



Nap-Gard® PCW601S9

UV Protection for FBE

Revised: 5 October 2022

DESCRIPTION

Nap-Gard® Sol-Gard Product No. PCW601S9 is a fast curing thermosetting polyester powder designed as a UV protection coating for Nap-Gard® single layer FBE or dual powder system. In above ground service, the coating is capable of protecting the FBE coating from UV deterioration. Nap-Gard® PCW601S9 is not intended as a corrosion protection coating and should only be used in conjunction with Nap-Gard® corrosion protection series.

TYPICAL POWDER PROPERTIES

Color:	White	Theoretical Coverage:	121 Ft ² /lb/mil
Specific Gravity:	1.59 ± .05	Typical Gel Time: @ 205°C (401°F) CSA	28 ± 6 Sec.
Density: CSA Z245.20-22	1590 ± 50 g/L	Shelf Life @ 25°C (77°F): @50% RH	12 months
Thermal Characteristics: CSA Z245.20-22	T _{g1} = 52 ± 5°C T _{g2} = 70 ± 5°C Δ H = 20 ± 5 (J/g)		

TYPICAL PROPERTIES OF APPLIED FILM*

Recommended Film Thickness:	75-100µm (3-4 mils) Average	DSC – glass transition temperature CSA Z245.20-22	T _{g3} = 72°C (162°F)
Impact Resistance: CSA-Z245.20-22	@-30°C (-22°F) >3.0J Pass	Hardness: Barcol, ASTM D2583 Shore D, ASTM D2240	65 avg 82 avg.
Bending CSA-Z245.20-22	@-30°C (-22°F) 2.0°/PD Pass		
Hot Water Resistance CSA Z245.20-22: 75°C, 24 hr.	1 - 2	Rating Pass	Salt Spray: ASTM B117 (1000hrs)
			Rating Pass

*All were prepared with 12-16 mils of basecoat and 3-4 mils of topcoat.

GENERAL APPLICATION PARAMETERS

Cleanliness:	Near White (NACE #2) or Swedish Standard Sa 2½.
Profile:	Grit blast to angular profile 50 µm (2.0 mils) to 112 µm (4.5 mils)
Application:	Preheat pipe to 232°C to 253°C (450°F to 488°F)
Repair:	Repair with Axalta approved material.

Apply Nap-Gard® single layer FBE or dual powder system followed by Nap-Gard® Sol-Gard (PCW601S9) using electrostatic spray or flocking application. Water quench after allowing sufficient time for proper cure.** For line pipe, apply PCW601S9 in-line before base coat has gelled. Base coat must be at or above 425°F to apply PCW601S9. The use of a separate reclaim system is required. Coating of girth welds and fitting – see separate application guideline recommendations. The minimum post application curing temperature (as measured on the coated pipe), and the time to quench may conform to the following cure schedule

Application Temperature	Min Time to Quench
220°C (428°F)	210 seconds
232°C (450°F)	120 seconds
239°C (463°F)	90 seconds

CAUTION Time to quench will vary with application parameters and pipe sizes. *Therefore, cure should be verified by DSC or other methods.*