



PLASTELEN® Petrolatum tapes and mastics

For pipes/pipelines

1. Surface treatment

The surface must be free from dust and loose objects. Rust must be removed using a wire brush. Minimum degree of cleanliness (ISO 8501-1) St2.

2. Primer (optional)

Work **PLASTELEN® Primer** into the surface thoroughly. Apply **PLASTELEN® Primer** by hand or using a spatula to the surface to be coated.

3. Anti-corrosion tape (pipes & bends)

Wind **PLASTELEN® Petrolatum tape** around the pipe with the required overlap and with no wrinkles. Then smooth down the **PLASTELEN® Petrolatum tape** with your hand and press it firmly into position.

4. Mechanical protection

Coat the areas encased in **PLASTELEN® Petrolatum tape** with a layer of **DEPROTEC®-DRM PP** up to the transitional point with the factory-encased surface. Fix the pipe protection mat in the overlap area by applying the heat of a flame and pressing down immediately. For additional mechanical protection, **DEPROTEC®-PUR** glass fibre bandage can be used.

For armatures/flange connections

1. DEKOTEC® Petrolatum mastics

Apply **PLASTELEN® Petrolatum mastics** by hand or using a spatula in order to fill hollow spaces. Shape the mastic and then wind **PLASTELEN® Petrolatum-tape** all the way around.

2. Flange connections & armature housing

Depending on the operating temperature, fill the hollow space between the crack between the flange plates with **PLASTELEN®-Jet** or **PLASTELEN®-Fill**.

3. Flange connections & armature housing

Lay **PLASTELEN® Petrolatum tape** centrally on the flange and shape it over the external circumference, screw heads, nuts etc. Tape width depends on the nominal size: 250, 300 or 400 mm

4. Flange connections & armature housing

Optional: Flanges DN > 400

Position 2 layers of **PLASTELEN® Petrolatum tape** alternately on the right and left flange edge. The length of the **PLASTELEN® Petrolatum tape** sections correspond to the external flange circumference plus 50 mm overlap. Cover the pipe surface adjacent to both sides of the flange with **PLASTELEN® Petrolatum tape** in a sleeve formation or spiral pattern.

5. Mechanical protection

Coat the areas encased in **PLASTELEN® Petrolatum tape** with a layer of **DEPROTEC®-DRM PP** up to the transitional point with the factory-encased surface. Fix the pipe protection mat in the overlap area by applying the heat of a flame and pressing down immediately. For additional mechanical protection, **DEPROTEC®-PUR** glass fibre bandage can be used.

Processing temperature	Primer	
	Product	PLASTELEN®-AQ Primer HT
Material °C (°F)	-10 to +50 (+14 to +122)	+5 to +50 (+41 to +122)
Surface °C (°F)	-10 to +50 (+14 to +122)	-10 to +100 (+14 to +212)

Processing temperature	Tape without lamination film						Tape with lamination film		Mastic		
	Product	PLASTELEN®-Feu	PLASTELEN®-Tape ET	PLASTELEN®-Tape MT ¹	PLASTELEN®-Tape ST	PLASTELEN®-Tape HT ²	PLASTELEN®-Tec PLASTELEN®-Verte PLASTELEN®-Tape LT ¹	PLASTELEN®-Cal ²	PLASTELEN®-Flex PLASTELEN®-Plast	PLASTELEN®-PF	PLASTELEN®-Plast
Material °C (°F)	-10 to +40 (+14 to +104)	+5 to +55 (+41 to +131)	-10 to +50 (+14 to +122)	+5 to +45 (+41 to +113)	+5 to +50 (+41 to +122)	-10 to +30 (+14 to +86)	+5 to +50 (+41 to +122)	-10 to +30 (+14 to +86)	+0 to +30 (+32 to +86)	+4 to +30 (+39,2 to +86)	+40 to +85 (+104 to +185)
Surface °C (°F)	-20 to +50 (-4 to +122)	-10 to +60 (+14 to +140)	-20 to +50 (-4 to +122)	-20 to +40 (-4 to +104)	-10 to +100 (+14 to +212)	-10 to +30 (+14 to +86)	+40 to +110 (+104 to +230)	-10 to +30 (+14 to +86)	+0 to +30 (+32 to +86)	+0 to +30 (+32 to +86)	≥ +5 (≥ +41)

General	
Surface preparation	Use an abrasive cloth #40 in a peripheral direction to roughen adjacent work surfaces and chamfer at an angle of < 30°. Surface cleanliness: min. St2 (ISO 8501-1) dry and free from grease, dust etc.
Health, safety & environmental protection	The installation must take place in accordance with customary and local environmental and safety standards. The safety and environmental notes which accompany DEKOTEC products must be heeded. Personal protective equipment such as safety glasses, safety gloves and fastened work garments must be worn.

- 1) Only for use with **PLASTELEN®-AQ Primer**
- 2) At low temperatures **PLASTELEN®-Cal Primer** can be used (surface -10 °C to +50 °C (+14 °F to +122 °F))
- 1) Only for use with **PLASTELEN®-AQ Primer HT**