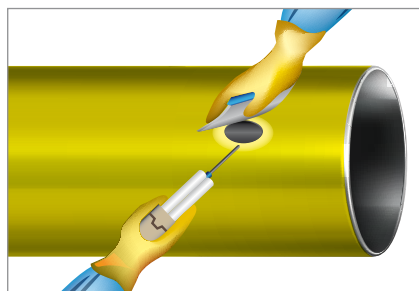




Repair systems for anti-corrosion coatings

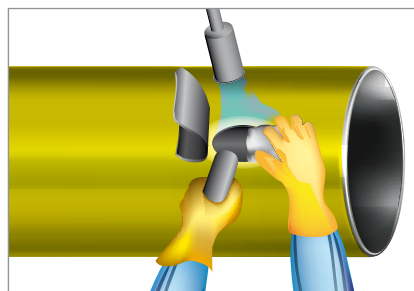
DENSOLID®-FK2 C



Processing:

- Activation of the factory coating in the repair area by means of contact with the propane gas flame.
- Place the static mixer on the cartridge and insert into the applicator (**DENSOMIX®**).
- Cease using the static mixer if the material has become gel-like.
- Before beginning each coating layer discard 5 ml of **DENSOLID®-FK2 C** (a homogeneous black mixture must be achieved).
- Apply the correct quantity of material into the repair area and remove the excess with a plastic spatula in a peripheral direction within the pot life range so the adjoining coating remains covered with a thin film.
- Do not fill larger repair areas in layers, instead fill them in sections.
- Hardening time until touch-dry at temperatures of +20 °C (+68 °F): approx. 10 min., loads can be borne after approx. 120 min.
- Protect the coating from water, precipitation and moisture until it is no longer sticky.
- High voltage test after hardening with 8 kV per mm coating thickness, max. 20 kV (DIN EN 10290).

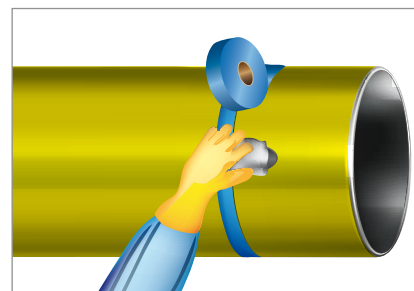
DEKOTEC®-DRP DEKOTEC®-Meltstick DEKOTEC®-Filler



Processing:

- Heat the repair area (factory coating and defect area) to +90 °C to +100 °C (+194 °F to +212 °F)
- Heat the **DEKOTEC®-Meltstick** with a yellow-blue flame until the material can be applied in a state which is as soft as wax.
- Fill in the repair area using **DEKOTEC®-Filler**, alternative to **DEKOTEC®-Meltstick**, in such a way that it is possible to achieve a hollow-free coating using **DEKOTEC®-DRP**.
- Smooth the filled defect area to the same level as the coating thickness with a hot spatula in a peripheral direction.
- Cut the **DEKOTEC®-DRP** in such way that there is a minimum layer of 50 mm of the undamaged factory coating on all sides. Cut the patch into a round shape, no corners.
- Heat the adhesive side until it is shiny and position it on the repair area.
- Heat the adhered **DEKOTEC®-DRP** evenly until the matt black surface begins to shine.
- Using a hand roller, apply under pressure in a length-wise and peripheral direction until the adhesive coating is smooth and visibly free from bubbles on all sides.

DENSOLEN®-W/ -W+/- -WP Mastic DENSOLEN® PE/Butyl-Bands



Processing:

- **Caution:** The mechanical and thermal load bearing capacity of the defect repair area depends on the **DENSOLEN® Band** tape system which has been used.
- Prior to application, stir the **DENSOLEN®-HT Primer**, thoroughly in the original container until no sediment remains (see product information).
- Coat the defect and the roughened factory coating evenly and apply a thin layer. Caution: Ventilate the primer coat until it is no longer sticky.
- Fill in the repair area using **DENSOLEN®-Mastic** in such a way that it is possible to achieve a hollow-free coating using **DENSOLEN® tape**.
- Wind **DENSOLEN® inner tape** completely around the pipe in a spiral pattern with 50% overlap over the defect area so that the adjacent factory coating is covered by at least 50 mm.
- Wind **DENSOLEN® outer tape** completely around the pipe in a spiral pattern with 50% overlap over the inner tape so it is covered by at least 50 mm.
- The first and last windings must be accurately aligned (with 100% overlap), i.e. in a peripheral direction with no misalignment.
- The start and end edges of the tape must point towards the bottom of the pipe.

Product	Processing temperature		Relative air humidity (%)	Pot life (sec.) at ambient temperatures			Storage temperature °C (°F)	Compatible factory coatings
	Surface °C (°F)	Material °C (°F)		+10 °C (+41 °F)	+20 °C (+68 °F)	+40 °C (+104 °F)		
DENSOLID®-FK2 C	+10 to +50 (+50 to +122) and min. +3 (+5) Above dew point	+10 to +35 (+50 to +95) and min. +3 (+5) Above dew point	< 80	75	60	50	+15 to +30 (+59 to +86) Store upright	PE, PP PU, FBE Bitumen
DENSOLEN®-HT Primer DENSOLEN® Mastic DENSOLEN® PE-/Butyl-Bands		-10 to +40 (+14 to +105)				<+50 (<+122)		
DEKOTEC®-DRP DEKOTEC®-Meltstick DEKOTEC®-Filler	ca. +90 to +100 (+194 to +212)							
Surface preparation	Remove loose factory coatings, even out notches and indentations and chamfer corners to an angle of <30°. Buff adjacent factory coatings to a minimum of 100 mm with an #40 abrasive cloth in a peripheral direction. Surface cleanliness: Blast de-rusting min. Sa 2½ (ISO 8501-1), surface roughness 40 µm to 100 µm, 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. Safety and environmental notices on labels and safety data sheets must be heeded. Personal protective equipment such as safety glasses, safety gloves and fastened work garments must be worn.							