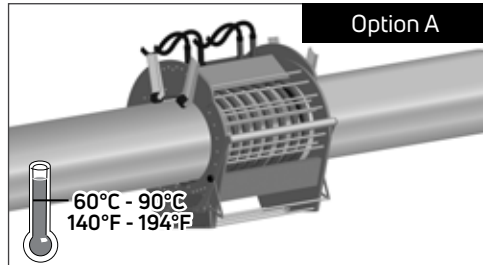


HBE

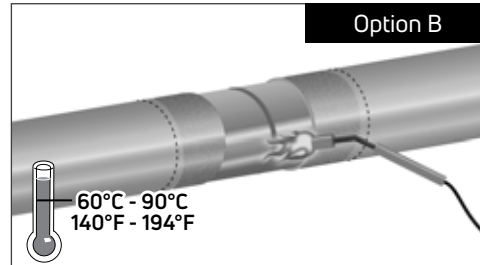
Expediting the Epoxy Cure Schedule

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) in 5 - 10 minutes (back-fill ready).

Pre-Heat

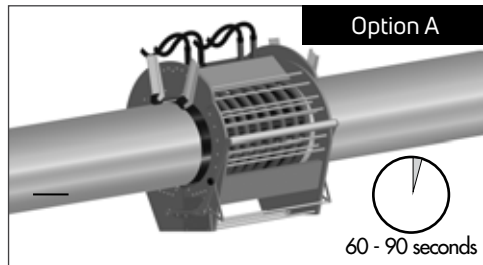


Pre-heat the pipe (by induction or torch or hot air gun) to temperatures of 60°C - 90°C (140°F - 194°F).



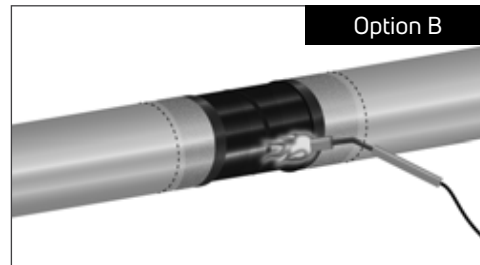
Pre-heat the pipe by torch or hot air tool to temperatures of 60°C - 90°C (140°F - 194°F).

Post-Heat



Force curing of the localized HBE 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.

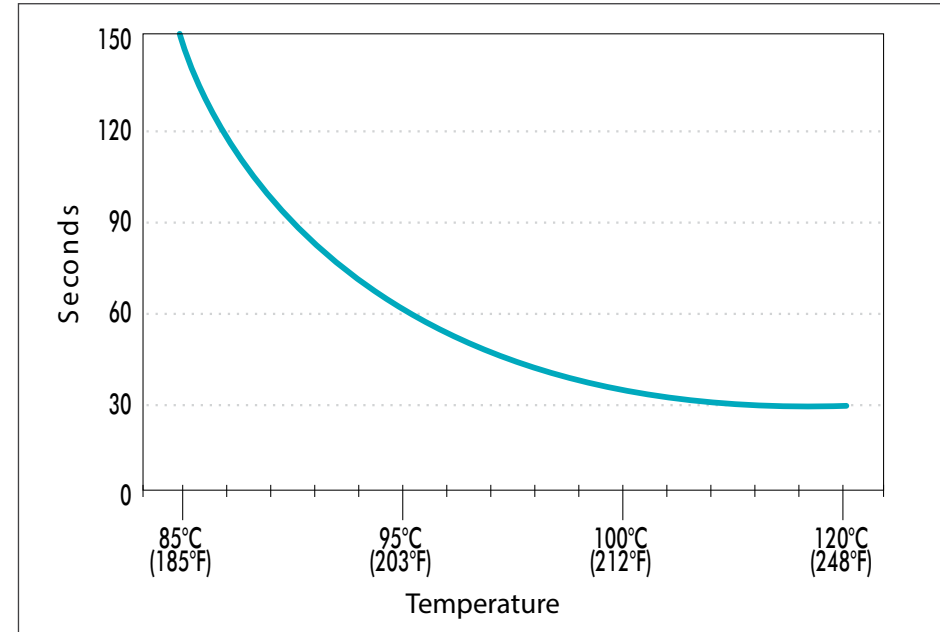
Heat the joint area to 100°C - 110°C (212°F - 230°F) by checking temperature on the adjacent coating. Shut the coil off for 60 seconds and hold temperature. After holding temperature for a minimum 60 seconds, continue to heat the joint area to 140 - 150°C (284°F - 302°F).



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



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

Applications



FBE Repair & Rehab



Girth-Weld Joints

Note: Expediting the cure schedule, using the above methods, is acceptable for all Canusa HBE products except for HBE-HT operating above 100C. It is also recommended to wait for HBE-HT to reach a tacky state before Post-Heat.

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)	Slow Cure	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**

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 Expedited Cure_rev015