

RAPID 3300

Technical Data Sheet

Fast Cure High Build Pipeline Coating

PROPERTIES	VALUE
Solids Content	100%
Mixed Material - (Mixed) @ 77°F (25°C)	
Specific Gravity	1,63
Viscosity	170,000 cps
Color	Green
Mixing Ratio (A/B) by Volume	3 Parts Base: 1 Part Hardener
Cure Times	
Pot Life @ 77°F (25°C)	14 - 17 Minutes
Pot Life @ 97°F (36°C)	7 - 8 Minutes
Handling Time @ 77°F (25°C) Shore D 70 min.	2.5 - 3 Hours
Handling Time @ 117°F (47°C) Shore D 70 min.	1 Hour
Handling Time @ 157°F (69°C) Shore D 70 min.	20 Minutes
Recoat Window	
@ 57°F (14°C)	5 Hours
@ 77°F (25°C)	2 Hours
@ 97°F (36°C)	1 Hour
Theoretical Coverage	14 ft ² (1.3 m ²)/30 mils/liter
Thickness - Weld Joints / FBE Repairs	
Minimum/Maximum	20/70 mils (508/1778 microns)
Recommended	25 - 30 mils (635 - 762 microns)
Thickness - Bore Pipe	
Minimum/Maximum	40/70 mils (1016/1778 microns)
Recommended	45 - 60 mils (1143 - 1524 microns)
Holiday Detection	Refer to NACE SPO188
Cathodic Disbondment Test (ASTM G95)	
28 Days @ 77°F (25°C)	3 mm
28 Days @ 150°F (65°C)	4 mm
28 Days @ 185°F (85°C)	6 mm
28 Days @ 203°F (95°C)	6 mm
Hardness (ASTM D-2240-02)	Shore D 80+
Impact Resistance (ASTM G14-04) @ 32°F (0°C)	70.6 in-lbs.
Tabor Abrasion (ASTM 4060-07)	
-1000 cycles, CS-17 wheels, 1000 g. load	1,270 cycles per mil (93 mg)
-5000 cycles, CS-17 wheels, 1000 g. load	1,612 cycles per mil (338 mg)
Gouge Resistance (Partech Test - 40 kg load)	15.4 mils (391 microns)
Dielectric Strength (ASTM D-149)	450 V/mil (17,716 V/mm)
Adhesion to Steel (ASTM D-4541-02)	3,956 psi (27.3 MPa)
Adhesion to FBE (ASTM D-4541-02)	2,579 psi (17.8 MPa)
Service Temperature	-40°F to 203°F (-40°C to 95°C)
Application Temperature	-30°F to 212°F (-34°C to 100°C)

Note: If temperature falls below 50°F (10°C), surface must be preheated and maintained throughout the cure process.

STORAGE: Minimum 24 months when stored in original containers @ 40°F (4°C) to 105°F (41°C). On job site where temperatures are below 50°F (10°C) product should be kept warm to mix properly (65°F to 85°F optimal).

CLEANING: Clean equipment with Xylene, MEK, Acetone or equivalent solvent cleaner.

HEALTH AND SAFETY: Wear protective clothing and ensure adequate ventilation. Avoid contact with skin and eyes. See material safety data sheet for further information.

PACKAGING: 1, 1.5 and 2 liter kits and 75 liter & 800 liter kits standard. Dual cartridge repair tubes (50 ml, 400 ml & 1000 ml) and dispensing guns available for small repair areas.