VivaxCoat® Repair

Preparation

Important information

- Repair site max. 10 x10 cm
- Repairs must be carried out with the same **VivaxCoat® system** as the existing system.
- Undamaged layers of the system structure can be retained and do not need to be removed. (PLASTELEN® Primer, PLASTELEN® Tape, BUTYLEN Tape)

1. Surface preparation

- Remove loose coating, smooth out grooves and hollows.
- Adjacent coating must be completely free of dust, sand and other surface contamination at least 200 mm to the right and left of the damaged area and around the entire circumference. Any contamination that affects adhesion must be removed before application. Roughen the entire coating around the repair area in the peripheral direction with abrasive cloth #40.
  Then clean the surface.

2. Repair the defect

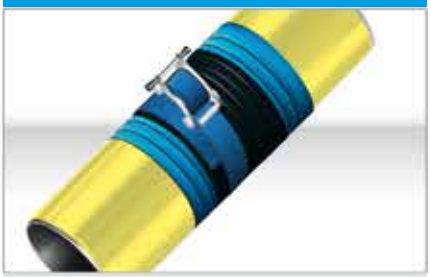
- If the damage extends to the steel surface, the entire system structure must be restored in **the original thicknesses.**
- Apply **PLASTELEN® Primer** to the steel surface in the damaged area by hand or with a spatula.
- Cut the **PLASTELEN® Tape** to the size of the damaged area and apply strip-by-strip.
- Cut the **BUTYLEN Tape** to the size of the damaged area and apply strip-by-strip.

3. BUTYLEN Primer application

- Prior to application, mix **BUTYLEN Primer** thoroughly in the original container until no sediment remains (see product information).
- Make sure that the surface to be coated is clean and dry. Otherwise clean and dry the surface again.
- Coat the defect and the roughened adjacent coating evenly and apply a thin layer.

Caution: Let the primer cure until it is no longer sticky (finger test).

4. BUTYLEN Tape application



- Wrap **BUTYLEN-AS50** (VivaxCoat®-LT/-MT) or **BUTYLEN-ET100** (VivaxCoat®-HT), as the mechanical protective tape, **in the original number of layers**, in a spiral with a 50% overlap and under uniformly strong tension.
- Wrapping starts/ends at least 150 mm to the right and left of the damaged area, wrapping in the peripheral direction without any offset.
- The start and end edges of the tape (between 8-10 o'clock positions) must point towards the bottom of the pipe.
- For efficient application, we recommend using a **DEKOMAT®** wrapping device.

5. Test

After applying the **BUTYLEN Tape** a high-voltage test can be performed according to relevant standards.
We recommend the use of spiral or rubber electrodes.

Product	Nominal size	Recommended roll width (mm)	Product temperature °C (°F)	Surface temperature °C (°F)	Ambient 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				
Safety and environmental protection	During all application steps, you must wear appropriate personal protection equipment, such as safety shoes, helmet, protective goggles and gloves, as prescribed by local health and safety regulations.					

DEKOTEC GmbH
Felderstrasse 24 | 51371 Leverkusen | Germany
Phone: +49 214 2602-0 | info@dekotec.com
www.dekotec.com

06.2021