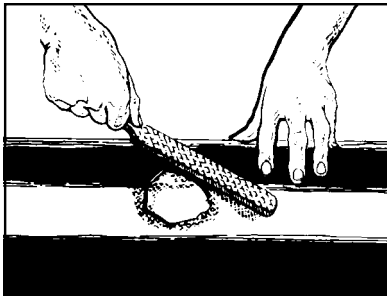




Materials and equipment

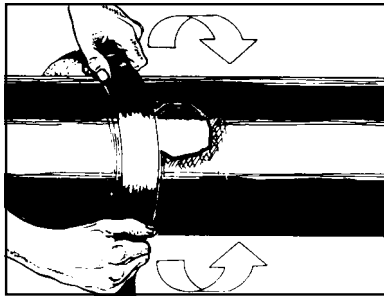
1. Roll of PERP repair tape
2. Roll of PERPFILLER tape
3. Wire brush, knife
4. Propane tank regulator, Raychem torch or equivalent
5. Contact pyrometer
6. Standard safety equipment as prescribed by local regulations

Installation has to be done according to local government regulations and usual safety precautions.

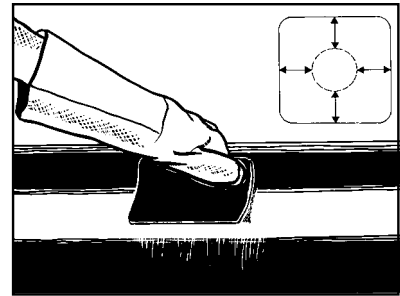


Preparation

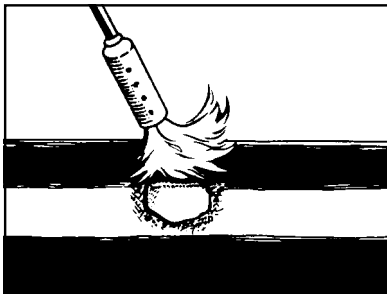
1. Remove loose coating from the damaged area with a knife, scraper or wire brush. Eliminate all sharp edges and clean the damaged area and adjacent coating to remove all foreign material such as dirt, rust, oil, grease and moisture.



2. Abrade adjacent PE coating extending 100mm (4") beyond the damage.



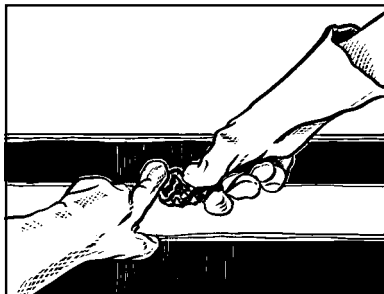
3. Cut a patch from the PERP tape so that it extends at least 50 mm (2") beyond the damaged area. Round off the corners.



Preheating

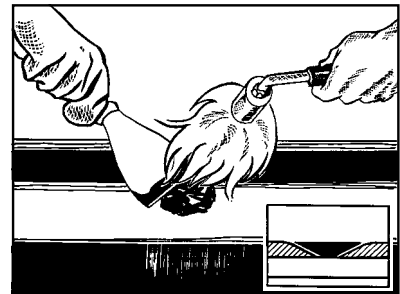
1. Preheat the exposed bare metal and adjacent pipe coating to following temperatures:

	line coating	bare metal
PERP	70-80°C (158-176°F)	70-80°C (158-176°F)
PERP 80	90-100°C (194-212°F)	70-80°C (158-176°F)
PERP 120	150-180°C (302-356°F)	70-80°C (158-176°F)



PERPFILLER application

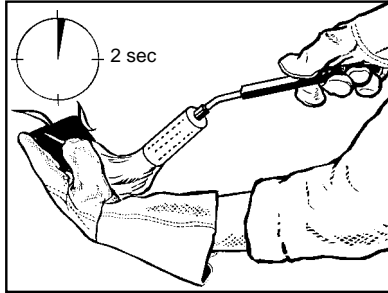
1. Cut PERPFILLER to size and apply it to all areas of exposed steel.



2. Heat the mastic and smooth it down with a paint scraper to cover all bare metal without air entrapments. Avoid traces of PERPFILLER on top of the PE coating.

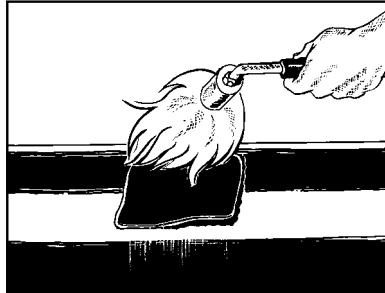
Note (*): PERP 120 only suitable for FBE and PE line coatings.

PERP*



PERP application

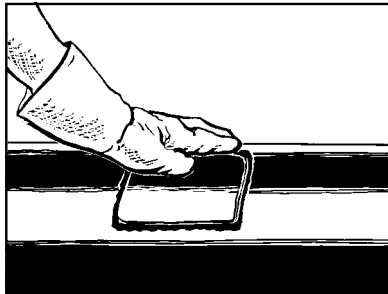
1. Flame brush the adhesive side of the PERP patch until the adhesive becomes glossy.



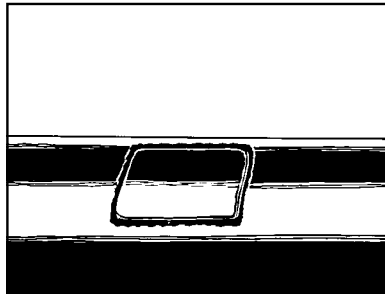
2. Position the precut PERP patch over the damaged area and heat until the adhesive melts. Roll out any entrapped air with a silicone roller.



3. Check that adhesive is soft to the touch of a gloved finger.



4. Smooth the repair patch with a gloved hand to eliminate air entrapments and ensure good bonding. Avoid squeezing filler between PERP and the line coating.



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

- 1) There are no upstanding edges.
- 2) After patch is cool, adhesive flow is evident on the edges.
- 3) The patch has fully conformed to the coating.