External coating repairs

The contractor is responsible for analyzing and eliminating any risks during installation (especially the use of personal protective equipment).

1 EQUIPMENT AND TOOLS REQUIRED

• Gloves, protective mask and goggles
• Brush, abrasive paper and cutter
• Spatula, mastic knife
• Paintbrushes, roller
• Gas burner
• Adhesive roller

2 PIPES WITH A BIOZINALIUM AND ZINALIUM EXTERNAL COATING: Natural, Integral, Blutop, Topaz, Tag 32

Brush to remove any dirt or loose particles.

Dry the surfaces to be coated (in case of low temperatures or high humidity, use a gas burner).

If the iron is exposed, apply high-zinc anticorrosion primer NATZINC (ref. 251222) with a paintbrush with vertical and horizontal strokes.

Allow to dry for a few minutes.

Apply AQUACOAT paint with a paintbrush (NATURAL/BLUTOP Blue ref. 240991 – INTEGRAL/TAG32/TOPAZ Red ref. 240990) with vertical and horizontal strokes.

3 FITTINGS WITH AN EPOXY EXTERNAL COATING: Natural, Blutop, Integral, Topaz (all versions).

Brush and clean the area to be touched up and then dry.

Apply the epoxy paint with a paintbrush or spatula with vertical and horizontal strokes.

• Natural / Blutop: EUROKOTE 4820 Blue (1 kg dose: ref. 158255)
• Integral / Tag32 / Topaz: EUROKOTE 4820 Red Brown (1 kg dose: 184653 or kit of five 50 ml syringes: ref. 220817)
• Standard TT PUX and Integral TT PUX: Eurokote 4820 Ivory (ref. 220818)
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4 PIPES WITH A ZINC AND SYNTHETIC PAINT EXTERNAL COATING

**Brush** to remove any dirt or loose particles.

**Dry** the surfaces to be coated (in case of low temperatures or high humidity, use a gas burner).

If the iron is exposed, **apply** high-zinc anticorrosion primer NATZINC (ref. 251222) with a paintbrush with vertical and horizontal strokes.

Allow to **dry** for a few minutes.

**Apply** ENDOLAC 245-30 FGC paint (ref. 158134) with a paintbrush with vertical and horizontal strokes.

5 PIPES WITH A POLYETHYLENE EXTERNAL COATING

5.1 Significant damage

**Roughen** the area to be repaired with abrasive paper.

**Clean and dry** the area.

**Preheat** to approximately 60°C.

**Fit** an open heat-shrink sleeve (reference on request).

**Wrap** the sleeve all around the pipe’s circumference using a gas burner and then fit the closing strip.

5.2 Moderate damage

**Repair kit** ref. 111216 comprising abrasive paper, mastic and a repair strip.

**Clean and dry** the exposed area.

**Cut off and remove** the damaged PE.
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Preheat to approximately 60°C. **Apply** the mastic and smooth with a knife. **Place the repair strip** with a 50mm overlap on the edges of the cut area.

**Heat** the strip with a gas burner until the heat-sensitive paint changes color. **Press** the strip down wearing appropriate gloves.

**5.3 Minor damage**

In case of minor damage to the TT coating, use the PE repair stick (ref. 175507). Using a brazing torch, heat the stick until it drips onto the damaged area and then smooth over.

**6 PIPES WITH A POLYURETHANE EXTERNAL COATING**

**Brush** to remove any dirt or loose particles and then **sand** to clean and roughen the surface. **Remove** any dust from the surface to be coated.

**Heat** with a gas burner to remove any traces of humidity.

**Apply** the product to the surface with a syringe (kit of five syringes - Eurokote 4820 Ivory - ref. 220818).

**Cover** with a sheet of PVC to smooth out and protect the product. Close with adhesive.

> **In case of major damage to the PUX coating, follow procedure 5.1 in the previous chapter.**
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**7 PIPES WITH A CEMENT EXTERNAL COATING**

**Prepare** the affected surface by removing the damaged and loose mortar.

**Brush** to remove any dirt or loose particles and then **clean** the surface.

**Prepare** the ZMU repair kit (DN 80 to 600: ref. 218842).

- Mix the dry components
- Add the liquid while stirring vigorously
- Leave for five minutes and then mix again

**Dampen** the surface.

**Fill** with mortar using a spatula and then smooth the surface.

(DN ≥ 700: ref. 158009)

**Prepare** the SIKADUR 3IDW mixture with three parts R (resin) and one part H (hardener). **Mix** to an even consistency.

Preferably **position** the area to be repaired facing downwards.

**Remove** any damaged and loose mortar.

**Clean** until spotless.

**Apply** the mixture and compact to ensure the correct thickness.

**Smooth** the surface.

**Minimum application temperature: + 5°C.**

**Cover** with plastic film or a damp cloth to maintain a high level of humidity and ensure that the mixture sets properly.

Optimal drying time: 2 hr 30 min.