Nap-Gard®

7-0015 Tan Internal Pipe Coating FBE

DESCRIPTION
Nap-Gard® 7-0015 is a fusion bonded epoxy powder designed to provide reliable corrosion protection in severe down hole environments. Nap-Gard 7-0015 is formulated to provide an excellent flexibility and reliable corrosion protection for different line pipes and pumps. Nap-Gard 7-0015 is generally recommended for use over a phenolic primer (Nap-Gard 7-1808 Red Phenolic Liquid Primer)†.

TYPICAL POWDER PROPERTIES

<table>
<thead>
<tr>
<th>Color:</th>
<th>Tan</th>
</tr>
</thead>
<tbody>
<tr>
<td>Specific Gravity:</td>
<td>1.60 ± 0.05</td>
</tr>
<tr>
<td>Typical Gel Time:</td>
<td>48 ± 10 seconds</td>
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</tbody>
</table>

Theoretical Coverage: 120 Ft²/lb./mil
Density: CSA Z245.20-14 1600 ± 50 g/L
Sheel Life: Below 25°C (77°F) and 50% RH

TYPICAL PROPERTIES OF APPLIED FILM††

Recommended Film Thickness
Average 500μm (20 mils)
Minimum 250μm (10 mils)

Glass Transition Temperature (Tg3) ≥110°C (230°F)
DSC

TEST / REQUIREMENT METHOD CRITERIA RESULT

Bending CSA Z245.20-14 >5.8°/dia. Length @25°C Pass
Hardness ASTM D2583 Barcol 69 Average
ASTM D2240 Shore D 90 Average
Taber Abrasion ASTM D4060 C17 wheel, 1Kg, 1000 Cycles 48 mg removal

AUTOCLAVE TESTING (Saudi Aramco 09-SAMSS-091)

Wet, Sour Gas or Crude Service
Gas Phase: 3% H₂S, 3% CO₂, 94% CH₄
Temperature: 95°C (203°F)
Pressure: 3000 psi
Duration: 24 Hrs.
Results: Pass all phases, No blisters, No cracking, No adhesion loss, No delamination

Aqueous Phase
Formation water brine

Wasia Water Service
Gas Phase: 100% CO₂
Temperature: 95°C (203°F)
Pressure: 3000 psi
Duration: 24 Hrs.
Results: Pass all phases, No blisters, No cracking, No adhesion loss, No delamination

AXALTA COATING SYSTEMS

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**RECOMMENDED APPLICATION PARAMETERS**

<table>
<thead>
<tr>
<th>Surface Preparation</th>
<th>NACE</th>
<th>#1 White Metal</th>
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</thead>
<tbody>
<tr>
<td>SSPC</td>
<td>SP-5</td>
<td></td>
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<tr>
<td>Swedish Standard</td>
<td>Sa 3</td>
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</table>

**Anchor Profile**  
Recommended Range  
Nominal  
1.5 mils (38μm) - 3.5 mils (89μm)  
2.5 mils (64μm), sharp, dense

**Liquid Phenolic Primer**  
Recommended Range  
0.5 mils (13μm) - 1.0 mils (25μm)

**Dry Film Thickness**  
Recommended Range  
10 mils (250μm) - 20 mils (500μm)

**Cured Powder Film Thickness**  
Recommended Range  
375°F (191°C) - 425°F (218°C)

**Preheat Temperature**  
Recommended Part Surface Temperature Range  
375°F (191°C) – 20 min  
400°F (205°C) – 12 min  
425°F (218°C) – 9 min

**Cure Schedule**  
Recommended Oven Temperature  
Time Required for Full Cure  
375°F (191°C) – 20 min  
400°F (205°C) – 12 min  
425°F (218°C) – 9 min

**TRANSPORTATION AND STORAGE**

The material is stable during transportation and storage at temperatures below 25°C (77°F) and 50% RH.