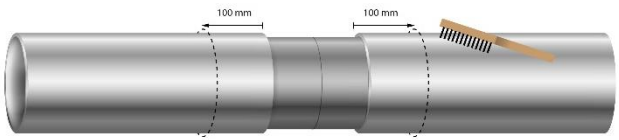
Evolen-Tape B 80-C

Installation Instructions

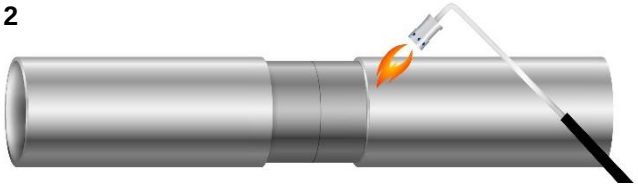
Vogelsang

1



The surface to be wrapped and the adjacent factory coating must be thoroughly cleaned from rust, dirt, temporary end protection, oil, grease, coupling agent from the ultrasonic test, oxyde and welding residuals. Naphta e.g. may be used as solvent. The cleaning may be executed ideally by sandblasting acc. to purity standard Sa 2½, steel wire brush or emery cloth (grain 60). The surface roughness is 50 -100 µm. Hard adhesive and the epoxy-resin-layer on factory delivered steel pipes are not to be removed, but both are to be roughened.

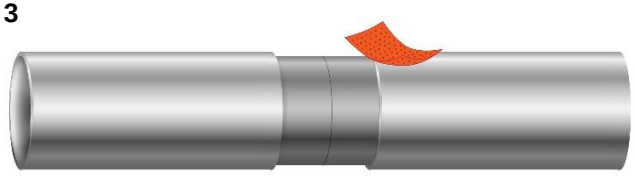
2



In case of existing moisture on the area to be coated, remove the humidity with a propane flame or with a hot air blower e.g.. Attention: Don't overheat the factory coating. Operating conduits must be dried with a strongly absorbent cloth (without fluffs).
Following temperatures are to be respected:

Surface temperature:	Min. 3°C over the dew point and >= 0°C Max. 70°C
Product temperature:	Min.3°C over the dew point and >=10°C

3



Chamfer the junction to the PE-factory coating with a rasp with semicircular blade to an angle of ≤ 30°, if not already factory done. Roughen the cleaned adjacent factory coating in a width of min. 100 mm in circumferential direction with emery cloth (grain 40). A grinding fleece may also be suitable. The surface roughness is 50 -100 µm. Rests of dust and shavings are to be removed by blowing away or with a hand broom. Attention: Loosely sticking parts or parts of the factory coating that are affected by moisture and corrosion are to be removed up to the closely sticking factory coating.

4

Apply the primer Testo S to the dry and clean steel surface and approx. 100 mm of the adjacent factory coating on both sides. Attention: Stir the primer thoroughly in its original packaging. Drying time approx. 5-10 min, depending on the weather (test with finger). Consumption approx. 0,25 l/m^2 with a mean thickness of 40-50 µm. If the drying time comes to more than 6 h or if in the meantime contaminations are found, the primer is to be applied once again. Take care for a good ventilation in case of applications in closed rooms. If welded seams stick out considerably (in longitudinal or lateral direction) or if the junctions to the factory coating are not sufficiently chamferred, these sections are to be padded with Evo-mastic in order to prevent from voids

DIN DVGW NV-5180AU0479

5

For obtaining **stress class B 50** apply a wrap with slight tension (tapering approx. 1%) without folds once with 67% overlap.The wrap begins and ends cylindrically on the factory coating, so from the initially painted 100 mm factory coating now min.75 mm are incorporated into the site applied coating (remove separation foil). Follow the top of the wrap and carry out the helical wrap. Commencing with a new roll, the first wrap is to be carried out cylindrically, incorporating the endpiece of the preceeding roll with overlap.

For obtaining **stress class C 50** apply a wrap with slight tension (tapering approx. 1%) without folds twice with 50% overlap. Remove the separation foil. The top and the end of the inner wrap (1st wrap) must cover 50mm of the factory coating. Follow the cylindrical beginning of the wrap and pass to the helical wrap. Terminate the wrap also with a cylindrical wrap.
Starting with a new roll, apply the first wrap cylindrically, incorporating the end piece of the previous roll with overlap.

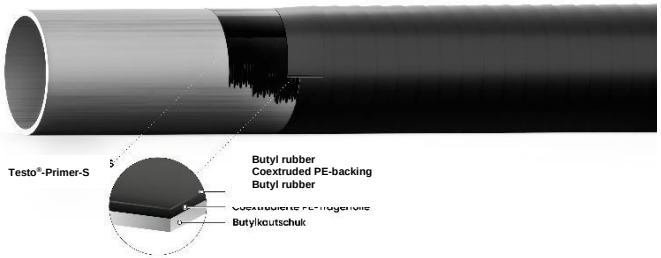
6

For **stress class C 50** apply the outer layer B 80-C (second wrap) also with slight tension in the same way. **Stress class C 50** is obtained with a min. overlap of 50%. The outer wrap must cover the inner wrap at the edges in the same way and direction with min. 25 mm, so that now min. 75 mm of the factory coating, painted initially in a width of approx. 100 mm, are incorporated into the site applied coating.

At the end of the wrapping apply the last 100 -150 mm of the B 80-C in falling 3-o'clock-position without tension on itself and press it on firmly by hand.

Test: The coating is to be tested with a pore detector for freedom from pores.

Attention: Our coating systems are not suitable for the sealing of media transporting pipelines, but exclusively for the prevention and protection from corrosion.



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