



CORROPIPE® II TX-15

TECHNICAL DATA

GENERAL PURPOSE PIPELINE COATING

THE PRODUCT AND ITS USES

CorroPipe II TX-15 has been used for the protection of the interior and exterior of steel, ductile iron and concrete pipe since 1981. CorroPipe II TX-15 is a pure polyurethane, combined with several performance enhancers, including Madison AquaNox, a hydrophobic additive especially effective in aqueous immersion. This 100% solids product is solvent-free, tar-free, and non-flammable.

This fast set, 1:1 ratio, two component product cures at virtually any ambient temperature to form a “structural” polyurethane film, hard yet resilient, which adheres tenaciously to any substrate. Several setting times are available from 30 seconds to 45 minutes.

CorroPipe II TX-15 (AM) is a modified version that contains Madison MicroSpear, an EPA registered Anti-Microbial agent. In septic environments, this reduces microbially-induced corrosion and in water service, it kills most microbes on contact, thus preventing bacterial growth on the pipe surface.

CorroPipe II TX-15 (CM) is a variation containing Madison NanoShield, a form of ceramic nanospheres that enhance the already high abrasion resistance of this product, making it ideal for highly abrasive or high flow applications and for greater impact resistance.

TECHNICAL INFORMATION

PROPERTY	TEST DESCRIPTION	RESULTS
Application Temperatures	N/A	-20°C(0°F) to 65°C (150°F)
Initial Setting Time	@20°C/70°F	3 choices (from 1 to 30 minutes)
Curing Time Before Handling	All temperatures	Three times initial setting time
Ultimate Cure	@20°C/70°F	7 days
Recoat Time*	@20°C/70°F	Within 45 minutes
Solids Content	ASTM D-1259	99±1%
Volatile Organic Compounds (VOC's)	ASTM D-2369	13 grams/litre (0.11 lbs/US gal)
Theoretical Coverage	N/A	1016 m ² /litre/micron; 1604 ft ² /USgallon/mil
Adhesion to Steel	ASTM D-4541 (SSPC 10)	Greater than 2,000 psi
Hardness	ASTM D-2240 Shore D	70 +/- 5
Flexibility	ASTM D-522	180°over 1" mandrel
Abrasion Resistance	ASTM D-4060 (CS-17 wheels, 1kg weights, 1000 revolutions)	75mg loss (standard version) 20 mg loss (CM version)
Resistance to Cathodic Disbondment	CSA Z-245 (65°C, 48 hours, 20mils)	Excellent; less than 12 mm radius
Colors		Contact a Madison Representative

*However, recoat window varies depending on the spray equipment temperature setting, the ambient conditions, product temperature/thickness and the temperature of the substrate being coated.

NOTE: All statements, technical information and recommendations contained herein are typical of results obtained under laboratory conditions and are not intended to be used as contract specifications. For specification guidelines please contact Madison Chemical. The information contained herein is believed to be accurate as of date of publication. Madison reserves the right to change product specifications without notice.

APPLICATION INSTRUCTIONS

CONTACT MADISON FOR DETAILED [APPLICATION INSTRUCTION BULLETIN](#) (ALSO AVAILABLE ONLINE).

A. SURFACE PREPARATION

- 1) Ensure that surface is clean, dry and uncontaminated. Proceed only if the substrate temperature is more than 3°C(5°F) above the dew point temperature during surface preparation and coating application.
- 2) Abrasive blast clean with angular media (sand, aluminum oxide, garnet or steel grit G40 or coarser). DO NOT USE steel shot or other non-angular products or slag-based media.
For **steel** surfaces, blast to a Near White Blast (SSPC-SP10; NACE 2; SA 2.5):
 - minimum 3.0 mil (75 microns) profile for immersion;
 - minimum 2.5 mil (65 microns) profile for buried / embedded service;
 - minimum 2.0 mil (50 microns) profile for atmospheric service.For **ductile iron** surfaces, abrasive blast to achieve a surface anchor profile of 2.5 mils or greater. Remove all rust and loose oxides.
For **concrete** surfaces, abrasive blast to remove laitance.
- 3) See Madison Application Instructions for details.

B. APPLICATION OF COATING

- 1) Roll or power agitate individual components thoroughly with an electric or air driven mixer to ensure homogeneity. Do not thin. Do not mix "A" and "B" together.
- 2) Spray apply coating using a plural component, 1:1 mix ratio, heated airless spray unit.
- 3) Unlimited film build can be obtained in a single coat, multi-pass application. For single pass lining application, spin the pipe.
- 4) A second coat may be applied over the first, as long as it is applied within the recoat window. Otherwise, it may be necessary to roughen the surface to ensure good intercoat adhesion.

C. CLEAN-UP AND STORAGE

- 1) This material will react with humidity and moisture. Keep containers tightly sealed and store upside down. For clean-up, use only Madison VR-1 Viscosity Reducer as any other reducer, whether from Madison or a third party will ruin the product.
- 2) Store between 10°C(50°F) and 27°C(80°F). DO NOT FREEZE. Use product within 6 months of receiving.

HEALTH AND SAFETY

CorroPipe II TX-15 is intended for industrial or professional use only. It contains no monomeric isocyanates but may nevertheless cause respiratory distress in some people. Provide ample ventilation in confined areas. Wear a NIOSH-approved cartridge-type face mask or a fresh air respirator in spray area. If swallowed, DO NOT induce vomiting as this will cause additional throat irritation; contact physician for instructions. Protect skin by wearing rubber gloves, safety goggles and protective clothing. If splashed on skin, remove immediately with a Madison Reducer (VR-1, VR-2 or VR-4) as product is very solvent resistant once it starts to polymerize (cure). If splashed in eyes, wash liberally with clean water and contact physician; temporary irritation of eyes may last several days. See MSDS for more information. The finished product is totally inert and harmless. Review [Application Instruction Bulletin](#) for additional safety information.

LIMITED TWO YEAR WARRANTIES

Madison will replace any product which, in service for which it is suitable, fails to meet specifications within two years of sale and which is proven to be defective when applied according to instructions by a Madison Approved Applicator or Certified OEM Applicator. Madison accepts no responsibility or liability for any other loss, claim, damage, injury or expense, direct or consequential, in contract or negligence. This product replacement warranty is in lieu of any other right, warranty, guarantee or condition, statutory or otherwise, expressed or implied, whether as to fitness for a particular purpose or as to merchantable quality or otherwise.

The information contained herein is believed to be accurate as of the date of publication. Madison reserves the right to change product specifications without notice.

NOTE: The following are Trademarks and/or Registered Trademarks of Madison Chemical Industries Inc.:
Madison Chemical, CorroPipe, AquaNox, MicroSpear, NanoShield and VR Reducers.

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