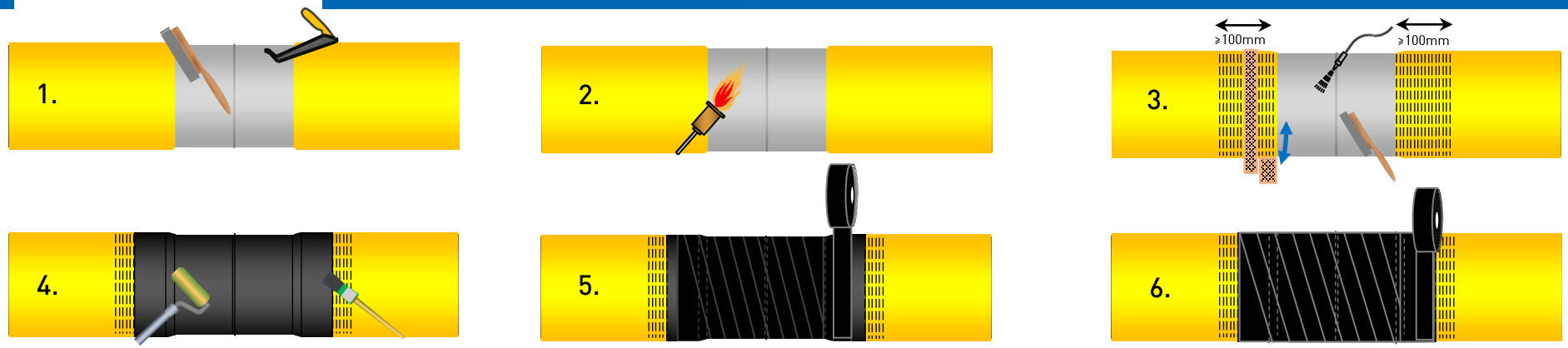
Application manual
Kebulen-Tape B 80-C



1. The area to be coated must be free of contaminants such as dirt, grease, rust and the temporary end protection. These must be removed with a suitable solvent, e.g. PE cleaner. As a rule, the edges of the factory coating are beveled. It must be ensured that no cavities can form under the coating. If this cannot be ruled out, the edges must be beveled to approx. 30° using a suitable tool, e.g. a rasp with a half-round blade.

2. The area to be coated must be dry before processing, if necessary it must be dried with a propane torch. Preheating of the area is not necessary. The factory coating must not be overheated in the process. The surface temperature has to be at least 3 °C above the dew point.

3. For every 100 mm of the adjacent factory coating, roughen in the circumferential direction with lubricating gel cloth or a hand wire brush. Optimum results are achieved by solid-state blasting. The target surface roughness is 50-100 µm.

4. The **Kebutyl Primer K III** is applied to the entire post-painting area with a brush or paint roller. The drying time is about 3-5 minutes, depending on the weather conditions (touch dry). The primer must be stirred thoroughly before use. Consumption is approx. 0.2 l/m^2. The primer must evaporate independently and must not be dried with a flame!

5. **Kebulen-Tape B 80-C** is wrapped in a ring-shaped coil starting and ending, wrinkle-free, spirally with 50 % overlap. The separating layer must be removed during the process. The adjacent factory coating is included by at least 50 mm. Areas at risk of cavities (e.g. high weld seams) must be padded with **Kebutyl mastic** before wrapping.

6. Like the first wrapping **Kebulen-Tape B 80-C** is wrapped in a ring starting and ending under tension in a spiral shape with 50% overlap (Load class C) or 25% overlap (Load class B). The tape must completely cover the previously applied inner layer. An overlap of at least 25-30 mm is recommended. At the end of the winding, in the sloping 3 o'clock position, place the last 100-150 mm of the outer tape on itself without tension and press down firmly by hand.