

STOPAQ® PE REPAIR PATCH

Product Information

Product description: Stopaq® PE Repair Patch is a coating repair patch for plant-applied PE pipeline coating. It is made of a radiation-cross-linked, unexpanded high density polyethylene backing with a copolymer adhesive. Stopaq® PE Repair Patch is used as mechanical protection applied on Stopaq® corrosion preventative products such as Stopaq® Paste CZH and Stopaq® Wrappingband CZH.

Features:

- Excellent adhesion to plant-applied PE pipeline coatings
- Resistant to high shear forces

Benefits:

- Adaptable repair system
- Fast and easy installation

Application examples

Pipeline coating spot repair: Repair of damages to plant-applied PE pipeline coatings that occurred during pipe transportation, storage or pipe laying.

Coating of pin brazes for Cathodic Protection: Provides mechanical protection to Stopaq® corrosion preventative products against impact, indentation and shear forces.

Product properties of Stopaq® PE Repair Patch

Thickness (as supplied)	Backing: 0,76 mm [30 mils] Adhesive: 0,80 mm [31 mils]
Temperature range	Operational: Max. 70 °C [158 °F]
Tensile strength	17 MPa [2450 psi] (ASTM D638) *)
Elongation at break	400 % (ASTM D638) *)
Hardness	55 shore D (ASTM D-2240) *)
Lap shear strength	0,10 N/mm ² [14.5 psi] (EN 12068) *)
Adhesion	Peel strength to plant coating PE (EN 12068): – @23 °C [73 °F] ≥ 10 N/mm [1000 ozf/in] *)
Impact resistance	≥ 15 J [132 in.lbf] (EN 12068) *)
Indentation resistance	Pass when tested with 10 N/mm ² [1450 psi] @ 70 °C [158 °F] (EN 12068) *)

*) typical values

General order information

Product	Stopaq® PE Repair Patch is available in rolls, packed in cardboard boxes:
Art. Nr.: 1360	Product dimensions and contents: 450 mm x 10 m [17.7 in x 33 ft], 1 roll/box
Handling	Handle with care. Keep boxes upright.
Storage	Store indoor, clean and dry, away from direct sunlight in a cool place below +40°C.

Application instruction - Brief version

See specific Stopaq coating instructions for coating repair, pin-brazes, etc.

Tools, equipment and auxiliaries	– Gas torch, temperature probe, measuring tape, marker pen, knife, scissors, abrasive pads, sand paper (coarse grit), siliconized roller, SFL™ Substrate Cleaner, lint-free cloth. – Personal protective gear: heat protective gloves, goggles, etc.
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Application instruction - Brief version (continued)

Additional coating materials	Prior to application of the Stopaq® PE Repair Patch, bare steel surfaces must be coated with Stopaq® corrosion preventative products like: – Stopaq® Paste CZH – Stopaq® Wrappingband CZH
Cutting to appropriate size	Cut a piece of Stopaq® PE Repair Patch from the roll that is sufficiently large to overlap the adjacent pipeline coating by at least 50 mm [2"] on all sides. Round the square corners by cutting them off.
Surface preparation of existing coating	Sharp and protruding parts of existing pipeline coating must be cut away. Edges of existing pipeline coating must be bevelled with a slight angle. A sufficiently large area of existing coating around the repair spot must be sanded, such in order to ensure proper adhesion of the Stopaq® PE Repair Patch. The sanded area must exceed the dimensions of the Stopaq® PE Repair Patch to be applied. After sanding the surface must be cleaned with SFL™ Substrate Cleaner and a lint-free cloth, and the surface shall be free from dust, soil, grease and other contaminants.
Preheating of existing coating	Preheat the adjacent existing coating to a temperature of approx. 70°C [158 °F]. Avoid excessive heating of Stopaq® corrosion preventative products, existing coating, and cables for cathodic protection.
Application	Place the Stopaq® PE Repair Patch on the repair spot, the existing coating must be overlapped by at least 50 mm [2"] on all sides. Gently heat the Stopaq® PE Repair Patch from the centre towards the edges using the gas torch. Avoid excessive heating of Stopaq® corrosion preventative products underneath. Use the siliconized roller to achieve adhesion of the patch to the existing coating and to remove any air inclusions. The adhesive should become visible at the edges. Rolling the area coated with Stopaq® corrosion preventative products should be avoided. The embossed pattern initially present in the product will vanish when sufficient heat has been applied.
Handling and commissioning after installation	Objects coated with Stopaq® PE Repair Patch should not be exposed to excessive loads before cooling down to ambient temperature. Burying is possible after the coating has cooled down to ambient temperature. Backfill and compact with clean sand and filling material without sharp stones or hard lumps of soil.

Information

Documentation	Extensive information is available on our web-site. Application instructions and other documentation can be obtained by contacting our head office, from our local distributor or by sending email to info@sealforlife.com
Certified staff	Application of the described coating system should be carried out by certified personnel.