



VivaxCoat®-LT/-MT/-HT

Preparation

1. Surface preparation



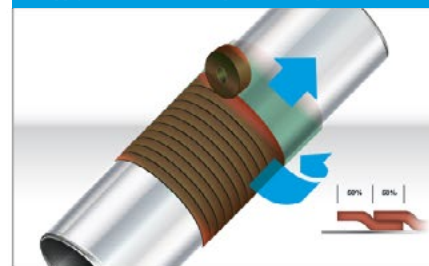
The surface must be free of dust, ice, frost and any loose particles. Rust must be removed with a metallic brush.

2. Apply the primer



Apply a thin layer of **PLASTELEN® Primer** using your hand or a palette knife onto the steel surface and the adjacent coating. If applying to a wet surface, firmly press the **PLASTELEN® Primer** to remove the moisture from the surface. Material consumption: Average 500 g/m²

3. Apply the anti-corrosion protection tape



Apply the **PLASTELEN®-Tape** to the pipe in a spiral with 50% of covering and without folds. Smooth the **PLASTELEN®-Tape** by hand and apply firm pressure.

BUTYLEN mechanical protection tape

4. Apply BUTYLEN protection tape



Apply the **BUTYLEN-AS50 (VivaxCoat®-LT/-MT)** or **BUTYLEN-ET100 (VivaxCoat®-HT)** mechanical protection tape on top of the anti-corrosion tape, with a cover rate of 50% (1x50% of covering for the HR class). The mechanical protection tape must fully cover the anti-corrosion protection tape and exceed at least 5cm. For effective implementation, it is recommended to use a **DEKOMAT®** coating machine.

5. Electrical porosity test



After the application of the **BUTYLEN** tape it is possible to carry out a test using an electrical porosity controller, provided for in standard. It is recommended to use spiral electrodes or rubber.

Product	Nominal diameter	Recommended roller Width (mm)	Product temperature °C (°F)	Surface temperature °C (°F)	Environment temperature °C (°F)	Storage conditions °C (°F)
PLASTELEN®-AQ Primer			-10 to +50 (+14 to +122)	-10 to +50 (+14 to +122)	-30 to +50 (-22 to +122)	dry ≤ +40 (≤ +104)
PLASTELEN®-AQ Primer HT			+5 to +50 (+41 to +122)	-10 to +100 (+14 to +212)	-30 to +50 (-22 to +122)	dry ≤ +40 (≤ +104)
PLASTELEN®-Tape LT	≤ DN 200	50	-10 to +30 (+14 to +86)	-10 to +50 (+14 to +122)	-30 to +50 (-22 to +122)	dry ≤ +30 (≤ +86)
	DN 200-DN 400	100				
	> DN 400	150				
PLASTELEN®-Tape MT	≤ DN 200	50	-10 to +50 (+14 to +122)	-10 to +50 (+14 to +122)	-30 to +50 (-22 to +122)	dry ≤ +40 (≤ +104)
	DN 200-DN 400	100				
	> DN 400	150				
PLASTELEN®-Tape HT	≤ DN 200	50	+5 to +50 (+41 to +122)	-10 to +100 (+14 to +212)	-30 to +50 (-22 to +122)	dry ≤ +40 (≤ +104)
	DN 200-DN 400	100				
	> DN 400	150				
BUTYLEN-AS50 BUTYLEN-ET100	< DN 65	30	-10 to +50 (+14 to +122)	-10 to +50 (+14 to +122)	-30 to +50 (-22 to +122)	dry ≤ +50 (≤ +122)
	≤ DN 200	50				
	> DN 200	100				
Other materials	Metallic brush, gloves, palette knife.					
Safety at work and Protection of the environment	All stages of the implementation should be carried out using personal protective equipment such as safety shoes, helmets, safety goggles and gloves that comply with the applicable health and safety regulations.					