

Field Repair of Polymer Laminate Barrier Coating

The CSP industry in Canada offers Polymer Laminated Galvanized Steel as a premium quality product providing extended service life and performance for corrugated steel pipe. If specific care is not taken in manufacture, handling and installation the tough barrier coat of polymer laminate can be breached, exposing the underlying galvanized steel. A number of liquid, paste and powder coat repair products are used by and are available from the CSP manufacturers. These materials have specific requirements with respect to temperature and surface condition and are best applied in a controlled environment.

Field repairs are best managed by applying **Denso Butyl 35 Tape** over any damaged area. This can be done at all temperatures and has been proven effective in a variety of construction site conditions. The tape is available from CSP manufacturers or from www.densona.com

Damage to the barrier coat can be minimized if impact and contact with hard or sharp objects is avoided.

Repair procedures are as follows:

1. With a clean cloth, wipe the damaged area removing any dirt, oil or water. Oil film can be removed with a solvent (Varsol) which should be allowed to flash off before the tape is applied. Removing surface shine with an abrasive pad (Scotch-Brite ® red) will improve the bond and should be considered as an extra measure if damage is located inside the pipe and below the water flow line. No primer application is required for these repairs.
2. Cut a piece of Denso Butyl 35 tape that is large enough to cover the damaged area allowing for a minimum of 1 cm coverage of the laminate all around the damaged area.
3. Remove blue backing from tape and place black tape over the damaged area.
4. Apply finger pressure to the tape forcing air from beneath and ensuring full contact with the surface of the CSP. Tape located over a lock seam should be pressed into any grooves.

Please direct any concerns or inquiries to the CSP manufacturer or to info@cspi.ca



APPLICATION BULLETIN / DENSO BUTYL 35



Leaders in Corrosion Prevention

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Denso Butyl 35 for repair of Polymer Laminated Corrugated Steel Pipe (PLCSP*)

The application of Denso Butyl 35 Tape is an approved repair method for PLCSP. Due to its high adhesive properties, Denso Butyl 35 Tape **Does Not Require a Butyl Primer** for repairs of damaged coating on New PLCSP.

Application (New Installations)

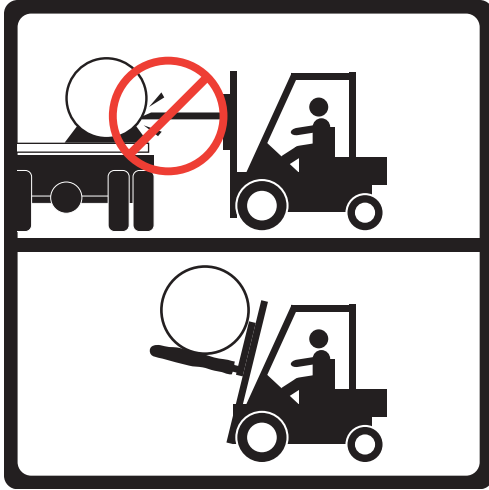
- Prepare pipe surface in damaged area by making sure it is clean and dry.
- Cut tape to length required to cover damaged area.
- Remove interleaving.
- Press adhesive side of tape firmly over damaged area.

Application (Old Installations)

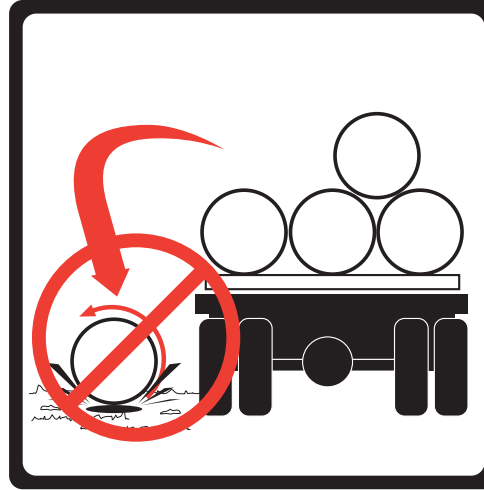
- Prepare pipe surface in damaged area by removing any rust and roughening the polymer surface with an abrasive pad. Make sure the area is clean and dry.
- Spray the repair area with Denso Butyl Spray Primer.
- Cut tape to length required to cover damaged area.
- Remove interleaving.
- Press adhesive side of tape firmly over damaged area.

*Note: PLCSP refers to Corrugated Steel Pipe Products as described in CSA G401-07

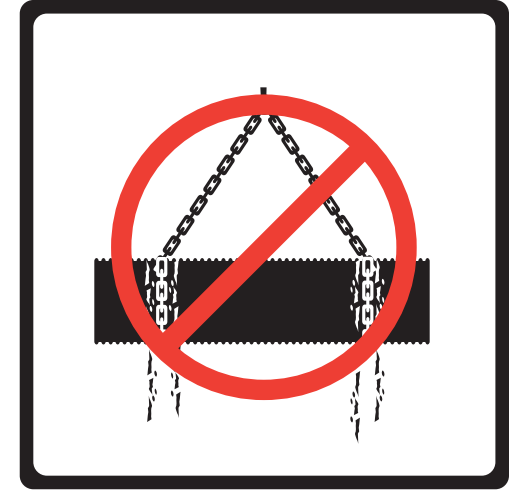
Handling polymer laminated CSP / Manutention des TTOG à strates de polymère.



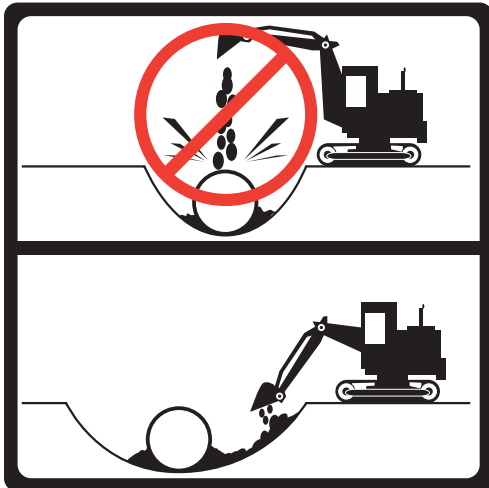
**AVOID IMPACT /
ÉVITER LES IMPACTS**



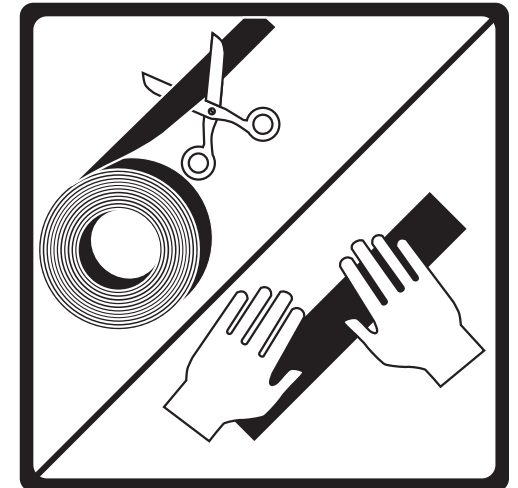
**DO NOT ROLL /
NE PAS FAIRE DÉBOULER**



**NO CHAINS / USE STRAPS
PAS DE CHÂÎNES / UTILISER COURROIES**



**DO NOT DRAG /
NE PAS TRAÎNER AU SOL**



**REPAIR DAMAGE /
RÉPARER LES DOMMAGES**