



Nap-Gard®

7-0014

Multipurpose Fusion Bonded Epoxy

Revised: 19 September 2022

DESCRIPTION

Nap-Gard® 7-0014 is a thermosetting epoxy powder designed as a coating for both external and internal buried pipeline service. In particular, it is recommended for use on the inside of steel pipe which is in adverse temperature and pressure service and in contact with corrosive oils, gases and waters.

Nap-Gard® 7-0014 meets the requirements of AWWA standards C116, C213, C550 and CSA standard Z245.20-22.

Nap-Gard® 7-0014 has been certified to NSF/ANSI/CAN 61, drinking water system components.

For NSF applications, the maximum recommended film thickness is 20 mils.



TYPICAL POWDER PROPERTIES

Color:	Green	Theoretical Coverage:	130 Ft ² /lb/mil
Specific Gravity:	1.48 ± .05	Density:	1480 ± 50 g/L
		CSA Z245.20-22 (Section 12.6.2.3)	
Typical Gel Time:	100 ± 20 seconds	Shelf Life*:	12 months
CSA Z245.20-22 @ 204°C (401°F)		@ 25°C (77°F) @ 50% RH	
	65 ± 13 seconds		
TM # 10.210 @ 232°C (450°F)			

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

TYPICAL PROPERTIES OF APPLIED FILM*

Recommended Film Thickness		Average	10 – 20 mils 15 mils
TEST / REQUIREMENT	METHOD	CRITERIA	RESULT
Impact Resistance	ASTM G-14	1/4x4x4 panel @ 25°C 1/8x4x4 panel @ 25°C	50 Lb / in Pass 120 Lb / in Pass
	CSA Z245.20-22 @ -30°C (-22°F)	> 1.5 J	Pass
Bending	CSA Z245.20-22	@ -30° (-22°F) 3.0°/PD	Pass
Hot Water Resistance	CSA Z245.20-22	75°C, 24 hr	Rating 1-2, Pass
Taber Abrasion	ASTM D4060 C17 wheels, 1 Kg	1000 Cycles 5000 Cycles	40 mg weight loss 134 mg weight loss
Cathodic Disbondment	CSA Z245.20-22 24 hr., 3.5 V., 65°C (150°F) 28 days, 1.5 V., 23°C (77°F)	2 - 4 mm radius 3 - 5 mm radius	Pass Pass



	Strained C.D.	No Cracking	Pass
Shear Adhesion	ASTM D D1002	4677 psi	
Heat Distortion Resistance	CSA Z245.20-22 Clause 12.7	T _{g3} = 109.5°C (229°F)	
Penetration	ASTM G-17 (140°F/96hr)		<4.0%

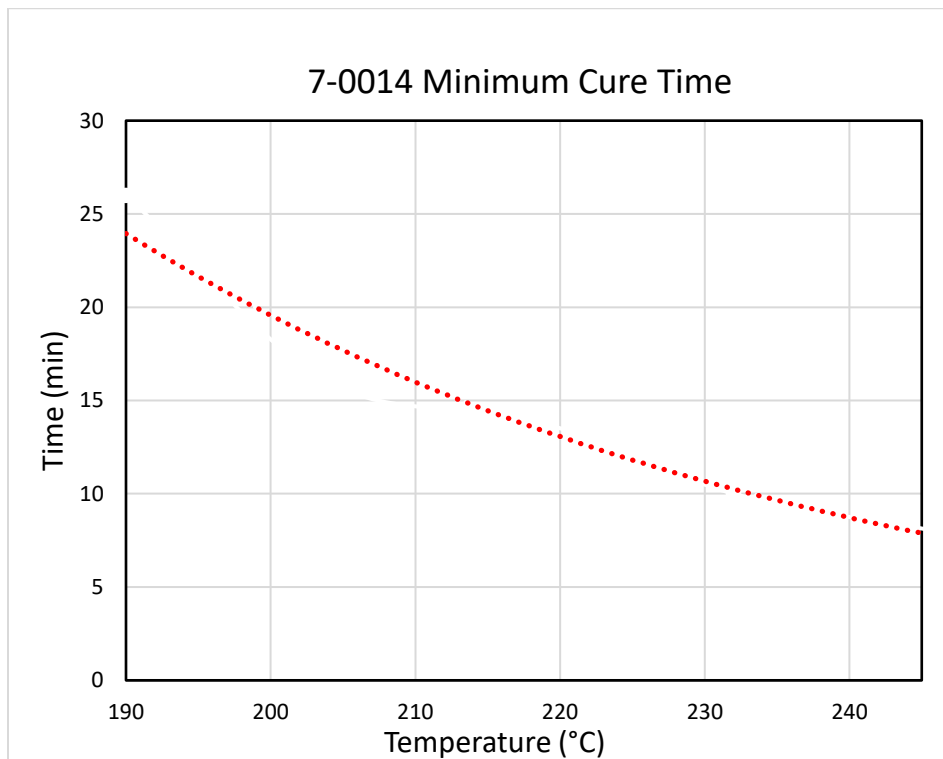
† Performance depends on film thickness. Consult Nap-Gard® Specialist for specific recommendations.

TYPICAL ELECTRICAL PROPERTIES OF FILM

Dielectric Strength:	1260 volts/mil	Volume Resistivity:	1.16×10 ¹⁵ ohm.cm
ASTM D149-97		ASTM D257 (23°C/50% RH)	

GENERAL APPLICATION PARAMETERS

- Grit blast to NACE Near-White specifications (Swedish Standard #Sa2½) and profile between 50µm (2 mils) and 112µm (4.5 mils).
- Use phosphoric acid/deionized water rinse if water soluble salt contamination is suspected.
- Preheat substrate to approximately 218°C (425°F) to 239°C (463°F)
- Apply Nap-Gard® 7-0014 powder to meet customer thickness specifications.
- Follow recommended cure schedule (see below).
- Cure should be verified by DSC or other methods.
- Electrically inspect for holidays. Repair with Nap-Gard® 7-1868.
- If girth welds are being coated, refer to Axalta's "Nap-Gard® Field Girth Weld Application Procedure."
- For NSF applications, a final cure of 20 minutes at 200°C or 13 minutes at 220°C may be used
- For minimum cure time, follow the chart below



Always consult product Safety Data Sheet (SDS) prior to handling.

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