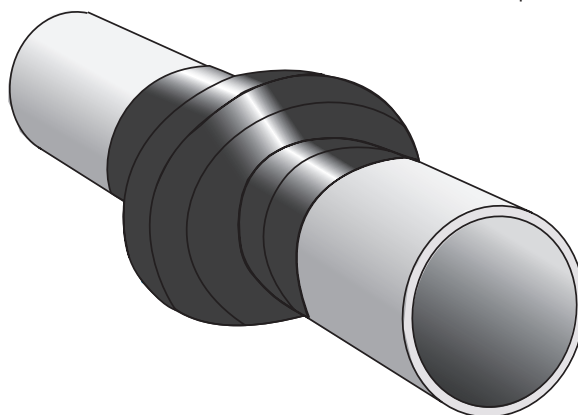


COVERING: PREMCOTE 150TM, PREMCOTE 500TM, PREMCOTE 1500TM,
PREMCOTE 150RTM and PREMCOTE 1000RTM (including tropical versions)

APPLICATION MANUAL

For the protection of pipes, welded joints, bends and fittings and similar structures from corrosion above ground, buried or immersed. To protect the metal structure from the environment the tape must cover the entire surface.



EQUIPMENT LIST

Power wire brush / scraper / blast cleaning equipment (optional),
Brush, brush cleaning solvent,
Utility knife,
Overalls, gloves, cleaning cloth, hand cleaner, barrier cream

SURFACE PREPARATION

Surfaces must be dry and free from dirt. Solvent wipe with a clean cloth to remove any grease deposits. Power wire brush to remove all scale, loose rust and old flaking coatings to achieve a finish of St 2 according to ISO 8501-1. The preferred method for refurbishment of old pipe lengths is abrasive blast cleaning to Sa 2½ according to ISO 8501-1.

PRIMING

Brush apply one coat of PREMCOTETM PRIMER over the entire area to be wrapped. Allow to dry.

| | |
|---------------------|-----------------------|
| Coverage: | 9-11m ² /l |
| Wet film thickness: | 90 -110 microns |
| Dry film thickness: | 40 - 50 microns |
| Drying time: | Approx 20 minutes |

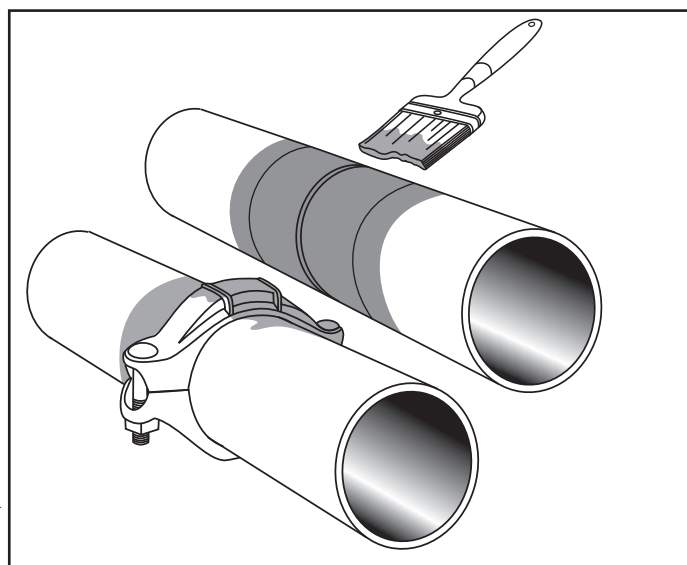


Fig 1. Priming pipes, couplings and welded joints. Apply PREMCOTETM PRIMER to entire area to be wrapped with tape.

TAPE APPLICATION FOR PIPES, RODS AND CABLES

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 adhesive side of the tape firmly to the pipe. Unroll the tape about 0.5m, peel back the interleaving and wrap 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.

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.

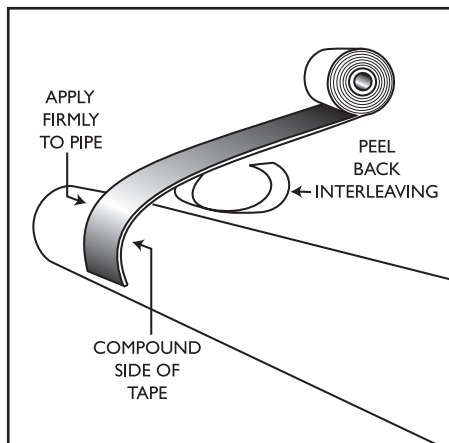


Fig 2. Starting the first roll of tape.

