



Technical Data

Valspar General Industrial
 1136 Fayette Street
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Valspar Pipeclad Phenolic Primer HXR0015

The Valspar Pipeclad Phenolic Primer HXR0015 (heat cure primer) is engineered to be applied as a universal primer on steel surfaces for interior pipeline coatings. It is compatible with fusion bonded epoxy (FBE) powder coatings, phenolic and phenolic/epoxy liquid coatings for applications on drill pipe, lined pipe and downhole tubing.

Specifications	
Density	9.18-9.58 lbs/gal (1.1-1.15 kg/liter)
Solids by weight (% NVM)	41.5-51.5 %
Volatile Organic Compound (VOC)	4.5-5.5 lbs/gal (0.54-0.66 kg/liter)
Viscosity(#1 Signature Cup @ 77° F)	25-30 Seconds

Additional Information	
Color	Red
Component	One
Coverage (assuming no loss)	One gallon of mixed material will cover 425.31 square feet / 39.51 square meters of smooth surface at 1 mils/25 microns dry film thickness with no allowance for loss or waste.
Safety	See MSDS and product label.
Storage	Container should be stored between 50°F/10°C and 90°F/32°C
Shelf Life	12 months

Application Information	
Application	Spray application
Substrate	Surfaces should be clean, dry, and free from dirt, rust, grease, oil, or other contaminants. The steel should be blasted to produce 1.5-4 mil / 37.5-100 microns profile, preferable 2-2.5 mil/50-62.5 microns.
Surface Temperature	Minimum 50°F/10°C, Maximum: 100°F/38°C
Recommended Dry Film Thickness	0.5 to 1 mil/12.5 to 25 microns

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Mixing	Stir product before application to ensure no pigment remains on the bottom of the container.
Thinning	If reduction is required use Methanol. Do not use more than 10% reduction without consulting Valspar sales representative.
Suggested Cure Schedule	The primer can be force dry at minimum metal temperature of 250° F/121°C for 15 minutes. For subsequent coatings, see manufacturer's recommendations for application and additional cure schedules.
Cleanup	Equipment should be cleaned before the product dries. Clean up with Methanol or Butyl Cellosolve.