

Fibercoat Ultra 4 pipes

Application instructions

- **Do not apply inside closed rooms**
- **Clean, dry, degrease** pipe surface, roughen with sand paper (corn 40-50)
- **Apply in a shaded area!**
- **Spiral wrapping** (2 to 8 layers)
- **Wrap tightly** and after that **overwrap with clear foil**
- During work interruptions, **secure transition zone from light** (e.g. with adhesive tape or the black packaging foil) to continue on non-hardened material, wet-in-wet
- **Working time max. 5 minutes**, max. 10 minutes when cloudy
- **Protection against direct UV-light is mandatory**, e.g. with a tent during application
- **Protect skin and eyes (with sunglasses) against UV-light! Do not work near active UV-spots!**
- Wrapping and hardening **up to 8 layers in one single process** is possible
- The **shady side of the pipe should be hardened with a UV-lamp** (2 UV-lamps minimum)
 - Distance lamp to pipe approx. 500 mm
 - Number of lamps should be higher on larger pipe diameters
 - The complete pipe surface must be covered by UV-light
 - Hardening time 5 minutes / layer at 20°C (e.g. 20 minutes for four layers)
 - Proceed in 500 mm steps along the pipeline
- Intense UV sunlight can help to shorten the curing time.
- For coating of pipes and coating systems for trenchless applications **consider valid DVGW-regulations**
- Optimum **application temperature +5°C up to 25°C**
- **Prevent pollution of the material**, otherwise this would lead to hardening failures
- Application always accord. to **regional standard health and safety regulations**
- Material must be **hardened fully** before mechanical load is applied (**shore D 80 ±**)

To coat pipeline parts e.g. welded joints, wrap on the mill coating should overlap **at least 200 mm on both sides**. The wrapping has to be applied as flat to the surface as possible to avoid any harsh edges. For a final quality check, apply a test piece to the most-tricky area. Remove this piece before deployment and carry out a hardness measurement. A warranty for Fibercoat Ultra 4 pipes is limited to replacement of faulty material only.

The 4 pipes warranty only applies to faulty material. Checking the suitability of the product for the individual application is solely the responsibility of the user.



Description	Art.-No.
Roll 150 mm x 15 m	16708
Roll 300 mm x 15 m	16709
Adhesive tape transparent 50 mm x 66 m	16760
Stretch foil 0.5m x 300m, 20 µm thick	16765
Gloves for Fibercoat Ultra application	16770
UV-Spot 400 Watt	16750
Shore D measuring tool with drag indicator for hardness test of Fibercoat Ultra	20304



Application video



Shore D Measuring Tool



UV-Spot

