

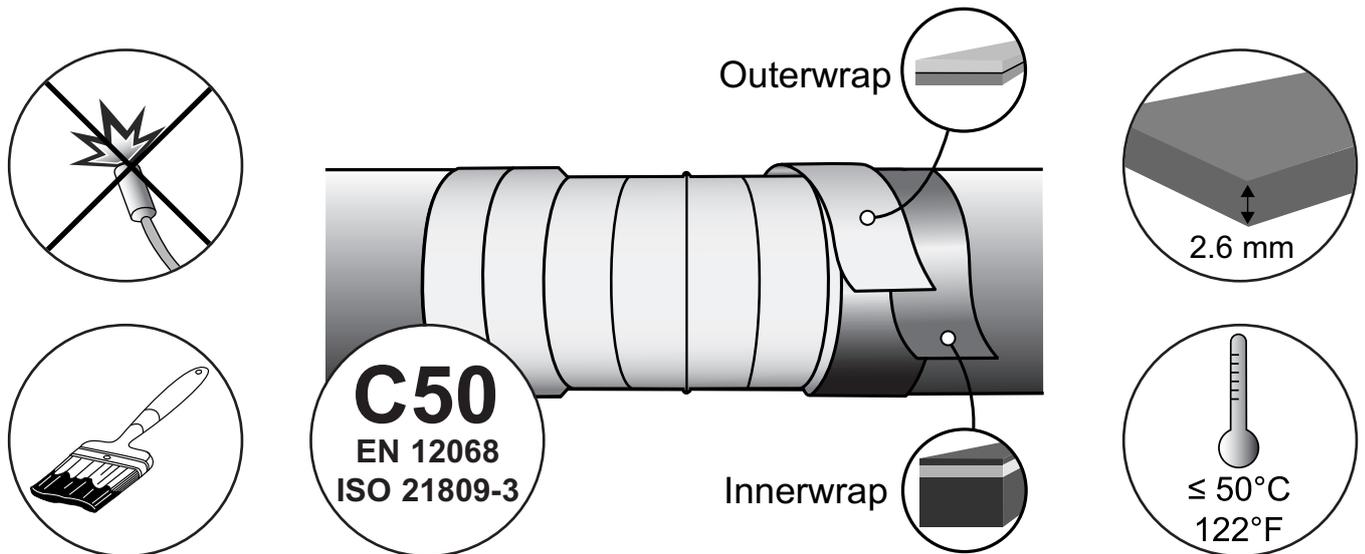
Denso® Premier Butyl Tape™ System

INSTRUCTIONS FOR USE

Introduction:

The following 'Instructions For Use' outlines the correct application of the Premier Butyl Tape™ System for the protection of pipeline and welded joints.

System Components: - Premier Butyl P16HT™ Primer - Premier Butyl Mastic™
- Premier Butyl S43HT™ Innerwrap - Premier Butyl R23HT™ Outerwrap



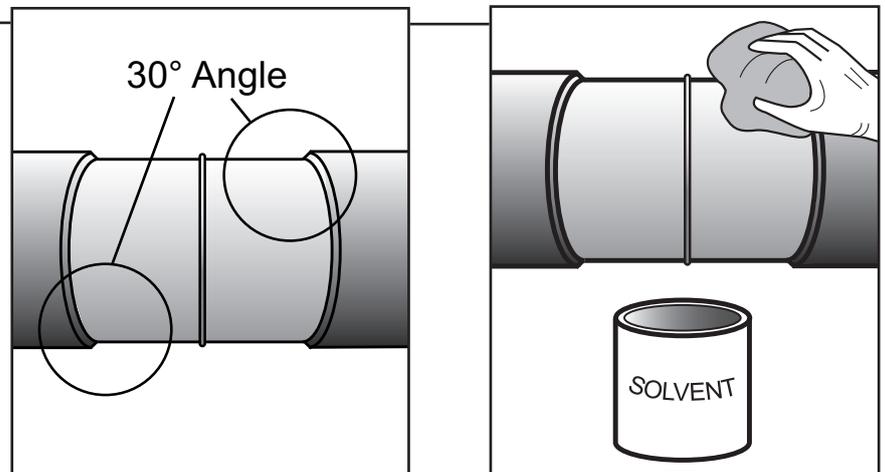
1 Bevel / Clean

The edges of the adjacent coating shall be bevelled as shown.

