

- Characteristics:** Adhesive sealing tape on rolls with release plastic
- 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
- Qualification:** **Functionality and resistance** – tested and certified in accordance with EN 489.
- Heat ageing resistance** – tested internally and passes ISO 21809-3.

Application guidelines:

1. Prepare all sealing surface area's 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 for 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 surfaces by heating to 30-40°C with a gas torch.
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 ca. 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:

	Test method	Typical value
Softening point:	ASTM E28	150°C
Brittleness temperature:	ASTM D3111	-20°C
Water absorption:	ASTM D570	0.3%
Shear strength @23°C:	EN 12068 (10mm/min)	0.1 N/mm ²
	DIN 30672 (10mm/min)	10 N/cm ²
Peel strength @ 23°C:	EN 12068 (10mm/min)	1.1 N/mm
	DIN 30672 (100mm/min)	>20 N/cm <i>Cohesive peel mode</i>
Heat ageing:	ISO 21809-3 100 days @ 70°C	84% of the original value

Ordering info: S1113-XXxYxZZZZZ-(C..)

XX = Width in mm
Y = Nominal thickness of the adhesive in mm
ZZZZZ = Length of roll in mm
(C..) = Unit of packaging

Standard:

- S1113 – 30 x 1 x 30000-PL (C5)
- S1113 – 40 x 1 x 30000-PL (C4)
- S1113 – 50 x 1 x 30000-PL (C3)

Product printing & Labeling:

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

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