

# Product Data Sheet

## PHOEPOX® 3388

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November 2016



### Phoepox® 3388

is a zinc-enriched fusion-bonded epoxy that can be used as a primer layer in multi-layer fusion bonded epoxy, three-layer polyethylene and three-layer polypropylene pipe and fitting coating systems. Phoepox 3388 provides excellent adhesion to steel surfaces and greatly enhances the overall integrity of any compatible pipe coating system. Phoepox 3388 is suitable for standard service temperatures

			Typical Value	Test Method / Device
<b>POWDER PROPERTIES</b>	<b>GEL TIME</b>	at 180°C	60-80 sec	ISO 8130-6
		at 200°C	30-45 sec	ISO 8130-6
	<b>THERMAL PROPERTY</b>	Tg1	60 ± 5°C	ISO 21809-2
		Tg2	105 ± 4°C	
		ΔH	40-80 J/g	
	<b>DENSITY</b>		1.65 ± 0.1 g/cm <sup>3</sup>	Gas Pycnometer
	<b>PARTICLE SIZE</b>		99.8% < 250 μm	Laser Scattering
<b>MOISTURE CONTENT</b>		≤ 0.5%	CSA Z245.20-06	
<b>COLOR</b>		Grey		
<b>PHYSICAL TESTS</b>	<b>CATHODIC DISBONDING *</b>	1-2,5 mm at -3.5VDC, 65°C, 24 hours 2-4 mm at -1.5 VDC, 20°C, 28 days		CSA Z245.20-06
	<b>ADHESION *</b>	Rating 1 at 75°C, 24 hours		CSA Z245.20-06
	<b>FLEXIBILITY *</b>	Pass, at 3°, -30°C		CSA Z245.20-06
	<b>STORES STABILITY</b>	12 months from production date in ≤ 23°C and ≤ 65% relative humidity. Cooler temperatures and lower humidity are recommended.		

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



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### APPLICATION DATA

#### SUBSTRATE

Mild steel

#### SURFACE PREPARATION

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

#### SURFACE ROUGHNESS

50-100 µm

#### RECOMMENDED FILM THICKNESS

50-250 µm

#### APPLICATION TEMPERATURE

215-240°C