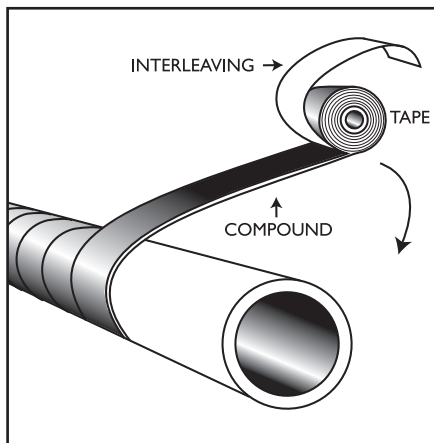


Fig 3. Diagram showing the correct application procedure for wrapping tape.

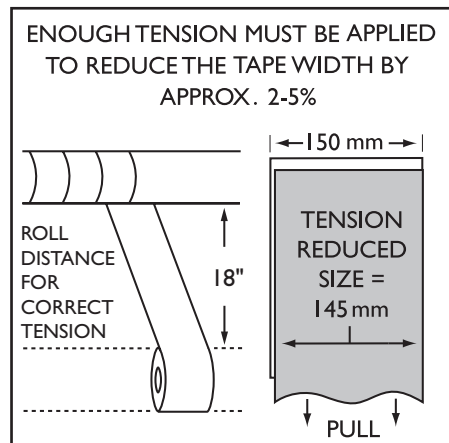


Fig 4. Ensure that tape is applied with the correct amount of tension to reduce width as shown in illustration above.

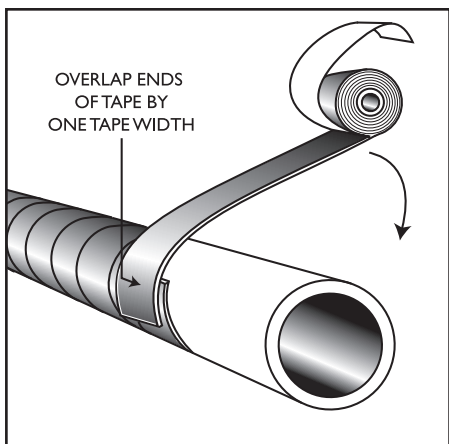


Fig 5. Starting a new roll of tape.

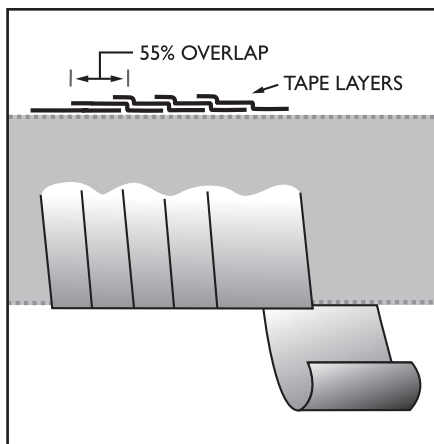


Fig 6. Overlapping each turn by 55% gives a double thickness.

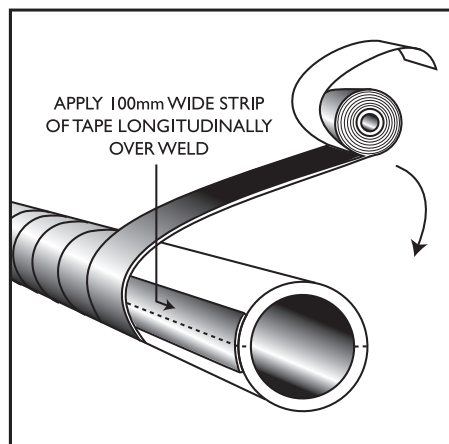


Fig 7. Wrapping a longitudinal weld.

TAPE APPLICATION FOR BUTT WELDED JOINTS

Proceed as for pipes rods and cables (above) but start and finish wrapping with a minimum of 75mm overlap on to the existing pipe coating either side of the joint area.

