



Ductile Iron H₂Sewer Safe® Pipe

SewperCoat® Lined

Epoxy Repair of Field Cut Ends

Epoxy Mixing Directions

Mix equal parts of Part A and Part B.

Stir thoroughly and apply according to instructions indicated below.

Mixed epoxy (Parts A and B) should be used within the following temperature/time parameters.

<u>Temperature</u>	<u>Time</u>
50°F	3 hrs.
60°F	2 - 2½ hrs.
75°F	1½ hrs.
100°F	45 - 60 min.

Epoxy Coating Instructions

After the pipe is cut and beveled, all sharp edges should be removed from spigot. For a length of 4" from the spigot, the pipe O.D. should be wire-brushed to remove the bituminous coating. Apply a 4 - 5 mil thick coat of Tnemec Series 61-D1182 black epoxy with a good quality paint brush. The outside and end of the spigot should be covered. The inside cement surface of the spigot should not be covered with epoxy. When the epoxy is tack-free, a second coat should be applied. The epoxy should cure for at least one hour prior to jointing the pipe.

If the ambient temperature is less than 60°F, we recommend uniformly heating the spigot end of the pipe with a propane shrink wrap gun to approximately 130°F (over-heating will blister the sealcoat). The epoxy should be at room temperature, then apply the first coat of epoxy as explained above. When tack-free, and without subsequent reheating, apply the second coat.

H₂Sewer Safe® is a trademark of Griffin Pipe Products Co.
SewperCoat® is a registered trademark of Lafarge Calcium Aluminates

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