

POLYKEN[®] 954 HT

Product Information

Product description: The Polyken[®] 954-HT is a protective pipeline joint outer wrap that is used where a complete bond of outer wrap to tape is specified. The tough polyethylene backing provides excellent mechanical protection to anti-corrosion joint wraps. The high tack adhesive assures a complete bond and eliminates the need for tie-downs on the outer wrap. Polyken[®] 954-HT is designed for hand application over the primary joint wrap.

Features & Benefits:

- Proven long-term in-ground performance.
- High tack pressure-sensitive adhesive providing tight bond of outer wrap to inner wrap.
Easy hand application.

Product selection guide

Operating temperature	-34° to 85° C (-30° to 185° F)
Compatible inner wrap	Polyken [®] 900, 905, 930, 932, 934, 943, 980

Product construction

	954 HT
Backing	11 mils (0.28 mm)
Adhesive	4 mils (0.10 mm)
Backing color	White

Product properties

Property	Method	Typical values	
		954 HT	Units
Tensile Strength	ASTM D 1000	20 3.5	pli N/mm
Elongation	ASTM D 1000	200	%
Adhesion to backing	ASTM D 1000	2.8 0.5	pli N/mm

Equation for Pipe Coating Requirements

Squares of coating required** $\frac{(\text{width of coating in inches}) \times (\text{area of pipe in square feet})^*}{(\text{width of coating in inches} - \text{overlap in inches}) \times 100}$

* Area of pipe in ft² = (diameter in inches / 12) x 3.1416 x length in feet

** One Square = one hundred square feet = 9.29 square meters

Square meters of coating required $\frac{(\text{width of coating in mm}) \times (\text{area of pipe in square meter})^*}{(\text{width of coating in mm} - \text{overlap in mm})}$

* Area of pipe in m² = (diameter in mm / 1000) x 3.1416 x length in meter

Squares per roll** $\frac{(\text{width of roll in inches}) \times (\text{length of roll in feet})}{(12) \times (100)}$

Square meters Per roll $\frac{(\text{width of roll in mm}) \times (\text{length of roll in m})}{(304.8) \times (30.48)}$

Rolls Required $\frac{(\text{squares of coating required})}{(\text{squares per roll})}$

Rolls Required $\frac{(\text{square meters of coating required})}{(\text{square meters per roll})}$

Ordering information

Polyken[®] 954 HT Tape Coatings are available in roll form.

Example **954-15 HT WHI 2X100 4.1CM**

954 HT	Product type	Standard Ordering options
15	Total tape thickness in mils	15 mils (0.39 mm)
WHI	Tape backing color	White (WHI)
2	Tape width in inches	2" (50 mm), 4" (101 mm), 6" (152 mm)
100	Tape roll length in feet	100 ft (30 m)
4.1CM	Tape inner core diameter	1.6" (41 mm)

For other ordering options please contact your Seal For Life representative.

Application instruction: Job preparation	
Tools, equipment and auxiliaries	Temperature gauge, DFT/WFT gauge, Primer application equipment/agitator, Tape application equipment, Coating "hot box"
Additional coating materials	931 or 939 filler material, and Polyken® 900, 905, 930, 932, 934, 943, 980 anti corrosion layers
High humidity	Polyken® 954 HT can be applied in a humid atmosphere. The substrate should be free from condensing water which can be reached by keeping the temperature at least 3°C (37°F) above dew point.
Work area and substrate	The substrate surface should be dry, clean and protected against negative weather influences.
Product conditions	The Polyken® 954 HT shall be stored and/or transported in a dry, ventilated location. Storage temperature shall be a minimum of 15°C (59°F) and a maximum of 50°C (122°F). The minimum primer and roll body temperature for application will be 15°C (59°F).

Application instruction: Surface preparation	
General	The area to be coated has to be clean, dry, and free from oil, grease and dust. All contamination including mill-scale has to be removed.
Degreasing	Degrease surfaces with Toluene or Heptane and e.g. a lint-free cloth.
Preventing condensation of water	Prior to and during the application, the temperature of the substrate(s) must be at least 3°C (37°F) above the dew point.
Substrate temperature	Temperature of the substrate should preferably be between 10°C and 50°C (50°F / 122°F). Preheating may be required.

Application instruction: Brief version	
Step 1	Clean substrate to SSA-ST2, SSPC-SP3 (power wire brush) or SSA-SA 2, SSPC-SP6 (commercial blast). Surface (anchor) profile depth shall be no less than 1.0 mils (25 micron) and no greater than 3 mils (76 micron).
Step 2	Uniform primer application achieving 2 to 3 mil WFT. Primer should be "dry to touch" before application of inner layer.
Step 3	If required, apply weld seam coating or filler material

* For further detailed information, please view the corresponding Application Guideline *

Step 4	Apply the required anti corrosion layer with a 1% to 2% neckdown. Depending on the anti corrosion layer used; ensure the proper minimum overlap is obtained.
Step 5	Spirally apply the 954 HT outer layer (mechanical Protection) over the anti corrosion layer with a 1% to 2% neckdown and no less than a 1" overlap.
Step 6	Perform holiday detection per NACE SP0274

Handling and commissioning	
Exposure to loads	Objects coated with Polyken® 954 HT should not be exposed to loads e.g. from supports- or lifting equipment.
Backfill	Backfill is possible immediately after completion of the coating application. Consult application guidelines for specific instructions. Backfill should be clean and not contain any foreign items that can cause damage to the coating system.

Information	
Documentation	Extensive information is available on our website. Application instructions and other documentation can be obtained by contacting our offices, from our local distributor or by sending an email to info@sealforlife.com
Certified staff	Application of the described coating system should be carried out by certified personnel.



DISCLAIMER: Seal For Life Industries warrants that the product conforms to its chemical and physical description and is appropriate for the use stated on the technical data sheet when used in compliance with Seal For Life Industries' written instructions. Because many installation factors are beyond the control of Seal For Life Industries, the user shall determine the suitability of the products for the intended uses and assume all risks and liabilities in connection herewith. Seal For Life's liability is stated in its General Terms and Conditions of Sale. Seal For Life Industries makes no other warranty either express or implied. All information contained in this technical data sheet is to be used as a guide and is subject to change without notice. This technical data sheet supersedes all previous data sheets on this product. Seal For Life Industries is a registered marks of the Berry Global Group, Inc. or its affiliates.

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