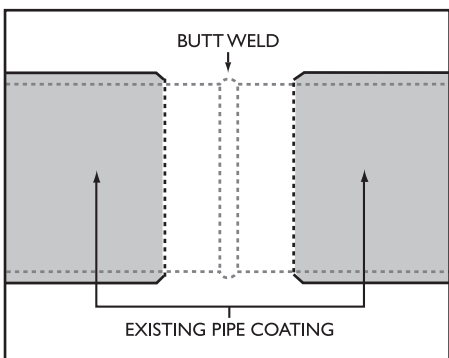
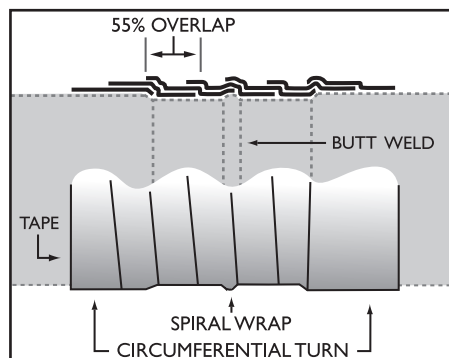


Fig 8. Butt weld and existing coating ready for overwrapping with tape. Note cutback of coating can be 75mm -150mm either side of the weld except on FBE coated pipe.

- Fig 9. Note method of wrapping.
1. Start with one circumferential turn onto factory coating.
 2. Then change to spiral wrap with 55% overlap over weld area.
 3. Finish with one circumferential turn over factory coating the opposite side of the weld. Overlap tape at least 75mm onto existing coating.



TAPE APPLICATION FOR FLANGES, COUPLINGS ETC

Apply one coat of PREMCOTE PRIMER over entire surface to be wrapped. Profile the pipe joint with PREMIER™ MOULDING COMPOUND so that there will be no air gaps under the subsequent tape wrapping. Push the mastic firmly into all cavities and around all bolt heads building it up to form a profile suitable for wrapping without forming bridges or voids. The tape is applied by dividing the joint into two halves. Start the tape on the centre of the crown of the joint and wrap away from the centre, towards the adjoining pipe, overlapping each turn by at least 25mm or preferably 55% to give a double wrap. Finish with at least one circumferential wrap onto the pipe to conclude first half of the application. Start again on the crown of the joint overlapping initial wrap. Wrap towards the pipe on the opposite side of the joint overlapping tape as per first wrapping. Smooth finished wrap down well particularly at the tape edges.

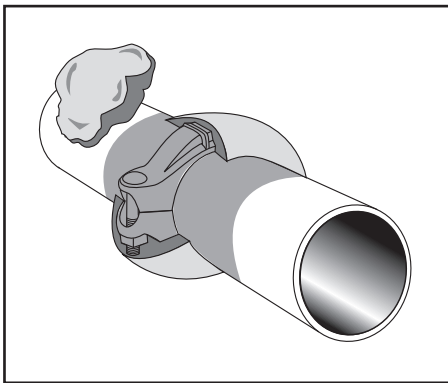


Fig 10. Profiling the joint with PREMIER MOULDING COMPOUND.

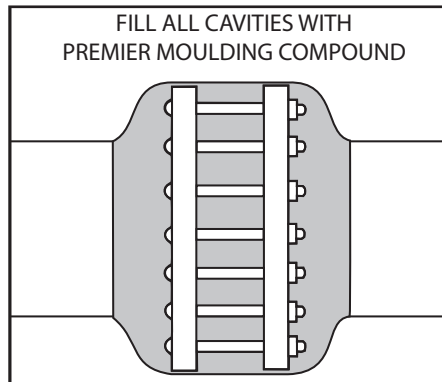


Fig 11. Make sure the mastic is pushed into all crevices and that it forms a smooth profile for wrapping.

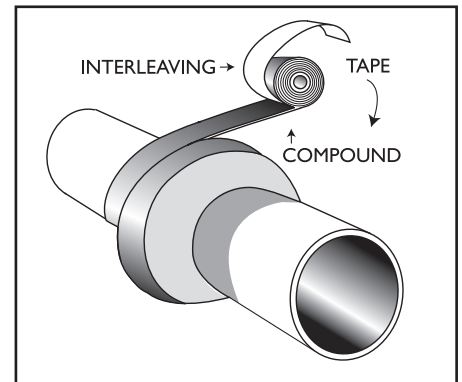


Fig 12. Wrap joint in two halves. Start on crown and work towards pipe then repeat from crown working towards pipe on opposite side of joint.

