

# Technical Data

## Proline System



### Product description

Proline System is an abrasion resistant, styrene free, glassflake reinforced polyester lining which gives a documented long service life time.

---

### Recommended use

Casting new pipes for drain and waste water pipes inside old pipes made of e.g. cast iron, plastic, concrete or ceramic material.

---

### Film thickness and spreading rate

	Minimum	Maximum	Typical
Film thickness, dry ( $\mu\text{m}$ )	600	1500	1000
Film thickness, wet ( $\mu\text{m}$ )	610	1530	1020
Theoretical spreading rate ( $\text{m}^2/\text{l}$ )	1,63	0,65	0,98

### Comments

The practical spreading rate may vary from the theoretical dependent upon layer thickness and the ambient temperature and ventilation during the application.

---

### Physical properties

Colour	Light grey
Solids (vol %)*	98 $\pm$ 1
Flash point	53°C $\pm$ 2 (Setaflash)
VOC	20 gms/ltr UK-PG6/23(97). Appendix 3
Gloss	Semiflat
Gloss retention	Good
Water resistance	Excellent
Abrasion resistance	Excellent
Solvent resistance	Very good
Chemical resistance	Very good
Flexibility	Limited
Compatibility with cathodic protection	Very good

\*Measured according to ISO 3233:1998 (E)

---

## Proline cleaning system

Please follow Proline cleaning instructions. The surface must be clean and dry.

## Surface preparation

The coating may be used on other substrates. Please contact your local Jotun office for more information.

---

## Condition during application

The temperature of the substrate should be minimum 5°C and at least 3°C above the dew point of the air, temperature and relative humidity measured in the vicinity of the substrate. Good ventilation is usually required in confined areas to ensure proper drying. The coating should not be exposed to oil, chemicals or mechanical stress until fully cured.

---

## Proline application method

Use Proline application method.

**Proline System**                      **min 3 x 900 - 1100 µm**      **(Dry layer thickness)**

## Application methods

**Spray**                      Preferably 2-comp. airless spray. Application with 1-comp. ordinary airless spray is also possible, provided that inhibitor is added.

---

## Application data

**Mixing**    1,25-2,5 vol.% Norpol Peroxide 13 at temperatures 5 - 35° C.  
**Pot life (23°C)**                                      15-20 minutes (Reduced at higher temperatures).

---

## Drying time

Drying times are generally related to air circulation, temperature, film thickness and number of coats, and will be affected correspondingly. The figures given in the table are typical with:

- \* Good ventilation (Outdoor exposure or free circulation of air)
- \* Typical film thickness
- \* One coat on top of inert substrate

<b>Substrate temperature</b>	<b>5°C</b>	<b>10°C</b>	<b>23°C</b>	<b>40°C</b>
<b>Surface dry</b>	2.5 h	2.5 h	45 min	45 min
<b>Cured</b>	3 d	2 d	12 h	4 h
<b>Dry to recoat, minimum</b>	2.5 h	2.5 h	45 min	45 min
<b>Dry to recoat, maximum <sup>1</sup></b>	14 d	14 d	14 d	14 d

1. The surface should be free from chalking and contamination prior to application.

The given data must be considered as guidelines only. The actual drying time/times before recoating may be shorter or longer, depending on film thickness, ventilation, humidity, underlying paint system, requirement for early handling and mechanical strength etc. A complete system can be described on a system sheet, where all parameters and special conditions could be included.

---

## Storage

The product must be stored below 25°C and in accordance with national regulations. Storage conditions are to keep the containers in a dry, cool, well ventilated space and away from source of heat and ignition. Containers must be kept tightly closed.

SHELF LIFE: 6 months, at 23°C, subject to re-inspection thereafter. Shelf life very much depends on temperature. Lower temperatures (if possible below freezing point) will lengthen the shelf life considerably, while high temperature may lead to gelling in the tin.

Peroxide must be kept in their original containers. No other materials shall be stored in the same room as peroxides. Always consult your local/national authorities for storing peroxides!

---

## Handling

Handle peroxide with care. Avoid that it comes in contact with flameable substances. Before handling, see safety data sheet for peroxide.

---

## Packing size

20 litre unit: 16 litres in a 20 litre container

---

## Health and safety

Please observe the precautionary notices displayed on the container. Use under well ventilated conditions. Do not breathe or inhale mist. Avoid skin contact. Spillage on the skin should immediately be removed with suitable cleanser, soap and water. Eyes should be well flushed with water and medical attention sought immediately.

**For detailed information on the health and safety hazards and precautions for use of this product, we refer to the Material Safety Data Sheet.**

---

### DISCLAIMER

The information in this data sheet is given to the best of our knowledge based on laboratory testing and practical experience. However, as the product can be used under conditions beyond our control, we can only guarantee the quality of the product itself. We also reserve the right to change the given data without notice. Minor product variations may be implemented in order to comply with local requirements.

If there is any inconsistency in the text the English (UK) version will prevail.

Jotun is a World Wide company with factories, sales offices and stocks in more than 50 countries. For your nearest local Jotun address please contact the nearest regional office or visit our website at [www.jotun.com](http://www.jotun.com)

ISSUED 13 MAY 2011 BY JOTUN  
THIS DATA SHEET SUPERSEDES THOSE PREVIOUSLY ISSUED