Thoroughly clean the area of the welded joint and the adjacent coating. The area cleaned shall extend at least 100mm on to the adjacent coating.

The surface of the steel and adjacent coating shall be free from grease, oil, and dust.

If solvent cleaning is required this shall be carried out according to Steel Structure Painting Council SSPC SP 1 using approved solvent, emulsion or cleaning compound.



2 Surface Preparation

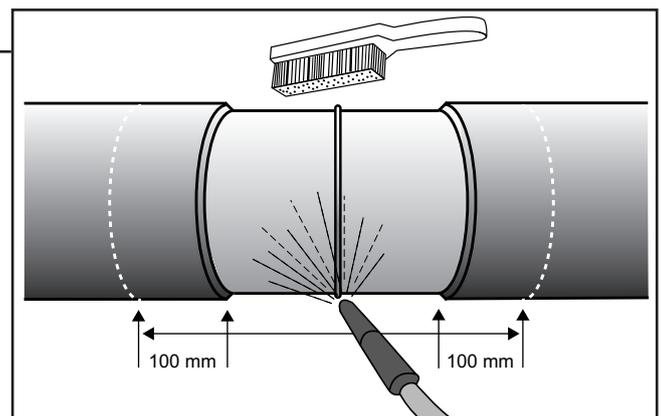
The preferred method of cleaning is Abrasive Blast Cleaning in accordance with one of the following standards:

Steel Structure Painting Council SSPC SP 10

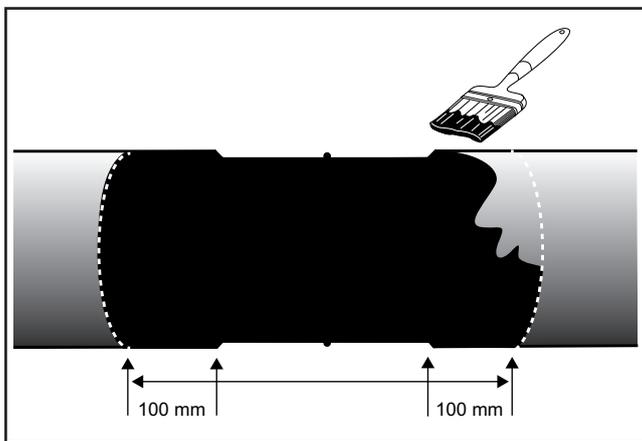
Swedish Standard Institution SIS 05 59 00 Sa 2½

International Standards Organization ISO 8501-1 Sa 2½

An abrasive blast profile of 50 microns minimum is required. Clean the area of the welded joint and the adjacent coating. The area cleaned shall extend at least 100mm on to the adjacent coating.



The following temperatures are to be respected: **Surface temperature:** Min. 3°C over the dew point and $\geq 0^{\circ}\text{C}$ Max. 70°C
Product temperature: Min. 3°C over the dew point and $\geq 10^{\circ}\text{C}$



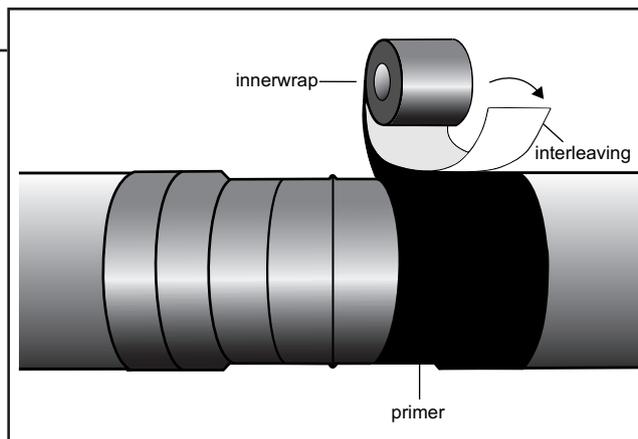
Apply the primer to the dry and clean steel surface and approx. 100 mm of the adjacent factory coating on both sides. Drying time approx. 5-10 min, depending on the weather (test with finger).