REPAIRING DAMAGED COATINGS

Cut away and remove loose coating from damaged area and smooth or chamfer edges. Clean area thoroughly then prime the exposed metal extending 50mm either side of the damage. Repair the damaged area with a patch of tape or PREMIER MOULDING COMPOUND. Wrap the section of pipe as for Butt Weld Joints.

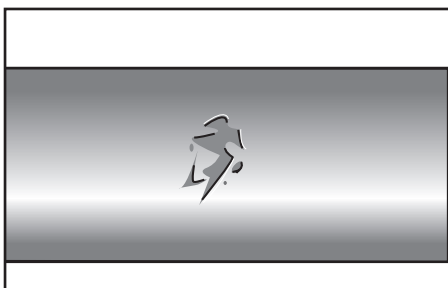


Fig 13. Damaged pipe coating.

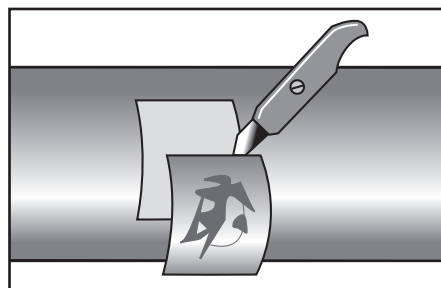


Fig 14. Remove loose or damaged area then clean thoroughly.

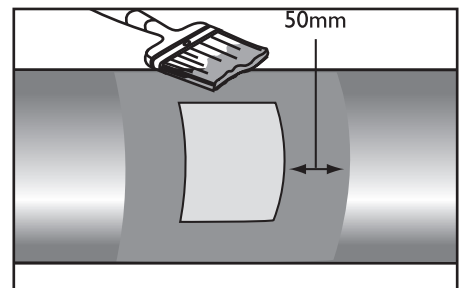


Fig 15. Smooth edges and prime area at least 50mm onto sound coating.

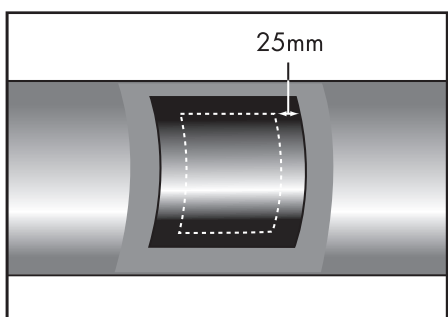
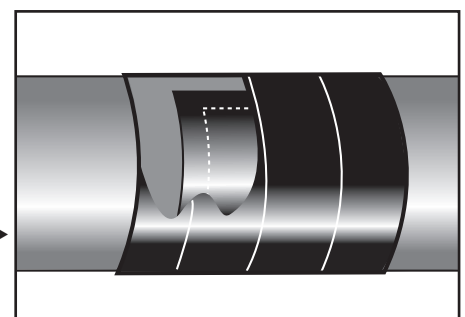


Fig 16. Repair damaged area with a patch of tape overlapping at least 25mm onto primed sound coating area before wrapping with tape as for Butt Weld Joints.

Fig 17. Overwrap repair as for Butt Weld Joints.



COVERING: PREMCOTE 150TM, PREMCOTE 500TM, PREMCOTE 1500TM,
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APPLICATION MANUAL

STORAGE:

Store correct way up in original packaging. Store away from direct heat and open flames.

TRANSPORT:

No special precautions necessary.

HANDLING:

- The use of barrier cream is recommended. Avoid contact of the compound with face, arms, etc..
- Wash thoroughly after use and before work breaks to remove compound from the skin.
- Careful attention should be given to personal hygiene.
- Change and clean soiled clothing

ACTION IN CASE OF..

FIRE: Extinguish with dry powder, carbon dioxide or chemical foam. Air breathing equipment may be necessary in large fires.

SKIN CONTACT: Wash with warm water and mild soap.

DISPOSAL:

Please do not discard waste material, including packaging, in the surrounding environment. Follow all relevant legislation for disposal.

IMPORTANT: Premier Coatings Ltd pursue a policy to develop and continually improve all of our products and therefore information given in this data sheet is intended as a general guide and does not constitute a warranty or specification. However, our sales personnel are committed to assisting the user in establishing the suitability of the product for its intended purpose and additional specific information is available on request. These Instructions may not cover all circumstances and must be read in conjunction with the project specifications. For further advice contact Premier Coatings Ltd.