

Product Data Sheet

PHOEPOX® 4480

1/2

November 2015



Phoepox® 4480

is a fusion bonded epoxy powder that is especially designed for the internal coating of drill pipes. Phoepox 4480 can withstand elevated temperatures and greatly enhances the longevity of drill pipes.

			Typical Value	Test Method / Device
POWDER PROPERTIES	GEL TIME	at 200°C	280±40 sec	ISO 8130-6
	THERMAL PROPERTY	Tg1	50± 5°C	ISO 21809-2
		Tg2	>185°C	
	DENSITY		1.6 ± 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	
PHYSICAL TESTS	WATER RESISTANCE	No blistering at 90°C, 15 weeks		ASTM D870
	IMPACT RESISTANCE	≥ 5J		ISO 21809-2
	Dry ADHESION TEST	Rate a		ISO 21809-2
	STORAGE STABILITY	6 months from production date in ≤ 23°C and ≤ 65% relative humidity. Cooler temperatures and lower humidity are recommended.		



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2/2



APPLICATION DATA

SUBSTRATE

Mild steel

SURFACE PREPARATION

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

SURFACE ROUGHNESS

45-100 µm

RECOMMENDED FILM THICKNESS

200-450 µm

APPLICATION TEMPERATURE

190-218°C

POST CURE CONDITIONS

225°C, 20 min