METHOD STATEMENT

iSTIK™ 150PVC

COLD APPLIED CORROSION PROTECTION TAPE FOR PIPES

INNOBIT INDUSTRIES LLC

PO No:3343, New Industrial Area,
Umm Al Thoub, Umm Al-Quwain, UAE

info@innobit.me

+971 6 706 9111

www.innobit.me

INNOBIT®

1.0 GENERAL

This method statement covers the systematic procedures to be followed for protection of pipes with **iStik150PVC**

1.1 This Method Statement is a specific system application procedure and may not be applicable to all site situations. Site Conditions will vary and the equipment to be used, materials and techniques need to be modified as per site situations. Please consult INNOBIT Technical Customer Services for any other specific method statements to suit the particular situations.

1.2 Please refer following documents in conjunction with this Method Statement:

The latest Technical Data Sheet (TDS) of **iStik150PVC**

Material Safety data sheet (MSDS) of **iStik150PVC**

1.3 The performance of the system is always dependent on placing in position & proper adhesion to the substrate during the application. So the following work conditions are to be followed for the optimum adhesion and proper placement of the Product.

1.3 Store the product between 10 and 25°C in a cool, covered dry place. Protect from extreme temperatures such as frost and rain.

1.4 The tools required for placing the adhesive and aligning the product such as measuring tape, spatula and scraper shall be kept handy.

1.5 The surface shall be cleaned thoroughly of all contaminants like dust, traces of oil and grease.

3.0 MATERIAL

iStik150PVC

4.0 **Equipment required during application**:

- Protective clothing: Gloves, face mask, overalls, and goggles.
- Blasting equipment for surface preparation.
- Measuring tape
- Strong brush or tooling scrapper / Spatula.
- Pipe wrapping machine.
- Cleaning Solvent.

The application temperature should be between 10°C to 45°C

5.1 SUBSTRATE PREPARATION

Surface shall be cleaned using propelled abrasive to remove all rust, mill scale, weld spatter, dirt, dust, grease
and other loose or deleterious matter to provide a surface finish equivalent to SA 21/2, SIS 05 5900.
Where applicable, factory-coating ends shall be wire-brushed for a minimum distance of 150mm and solar
protective coating shall be removed. Coating ends shall be levelled using a hot knife or similar approved
process.

5. 2 PRIMING

iKote SB41 Primer shall be applied immediately following completion of surface preparation in accordance with AWAC209 – 76 section 3.3.
All surfaces to be wrapped shall be primed and allowed to dry.
Primer application shall be limited to the area that can be wrapped during the working day, after which
repriming or stripping and repriming shall be required.

5.3 APPLICATION

Tape shall be applied in a spiral fashion by hand or hand operated machines to provide a 55% overlap (or as specified) and with sufficient tension to give constant adherence without voids or wrinkles.
Interleaving shall be removed and discarded as wrapping proceeds.
The tape wrapping shall commence and finish to give a minimum of 150mm overlap to factory applied
coating. On completion of the wrap, the surface of the tape shall be smoothened gloves hands to ensure
completely sealed overlap and absence of air pockets under the tape.

5.4. BURIED VALVES AND FITTINGS, etc

Buried valves and fitting etc shall be coated and protected to achieve the same standard of protection as to the pipe. After surface preparation and priming, all protrusion and indentation shall be fully profiled with the moulding putty iKote AP35 to a smooth continuous shape before tape wrapping. Valves shall be wrapped up to stem level. Wrapping of irregular shapes shall be to the approval of the Engineer.

5.5 CABLE / PIPE CONNECTIONS

Welded stud and soldered cable / pipe connection shall be coated to the same standards as the pipe to which it is attached. After completion of cable connection, the cable tail shall be

secured to the pipe with a lap of tape. The cable connection shall be cleaned, primed and profiled with mastic before tape wrapping. Cleaning and priming shall be as detailed above. The tape wrap shall have a minimum of three and a half circumferential overlap.

5.6 BONDING / OVERLAP OF BACKING

Where required the tape shall be capable of being cigarette wrapped around the pipe and with the adhesive removed, the PVC backing shall be bonded over its full overlap to PVC layer beneath with suitable PVC adhesive.

6.0 INSPECTION

Inspection of coated pipe joints, fitting etc. shall be visual for satisfactory adhesion and 100% holiday inspection by a holiday detector set at the working voltage. The applied tape shall be inspected to confirm that effective bond of formed between the pipe surfaces and the tape. This inspection shall be carried out not less than 24 hours after application. The working voltage shall be set at least twice per working day. Specific inspection upon completion of works may be required by certain project specification.

7.0 PRECAUTIONS

Wrapping by hand or machine must be undertaken by experienced personnel under proper supervision. Unsatisfactory workmanship shall be rejected especially where overlaps are not consistent and where rocking is evident. Rucking, especially at in-situ joints are to be avoided. Awkward and abrupt changes in shape shall be subject of special attention and care during wrapping, ensuring elimination of entry paths for ground salts.
Handling after wrapping must not allow any slings etc. to bear on wrapped areas. Write or rope slings shall not be used.
Wrapped pipes must be supported on unwrapped ends of pipe and not laid on the ground except as necessary in the trench for final laying. Wrapped pipes shall be protected from direct sunlight at all times.

8.0 CLEANING

Clean all tools with a cleaning solvent immediately after use.

9.0Technical Customer Service.

Please note only INNOBIT Technical Customer Services are permitted to change any of the information in this method statement or to provide any further recommendations concerning the use of this product.