

Pipe Line Repair Products

To ensure maximum performance, store Berry Plastics CPG products in a dry, ventilated area. Keep products sealed in original packaging and avoid exposure to direct sunlight, rain, snow, dust or other adverse environmental conditions.

Avoid prolonged storage at temperatures above 35°C (95°F) or below -20°C (-4°F). Product installation should be done in accordance with local health and safety regulations.

These installation instructions are intended as a guide for standard products. Consult your Berry Plastics representative for specific projects or unique applications.



Epoxy Primer



Meltstick



Patch



Material and equipment

- Appropriate tools for surface abrasion: grinder, scraper, sandpaper, sanding disk P24
- Hot air tool (min 3000 Watt) and power supply
- Tools: Roller, spatula, knife, marker, measuring tape
- Tools for cleaning: rags, approved cleaner: e.g. ethanol
- Propane gas bottle, regulator and gauge, hose and gloves
- Digital thermometer
- Standard safety equipment as prescribed by local regulations



For a major repair with exposed steel, the epoxy layer will also be repaired. Using a marker, mark a rectangle 50mm beyond the damaged area on all sides. Measure the dimensions required for the PERP-PP patch to cover this rectangle. Cut 4 corners off of patch to avoid lifting of corners.



Using a grease and lint-free rag, clean the damaged area with an approved cleaner (i.e. ethanol, isopropanol,...).



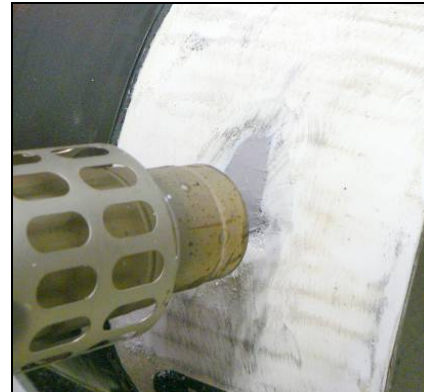
Using a grinding tool, bevel the edges of the damaged area to a 30° angle. Also abrade the surrounding line coating of the area to be repaired. The exposed steel or FBE shall also be abraded and rust has to be abraded away. When the area is relatively large, the steel should be grit blasted to SA 2 ½.



Follow the instructions supplied with the S1401 epoxy kits for preparation, mixing and application of the epoxy.



Ensure all FBE and exposed steel is covered to a uniform thickness of 150-200µm (6-8 mils). Avoid as much as possible applying epoxy on the PP-line coating.



Using the hot air tool, heat the area to 80–100°C. Avoid holding the hot air tool in the same place to prevent local overheating of the PP. The PP shall not start to melt; only a slight gloss must be attained. Epoxy must be dry to the touch before applying the PP-meltstick.



Heat the tip of the PP-Meltstick with the hot air tool. Apply the molten material of the PP-Meltstick into the damaged area by turning the stick.



The applied repair material needs to be smoothed with a spatula. If necessary, grind or scrape to achieve a flush finish with the PP line coating after cooling of the PP-Meltstick material.



Using the hot air tool, heat the area to 80–100°C. Using the digital thermometer, ensure the correct temperature has been reached. Avoid holding the hot air tool in the same place to prevent local overheating of the PP. The PP shall not start to melt; only a slight gloss must be attained.



The heat needs to penetrate through the line coating to the steel, otherwise the surface of the line coating loses its heat too fast. Measure the temperature of the surface at least 15 seconds after passing the hot air tool over the surface.



Using the hot air tool, heat the underside of the patch to soften it, and heat the repair area at the same time. Gradually place the PERP-PP patch on the repair area.



Using the propane torch and a medium flame, uniformly heat the entire PERP-PP patch. Using the roller, carefully roll the patch from the middle to the edges. Repeat the heating and rolling steps until air entrapments have been removed.



Check the adhesion of the patch by retracting the backing slightly. If required, reheat with the torch and roll the patch again.



Completed installation

Patch is correctly installed when all of the following have occurred:

- There are no upstanding edges.
- After patch is cool, adhesive is protruding on the edges.
- The patch has fully conformed to the coating.

Berry Plastics warrants that the product conforms to its chemical and physical description and is appropriate for the use stated on the technical data sheet when used in compliance with Berry Plastics written instructions. Since many installation factors are beyond the control of Berry Plastics, the user shall determine the suitability of the products for the intended use and assume all risks and liabilities in connection herewith. Berry Plastics liability is stated in the standard terms and conditions of sale. Berry Plastics makes no other warranty either expressed or implied. All information contained in this technical data sheet is to be used as a guide and is subject to change without notice. This technical data sheet supersedes all previous data sheets on this product.



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