Covalence
Heat Shrinkable Technology

PPRP on 3LPP

Material and equipments

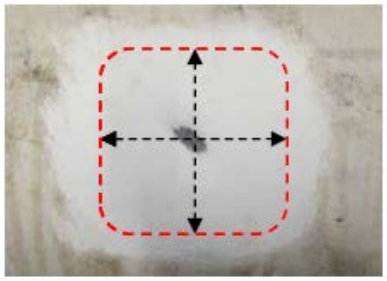
- PPRP
- S1137
- S1401 epoxy primer or Powercrete R150 epoxy coating
- Appropriate tools for surface abrasion: grinder, sanding disc (P16, P24, P36)
- Silicon hand roller, spatula, knife, measuring tape, scissor
- Tools for cleaning: rags, approved cleaner (e.g.PE-cleaner)
- Generator and induction coil.
- Digital thermometer and contact pyrometer
- Propane tank regulator, torch or equivalent
- Standard safety equipment as prescribed by local regulations

MAXIMUM DAMAGED AREA IS 50 CM²

Installation instructions

1. Remove loose coating from the damaged area with a knife, scraper or grinder. Eliminate all sharp edges and clean the damaged area and adjacent coating to remove all foreign material such as dirt, rust, oil, grease and moisture.
Maximum damaged area is ≤50 cm².

2. Abrade adjacent PP coating extending 100 mm (4") beyond the damage.



3. Cut a patch from the PPRP roll so that it extends at least 50 mm (2") beyond the damaged area.
Round off the corners of the PPRP patch!

4. Pre-heating. Pre-heat the exposed bare metal between 110-120°C (230-248°F) with induction heating equipment so that the 3LPP surface temperature is ≥90°C (194°F)

5. Follow the instructions supplied with the S1401 epoxy kits for preparation, mixing and application. Alternatively R150 cartridges can be used.

6. Using an applicator pad or similar tool, apply the epoxy and ensure all FBE and exposed steel is covered with 50-100 µm (3-4mils). Avoid as much as possible applying epoxy on the 3LPP line coating.

PERP-FILLER application
7. Cut the S1137 to size.

8. Apply S1137 to all areas of exposed epoxy. Avoid traces of S1137 on top of the 3LPP line coating if possible.

PPRP application
9. Position the pre-cut PPRP patch over the damaged area. Apply heat to PPRP backing, until the adhesive melts.

10. Smooth the repair patch with a gloved hand to eliminate air entrapments and ensure good bonding. Avoid squeezing S1137 between PPRP and the line coating.

11. Using the propane torch and medium flame, uniformly heat the entire PPRP patch. Use the roller, carefully roll the patch from the middle. Repeat the heating and rolling steps until air entrapments have been removed.

12. Check the adhesion of the patch by retracting the backing slightly.
If required repeat step **11**, reheat with the torch and roll the patch again.

13. Completed installation
Patch is correctly installed when all of the following have occurred:
1) There are no upstanding edges
2) After the patch is cool, adhesive is protruding on the edges
3) The patch has fully conformed to the line coating

SEALFORLIFE Industries

Seal For Life Industries - Stopaq B.V.
Stadskanaal, the Netherlands
Tel: +31 599 696 170

Seal For Life Industries BV
Westerlo, Belgium
Tel: +32 14 722 500

Seal For Life Industries US LLC
San Diego, USA
Tel. +1 858 633 9785

Seal For Life Industries Mexico
S de R.L. de C.V.
Tijuana, Mexico
US Tel: +1 858 633 9785
MX Tel: +52 664 647 4300

Seal For Life India Private Ltd.
Baroda, India
Tel: +91 2667 264 721

Further information is available on our website www.sealforlife.com, or by sending an inquiry to info@sealforlife.com