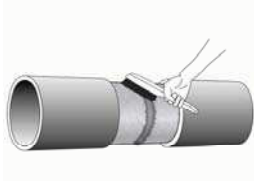


HDD FIELD JOINT COATING

RD-6[®] Corrosion Coating and IRO[™] – Impact Resistant Outerwrap

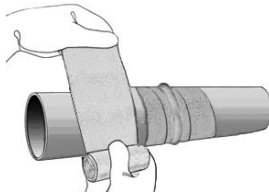
IRO Quick Application Guide:



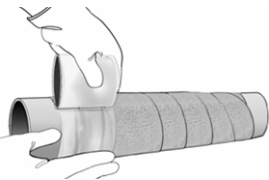
Clean and roughen surface and de-gloss an area extending a minimum distance of 6" on either side beyond the **RD-6**. Dry pipe if wet. Remove any oils, greases or other foreign debris from surface with solvent cleaning.



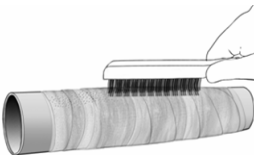
Water is needed to activate the **POLYGUARD IRO**. Remove roll from foil pouch and submerge in tepid water for 10 seconds. Note: water could also be poured into the pouch. Once opened, the **POLYGUARD IRO** cannot be repackaged.



The **POLYGUARD IRO** application should start on the side of the filed joint that will be pulled into the hole first. Begin the application of the **POLYGUARD IRO** at a minimum distance of 6" beyond the **RD-6** and spiral wrap using a 75% overlap. The **POLYGUARD IRO** should be applied in same direction as the **RD-6** was applied. Apply pressure during application by pulling firmly on the roll as it is applied. Squeeze and mold firmly in the direction of the wrap.



Apply compression film in the same direction as the 2 previous layers, starting beyond the outer edge of the **POLYGUARD IRO**, pulling firmly during application. Apply 2 layers of compression film over the entire composite area.



Perforate the compression film using wire brush (or other perforating device) by tapping firmly on the tape with the metal bristles. Perforation allows the CO² gas generated by the curing process to escape. Remove compression film after 10 minutes.

Once the **POLYGUARD IRO** has cured, during compression film stage, the pipe can then be pulled. **POLYGUARD IRO** reaches a hardness of 70d in 30 mins @ 75°F (24°C).

X:/Lit/Mechanical/2012/IRO HDD Quick App.doc R.3-15-12