

**Characteristics:** Fiber reinforced adhesive tape (RI) on rolls with double plastic release liner for pre-assembly.

**Applications:** Used in combination with joint casings of pre-insulated pipes

- Primary, durable sealing of non-welded shrinkable joint casing systems
- Additional, durable sealing of welded shrinkable joint casing systems

**Performance:** **Functionality and resistance** – tested and certified in accordance with EN 489.

**Heat ageing resistance** – tested internally and ISO 21809-3 fully compliant.

**Application guidelines:**

1. Prepare the sealing surface area plus 50 mm extra on each side
  - **clean and remove** all foreign materials,
  - **degrease** using PE-cleaner of min 98% purity,
  - **roughen** with 40-60 abrasion tape (optional roughen also inner surface of casing) and
  - **final cleaning**, e.g., by means of an industrial paper that does not leave any residue or colorant.
2. Dry the sealing surface area to 30-40°C.
3. Position the adhesive tape on the jacket pipe next to the guiding line, max. **10 mm** inside the shrinkable casing.
4. The overlap of the adhesive tape on itself shall be about 50 mm, independent of the pipe diameter.
5. For making the overlap of the adhesive tape remove the release plastic between the two layers and push the adhesive overlap together. Reapply one release plastic over exposed adhesive tape. The free release liner end is folded 90° outwards to facilitate later removal.
6. The shrinkable casing is positioned centrally and the two plastic release liners are pulled out carefully.

**Technical data:**

	<b>Testmethod</b>	<b>Typical Values</b>
Softening point:	ASTM E28	134°C
Brittleness temperature:	ASTM D3111	-15°C
Water absorption:	ASTM D570	0.3%
Shear strength @23°C:	EN 12068 (10mm/min)	0.1 N/mm <sup>2</sup>
	DIN 30672 (10mm/min)	10 N/cm <sup>2</sup>
Peel strength @ 23°C:	EN 12068 (10mm/min)	1.1 N/mm
	DIN 30672 (100mm/min)	>20 N/cm <i>Cohesive peel mode</i>
Thermal ageing resistance:	ISO 21809-3 100 days @ 85°C	$P_{100}/P_0 > 0.85$

\*  $P_{100}$  = Peel strength after 100 days -  $P_0$  = Peel strength without ageing

**Ordering info:** S1113-RI-XXXxYYYYY-DR-RL(C..)

RI = Two independent fiber meshes embedded centrally in the adhesive  
 XXX = Width of the tape in mm  
 YYYYY= Length in mm  
 DR = With double plastic release liner  
 RL = Roll  
 (C..) = Unit of packaging

- S1113 – RI – 50 x 25000 – DR – RL (C8) (\*)
- S1113 – RI – 100 x 25000 – DR – RL (C4) (\*)

(\*) *Nominal thickness of the adhesive 1.55 ±0.15 mm*

**Product Printing & Labeling:**

The core of each roll and the box carry a label with the following product information: **Covalence Product description –Product number – Lot number**

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