

Product Data Sheet

PHOEPOX® 2614

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January 2020



Phoepox® 2614

Is an enhanced fusion bonded epoxy powder that is designed as an impact resistant middle layer for multi-layer FBE coating systems. Phoepox® 2614 possesses a combination of corrosion protection and impact-resistance properties.

Phoepox® 2614 is suitable for standard service temperatures and is applied at a recommended average thickness of 300 microns..

			Typical Value	Test Method / Device	
POWDER PROPERTIES	GEL TIME	at 180°C	65-80 sec	ISO 8130-6	
		at 200°C	35-45 sec	ISO 8130-6	
	THERMAL PROPERTY	Tg1		60 ± 5°C	
		Tg2		103 ± 5°C	
		ΔH		40-80 J/g	
	DENSITY			1.5 ± 0.1 g/cm ³	Gas Pycnometer
	PARTICLE SIZE			99.8% < 250 μm	Laser Scattering
MOISTURE CONTENT			≤ 0.5 %	CSA Z245.20-06	
	COLOR		Green or Blue		
PHYSICAL TESTS	CATHODIC DISBONDING * (OVER PHOEPOX® 3314)	1-3 mm at -3.5 VDC, 65°C, 24 hours		CSA Z245.20-06	
		3-5 mm at -1.5 VDC, 20°C, 28 days			
	ADHESION *	Rating 1 at 75°C, 24 hours		CSA Z245.20-06	
	FLEXIBILITY *	Pass, at 3°, -30°C		CSA Z245.20-06	
	WATER RESISTANCE	No blistering at 38°C, 15 weeks No blistering at 90°C, 5 weeks		ASTM D870	
ABRASION (TABER)	≤ 50 mg		ASTM D4060, 1000 g load, 1000 cycles, C10 wheels		



◀ corrosion protection that stays.

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STORAGE STABILITY

12 months from production date in
 $\leq 23^{\circ}\text{C}$ and $\leq 65\%$ relative humidity.
Cooler temperatures and lower
humidity are recommended.

* The performance will be affected by surface preparation and curing condition.

APPLICATION DATA

SUBSTRATE

FBE coated steel

SURFACE PREPARATION

Surface must be free from contamination and
blasted as defined by Swedish Sa 2½

RECOMMENDED FILM THICKNESS

200-400 μm

APPLICATION TEMPERATURE

215-240°C



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