**SUPERIOR PRODUCTS INTERNATIONAL II, INC.**

# HOT PIPE COATING

**APPLICATION INSTRUCTIONS** (8/4/06)

*Hot Pipe Coating is a one-part, water-based design with seven ceramics blended into a heavy-bodied coating that can be used to coat behind the firebrick on the interior walls of furnaces and boilers facing the brick to block the loss of heat in areas up to 2,000F. degrees, and as an insulation system over existing and operating hot pipes, tanks, elbows and values. Hot Pipe Coating can be applied to metal, concrete, masonry and wood.*

## SURFACE PREPARATION

New construction or previously coated (metal, concrete, masonry and wood):

1) Power wash surface (3,500 psi) to remove loose or flaking paint and rust, and to clean the surface of dirt, oil, tar, grease and film.
2) Surface must be completely dry.
3) If existing coating surface is glossed, it must be sanded and roughed before application, no gloss.

## MIXING

1) When a container is opened, it will appear to be dry.
2) Mix with a drill and a 6" diameter dispersion blade at low or medium speed for two minutes to loosen up product and begin for 5-gallon pails.
3) Coating should appear like a thick whipped cream with no lumps once it has been blended. If it still appears to be dry, begin to add water while continuing to mix.
4) Up to one quart of water may need to be added to get to the desired consistency.

NOTE: See attached question and answers that will more clearly explain this mixing process. Pictures have also been added to clearly show the consistency required.

## POT LIFE

Two hours at 70F. degrees if container is left open.

## APPLICATION

Hot Pipe Coating was designed to be applied by spray:

1) If application is by spray, the preferred machine is the Graco Texspray RTX 1500 or a hopper gun with air control.
2) HOT APPLICATIONS--If application is directly to hot pipes (pipe surface temperature of 600F. degrees or less; if over 600F. degrees, contact the manufacturer for exact application instructions), first apply a thin coat (fifty mils wet) to act as a primer. Allow to set-up for five minutes, then apply additional coats as necessary to build to the required thickness.
3) AMBIENT APPLICATIONS--If application is directly on dry, non-operating pipes, since the surface is not hot and no problem of trapping steam bubbles in the coating film, the entire thickness desired can be applied in a single coat, according to hang allowance. Allow the final coat to set up for eight hours before heat is returned to the pipe. Two hours for each 200 mil coat applied; drying can be enhanced by introduction of heat.
4) If exterior application is done, Hot Pipe Coating should be overcoated with Super Therm or Enamo Grip WB for UV protection and weathering.
5) In all hot applications, Hot Pipe Coating is best applied in multiple coats (build-up coats).
6) For cold applications, never apply to pipes that are condensating or will be back in operation within thirty days when condensation is the problem.

## CURE TIME

1) Twelve hours to touch at 70F. degrees.
2) The overcoat window on dry, non-operating pipes is eight hours at 70F. degrees or longer.
3) Fully cures in thirty days with heat added to speed dry down.

NOTE: The overcoat window on hot pipes is five minutes over hot surfaces. The overcoat window on dry, non-operating pipes is eight hours as an overcoat for HPC.

## TEMPERATURE

1) Apply between 50F. and 100F. degrees.
2) Store between 40F. and 100F. degrees.

## CLEAN-UP OF EQUIPMENT

1) Spray equipment should be flushed and cleaned with soap and water.