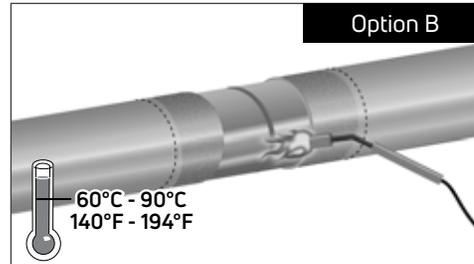
Expediting the Epoxy Cure Schedule

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

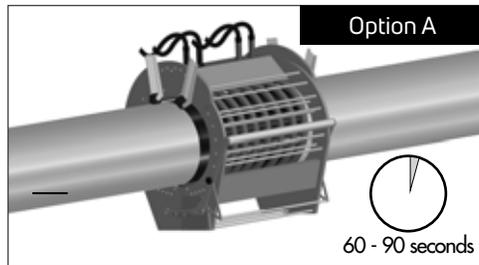


Pre-heat the pipe (by induction or torch or hot air gun) to temperatures of 60°C - 90°C (140°F -194°F).



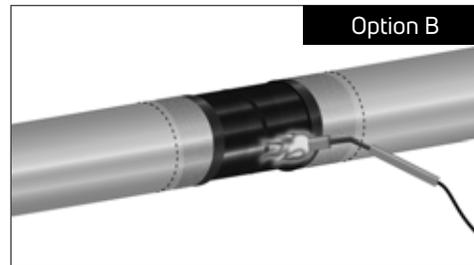
Pre-heat the pipe by torch or hot air tool to temperatures of 60°C - 90°C (140°F -194°F).

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.

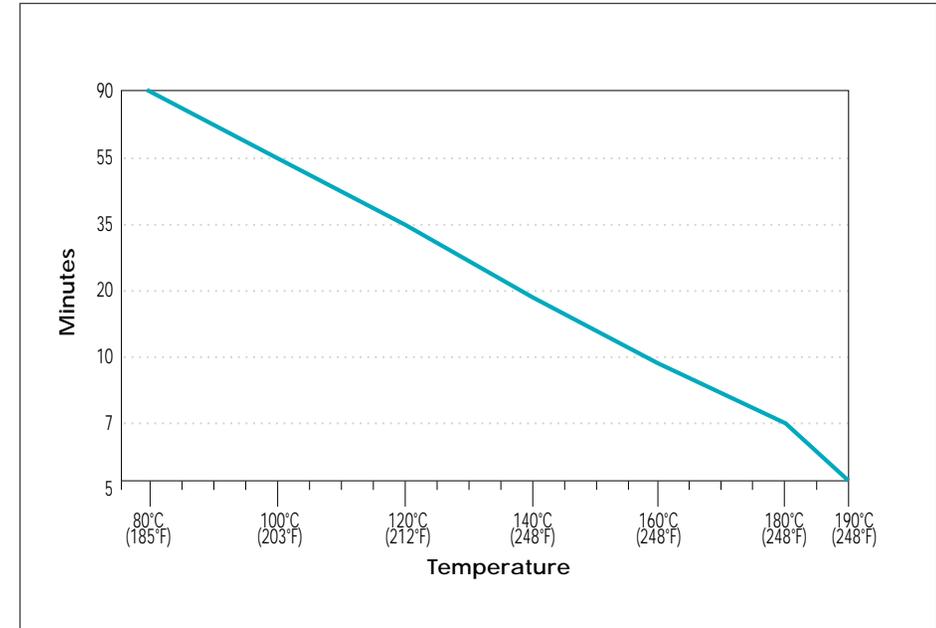
Allow the applied HBE-HT to cure for approximately 20 minutes to a gelled (tacky) state. Once a gelled state is achieved, heat the joint area to 90 - 100°C (194 - 212°F) by checking temperature on the adjacent coating. Shut the coil off for 60 seconds and hold temperature. After holding temperature for 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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ISO 9001**

Canusa warrants that the product conforms to its chemical and physical description and is appropriate for the use stated on the installation guide when used in compliance with Canusa's written instructions. Since many installation factors are beyond our control, the user shall determine the suitability of the products for the intended use and assume all risks and liabilities in connection therewith. Canusa's liability is stated in the standard terms and conditions of sale. Canusa makes no other warranty either expressed or implied. All information contained in this technical bulletin is to be used as a guide and is subject to change without notice. This technical bulletin supersedes all previous technical bulletins on this product. E&OE

TB_HBE-HT Expedited Cure_rev010