

Application manual

Pipe surface has to be dried, cleaned and degreased accord. to DVGW-regulation GW15. PE-cleaner is recommended for degreasing. Roughen the dry pipe surface with emery cloth. The temporary edge protection paint at the transition from PE to steel has to be removed.

Drying the surface shall happen with a soft propane flame. The temperature of the pipe surface has to be $\geq 5^{\circ}\text{C}$ and the tape has to be warmer than 10°C . At the transition to steel the PE-coating has to be beveled on an angle of max. 30° in optimum with a PE-rasper. All lose parts as well as polish and emery flakes have to be removed.

The dry and clean surface including about 100mm of the factory coating has to be painted with **Primer HT** well before handling (**Primer 700 for MonoTape 710.35**).

The primer drying time is about 5 to 10 min. in average (finger proof), the consumption is about $0,25\text{l/m}^2$. After about 6 hours or a new contamination, the priming process has to be repeated. Higher profiles, e.g. a welding seam bead have to be adjusted with a filler if necessary to guarantee a hollow-free application.

Wrap the tape under slight tension with 50% overlap (first layer), in doing so remove release layer. Overlap beginning end of wrapping to itself and minimum 50mm on the factory coating. Overlap the first wrapping of a new roll when attached and also include the end piece of the previous roll 100 mm.

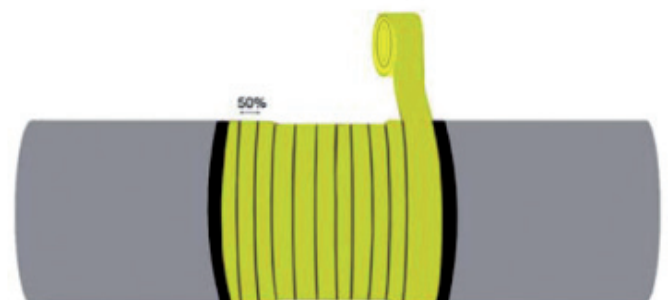
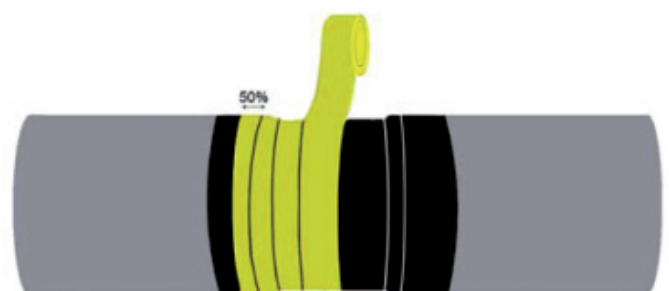
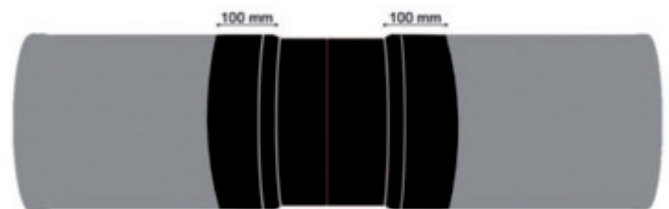
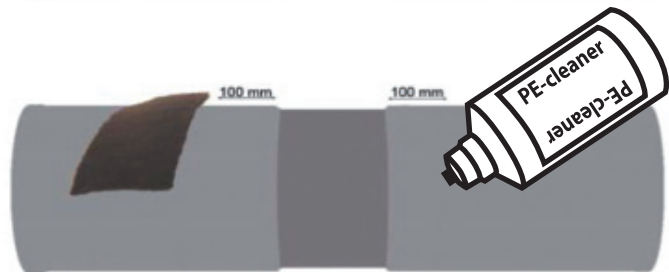
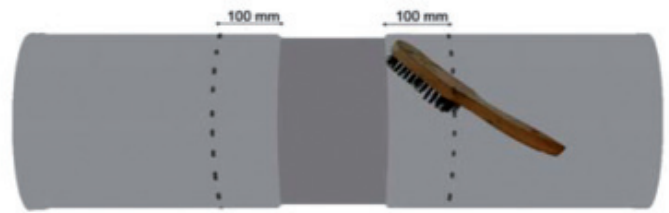
As outer layer apply a further wrapping on top under slight tension. The class C/50 is reached with minimum overlap of 50% (all together 4 layers) and the class B/50 with an overlap of about 10mm (all together 3 layers). The outer wrapping should cover the inner one of about minimum 10 mm at both ends.

Class B/30 can be reached with 1 x 50% MonoTape 710.35.

The end of the tape should point down without tension and pressed on firmly.

Before back filling or a destroying test the corrosion protection system should amalgamate for **minimum one hour**.

The warranty of 4pipes GmbH is limited to the material and its substitute when faulty. The user takes the responsibility for application and handling of the tape.



ATTENTION:
Always use safety
equipment!

