

# HBE Standard Cure Speed Options

Canusa-CPS offers the choice of three different cure speed options, FAST, MEDIUM and SLOW with brush grade kit sizes for HBE-95 liquid epoxy. Cure speed options present the applicator with pot-life flexibility and back-fill accommodation to serve the spectrum of construction temperatures.

In all cases, the Base component is common. The speed of the Cure component is altered without changing the epoxy chemistry. The goal is to balance Pot Life and Backfill Time, each of which vary with ambient and surface temperature changes.

**Table 1: Recommended HBE-95 Pot Life at Various Ambient Temperatures**

The shaded areas indicate the grade and temperature conditions that are workable for most construction crews – generally 7-16 minutes.

Kit Description (0.5, 1.0 & 1.5L kits)	Approximate Pot Life in minutes		
	10°C (50°F)	24°C (75°F)	38°C (100°F)
HBE-95 RG SLOW CURE	33	16	7
HBE-95 XG MEDIUM CURE	15	11	4
HBE-95 WG FAST CURE	7	4	< 2

**Table 2: Approximate Times for HBE-95 to Reach 75 Shore D Hardness**

Table 2 is estimated Backfill Time in colder temperatures, which equates to time required for HBE-95 to achieve a Shore D hardness of at least 75. This is dependent on substrate temperature during and after application.

Kit Description (0.5, 1.0 & 1.5L kits)	Approximate time to reach 75 Shore D (hours)	
	5°C (40°F)	10°C (50°F)
HBE-95 RG SLOW CURE	> 24	> 18
HBE-95 XG MEDIUM CURE	12 - 16	< 12
HBE-95 WG FAST CURE	< 12	< 12

## Summary

Seasonally, crews face a variety of construction temperatures. Typically, coating application is done early afternoon following a morning of excavating, grit-blasting and corrosion measurement & analysis. In this scenario, backfilling occurs the following day. Therefore as a field use guideline:

- Use HBE-95 RG SLOW CURE – when the ambient temperatures are above 15°C (60°F)
- Use HBE-95 XG MEDIUM CURE – when the ambient temperatures are in the 7 - 18°C (45 - 65°F) range
- Use HBE-95 WG FAST CURE – when the ambient temperatures are below 10°C (50°F)

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.

### Canada

SFL Canusa Canada  
333 Bay Street, Suite 2400  
Toronto ON M5H 2T6, Canada  
info@canusacps.com

### USA

3813A Helios Way, Suite 900  
Pflugerville, TX 78660  
info@canusacps.com

### Europe

Elskensakker 8  
5571 SK Bergeijk  
The Netherlands (NL)  
Tel: +31 497 54 25 27

### Middle East

Plot # 37-WR43, Sector no.: ICAD III  
Musaffah South, PO Box 2621  
Abu Dhabi, United Arab Emirates  
Tel: +971 (2) 204 9800

### Quality Management system registered to ISO 9001

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