



# ECOTAPE

## ECOTAPE 2-PLY TAPES APPLICATION INSTRUCTIONS

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### EQUIPMENT LIST

Power wire brush / scraper / blast cleaning equipment (optional)

Brush or roller, cleaning solvent

Utility knife, overalls, gloves, eye protection, 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 St2 according to ISO 8501-1 or Swedish Standard SIS 0055900.

The preferred method for refurbishment of old pipe lengths is abrasive blast cleaning to Sa21/2 according to ISO8501-1 or Swedish Standard SIS 0055900.

### APPLICATION:

#### 1. PRIMING

Brush or roller apply a thin coat of ECOTAPE P29 PRIMER over the entire area to be wrapped. Allow tacking dry\*.

Coat a wide enough section so that the primer will protrude slightly from under the tape edges after the tapes are applied.

Coverage: 8m<sup>2</sup>/l

Tack dry: 5 - 10 minutes

Dry film thickness: 20 - 30 microns

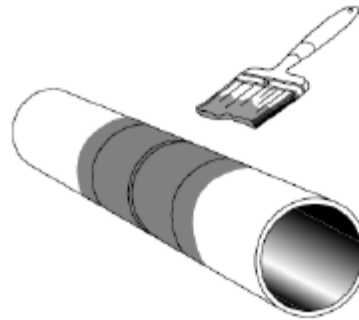
\*Tape will need to be applied whilst the primer is still “active”. A slight tackiness indicates it is still active. Once completely set (20 minutes) a chemical bond is unlikely to be achieved. Only a weaker mechanical bond will be obtained.

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**Fig 1. Priming pipes:** Apply ECOTAPE P29 PRIMER to entire area to be protected with tape.



**Fig 2. Priming butt welded joints.** Apply ECOTAPE P29 PRIMER to entire area to be protected with tape.

## 2. TAPE APPLICATION

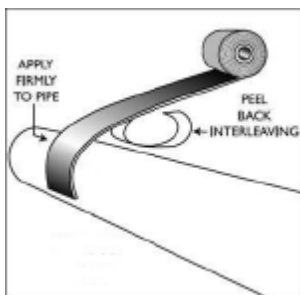
### T150-20, T165-25, T180-30 INNER WRAP TAPE

Select as wide a width of 2-PLY INNER WRAP TAPE as practical, e.g. 100mm wide for 100mm diameter pipe. Peel back about 0.5m of interleaving and apply the tape firmly to the pipe. Unroll the tape about 0.5m, peel back the interleaving and wrap the tape spirally ensuring correct alignment. Ideally maintain sufficient tension to reduce the width of the tape by 2-5% to ensure that the tape conforms to the surface without gaps. For ease of application use an ECOTAPE WRAPPING MACHINE Model ECOMAT. Tape contact with the pipe must only occur on primed substrate.

Overlap each turn by 55% to give a double layer thickness of 2-PLY tape. Start new rolls by overlapping the ends by one tape width. Figures 3 to 7 below illustrates tape application.

### T280-30 OUTER WRAP TAPE

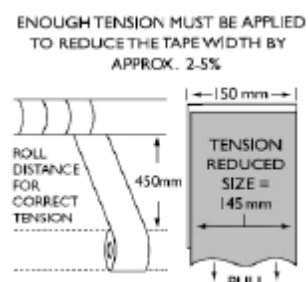
Select the same width of T280-30 OUTER WRAP TAPE as the inner wrap tape used. The wrapping starting and finish points should overlap the edges of the INNER WRAP TAPE by 25mm. The overlapped sections must contact the primer on the pipe surface. Compound side of tape is to be placed down on to the inner wrap tape. Ideally maintain sufficient tension to reduce the width of the tape by 2-5% to ensure that the tape conforms to the inner wrap tape surface without gaps. Once again for ease of application use an ECOTAPE WRAPPING MACHINE Model ECOMAT. Overlap each turn by 25mm (3 layer finish) or 55% (4 layer finish). Start new rolls by overlapping the ends by one tape width.



**Fig 3. Start at the 9 o'clock position.** Apply tape whilst primer is still tacky.



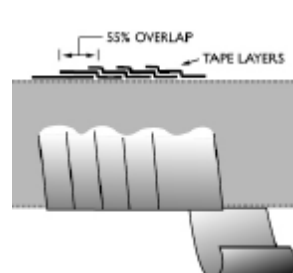
**Fig 4. Diagram showing the correct application of tape.**



**Fig 5. Diagram showing the correct tension for wrapping tape**



**Fig 6. Starting a new roll of tape.**



**Fig 7. Overlapping each turn by 55% effectively gives a double layer thickness.**