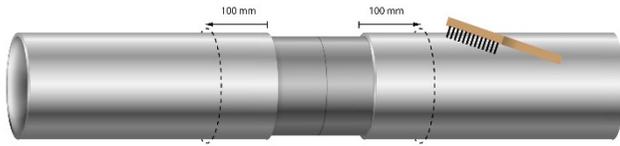


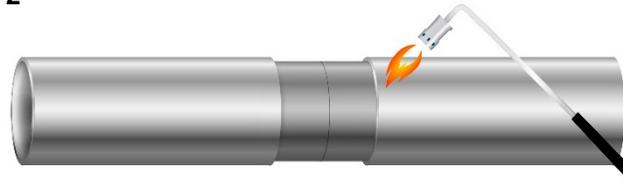
Installation Instructions for Denso Butyl Tape HT (High Temperature) System

1



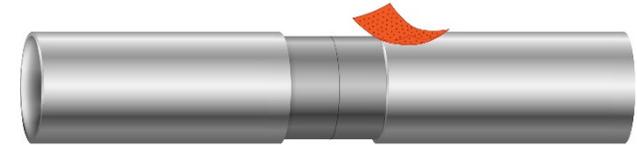
The surface to be wrapped and the adjacent factory coating must be thoroughly cleaned from rust, dirt, temporary end protection, oil, grease, coupling agent from the ultrasonic test, and welding residuals. Solvent such as naphtha may be used for cleaning. The cleaning may be performed ideally by sandblasting to Swedish Standard Sa 2½, steel wire brush or emery cloth (grain 60). 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 moisture with a propane flame or with a hot air blower. Do not overheat the factory coating. Operating conduits must be dried with a strong absorbent cloth (without contamination).
Following temperatures are to be respected during application:
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 $\geq 10^\circ\text{C}$

3



Chamfer the junction to the PE-factory coating with a rasp semi-circular blade to an angle of $\leq 30^\circ$, if not already factory done. Roughen the cleaned adjacent factory coating to a width of minimum 100 mm in circumferential direction with emery cloth (grain 40). A grinding fleece may also be suitable. Any remaining dust and shavings are to be removed by blowing away or with a hand broom. **Attention:** Loosely adhering parts or parts of the factory coating that are affected by moisture and corrosion are to be removed up to the closely adhering factory coating.

4



Apply Denso Butyl Primer HT to the dry and clean steel surface and approx. 100 mm of the adjacent factory coating on both sides. Stir the primer thoroughly in its original packaging. Drying time approx. 5-10 min, depending on the ambient temperature (test with finger). Consumption approx. 0.25 L/m². If the drying time exceeds 6 h, or if contamination is found, the primer is to be reapplied. Denso Butyl Mastic to be used to contour welded seams, or if the junctions to the factory coating are not sufficiently chamfered.

5



Wrap the Denso S43 HT Tape with slight tension and without folds (tapering approx. 1%) with a 55% overlap. Remove release paper as wrapping progresses. Grey adhesive side of Denso S43 HT Tape is to be applied to the substrate. The top and the end of the coating to be wrapped cylindrically in a width of minimum 50 mm on the factory coating. Follow the top of the wrap and carry out wrapping spirally. When commencing a new roll, the first wrap is to be carried out cylindrically, incorporating the end piece of the preceding roll with overlap.

6

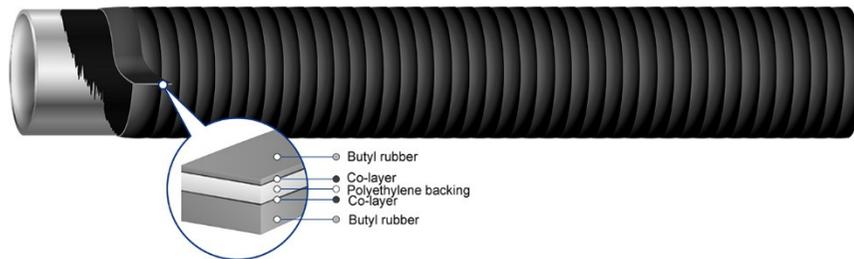


Wrap a second layer of Denso S43 HT Tape with a 55% overlap using slight tension and without folds. The grey compound is to be in contact with the black outer layer of the previous wrap. The outer wrap must cover the inner wrap at the edges with minimum 25 mm, so that now minimum 75 mm of the factory coating, painted initially in a width of approx. 100 mm, are incorporated into the site applied coating.

Without tension, apply the last 100 - 150 mm of the outer tape at the end of the wrap to the 3-o'clock-position on to itself. Press firmly by hand.

Colours of the tapes are for illustration only.

The coating is to be tested with a holiday detector according to AS 3894.1.



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