

POLYGUARD® 606 FILLER TAPE AND RD-6® APPLICATION INSTRUCTIONS FOR PROTECTING WIRED CONNECTIONS TO PIPELINES

(Store and handle material according to RD-6 and 606 Filler Tape application general instructions)

1. Use company approved methods to connect the wire to the pipe. In the area of the connection remove any visible coating, corrosion, dirt or debris with a wire brush or other company approved method. Oil, grease or other hydrocarbon contamination shall be removed by using the appropriate company approved solvent.
 - 1.1. Remove any disbonded or damaged coating from the coating edge of the existing pipe coating.
 - 1.2. Remove any weld splatter or other pipe defects by company approved method.
2. If moisture is present remove from pipe using the appropriate torch. The heat from the torch is applied to the exposed steel area; the flame from the torch is not to be directed at the adjacent coating wiring. Only the steel in the exposed area of the pipe surface should be heated to at least 5° F (3° C) above the dew point.
3. Pipe surface should be heated to above 45° F (7° C) prior to application, regardless of presence of moisture.
4. It is recommended the metal surfaces be blasted to SSPC-SP-6, (NACE 3), commercial blast. If blasting is not feasible, then a power buff (SSPC-SP3) or hand wire brush (SSPC-SP2) is recommended to remove all loose and foreign materials. [This step may be performed before the thermite weld is attached.]
5. If coated, the surrounding coating should be cleaned, and brush blasted or abraded approximately 6 inches back from the edge of the cleaned area on each side of the weld, taking care not to remove an excessive amount of the existing pipe coating.
6. For thicker coatings, the edge of the existing coating shall be beveled to at least a 45° angle from the steel surface by grinding or buffing.
7. Using a dry, clean cloth or brush to clean the exposed area and adjacent mainline coating to remove any dust left from blasting or brushing before applying primer.
8. Apply a thin coat of **Polyguard® 600 Liquid Adhesive** to all surfaces to be coated including the exposed metal at the connection. Ensure that the 600 Liquid Adhesive extends at least 2 inches past where the **Polyguard RD-6® Coating** will begin and end on the main line coating.
9. Allow liquid adhesive to dry (to a tacky state). Time to dry to a tacky state may vary depending on ambient and surface temperatures.

10. Cut a 3" x 3" (or larger) piece of **Polyguard 606 Filler Tape** and remove the release liner from one side. Place it over the connection area and ensure a good seal with no air pockets or voids by pressing and squeezing by hand using the remaining release liner, then remove the remaining release liner. (Figure 1)



Figure 1

11. Cut two pieces of 6" or 4" wide **Polyguard 606 Filler Tape** 8 to 10 inch in length. [The width of the **Polyguard 606 Filler Tape** may be less according to the area exposed and pipe size.] Split two pieces of the **Polyguard 606 Filler Tape** in the longitudinal direction at least 4 to 6 inches and centered in the strip. Cut a third piece of **Polyguard 606 Filler Tape** 10 to 12 inches in length, but do not split.

12. While holding up the wire, apply one piece of the split **Polyguard 606 Filler Tape** to the pipe surface by removing the release liner on one side of the **Polyguard 606 Filler Tape** and placing the split area over the connection area, and pipe by pressing using the remaining release liner. Remove the remaining release liner. Overlap one side of the split area over the other on the other side of the connection. Use a piece of the release liner to press the **Polyguard 606 Filler Tape** to seal it around the connection. (Figures 2 & 3)



Figure 2



Figure 3



Figure 4

13. Use the other piece of the split **Polyguard 606 Filler Tape** and apply it in the same manner (under the wire) as in step 12, but in the opposite direction. (Figure 4)

14. Take the un-split piece of **Polyguard 606 Filler Tape** and remove one side of the release paper. Place this piece over the entire wire and the connection area. Press and seal this piece around the wire using the remaining release liner. Remove the remaining release liner. (Figure 5)

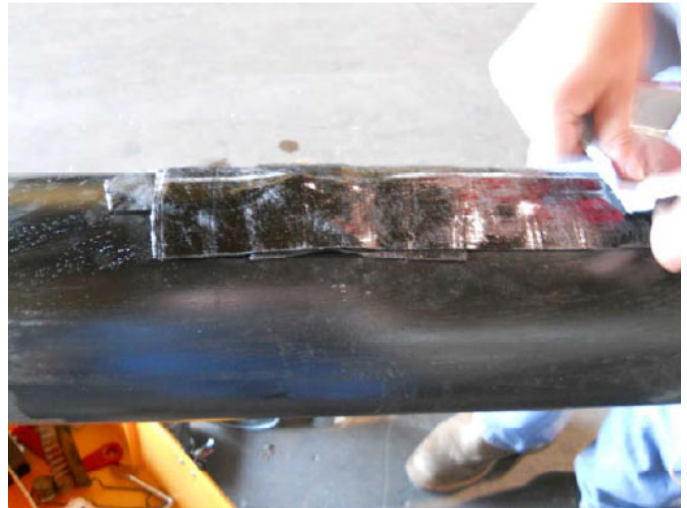


Figure 5

15. This area can now be coated with the **Polyguard RD-6** to provide additional protection to the connection area. It is recommended that the entire area be spiral wrapped using the normal **Polyguard RD-6** procedure. If the entire pipe is not exposed, use strips of **Polyguard RD-6** applied over the area after cleaning and priming. Be sure to seal all areas by pressing and working the compound into any void areas. (Figure 6)

16. Continue to spiral wrap to completely cover the area with **RD-6**. (Figure 7)

17. Complete the process by applying the **Polyguard SP-6 Outer wrap**. (Figure 8)



Figure 6

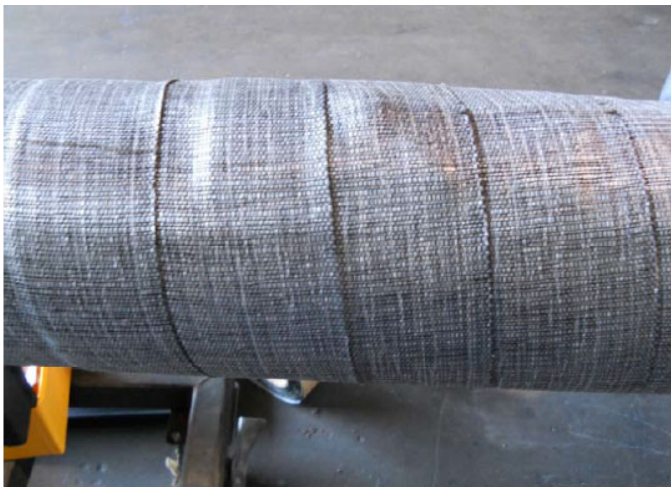


Figure 7



Figure 8