Ensure there is adequate ventilation if applied in closed areas. If welded seams stick out considerably (in longitudinal or lateral direction) or if the junctions to the factory coating are not sufficiently chamfered, these sections are to be padded with mastic in order to prevent voids.

4 Innerwrap Application

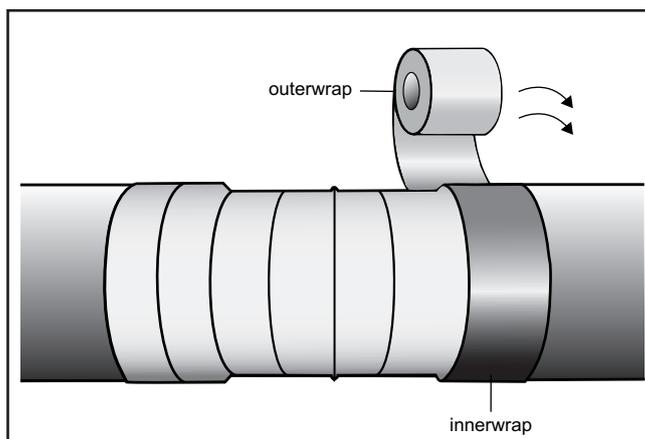
Select as wide a width of tape as practical, e.g. 100mm wide for 100mm diameter pipe. Peel back about 0.5m of interleaving and apply the 'grey' adhesive side of the tape firmly to the pipe, wrapping the tape spirally and ensuring correct alignment. Maintain sufficient tension to ensure that the tape conforms to the surface without gaps. Repeat this, overlapping each turn by at least 25mm or preferably 55% to give double thickness. Start new roll by overlapping the ends by one tape width.

Note: Where longitudinal welds are included in the area to be wrapped, apply a 100mm wide strip of the tape longitudinally over the weld and press into the contours before wrapping.



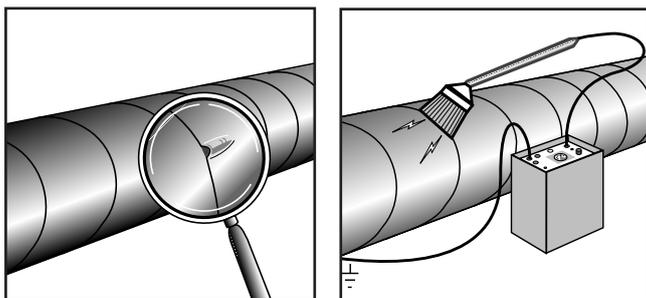
Outerwrap Application **5**

Select as wide a width of tape as practical, e.g. 100mm wide for 100mm diameter pipe. Apply the adhesive side of the tape firmly to the pipe and commence wrapping the tape spirally, ensuring correct alignment. Maintain sufficient tension to ensure that the tape conforms to the surface without gaps. Repeat this, overlapping each turn by at least 25mm or preferably 55% to give double thickness. Start new roll by overlapping the ends by one tape width.



6 Inspection and Coating Repair

Inspection: Ensure that the entire surface is covered with no gaps or air pockets. Ensure that the correct overlap is achieved. Holiday test at 10kV



Coating Repairs:

1. Mechanical Damage:

Damaged coating should be repaired by first cleaning and removing any loose coating and then using Butyl Mastic to fill any voids to create a smooth surface. Then wrap Innerwrap Tape and Outerwrap Tape over the damaged area as described in sections 4 and 5 above, extending all around at least 50mm onto firm existing coating.

2. Peeling Test Damage:

To repair damage caused by a peeling test, first press the peeled section of tape firmly back into position then wrap the area with the Innerwrap and Outerwrap Tape as explained above under 'Mechanical Damage'.