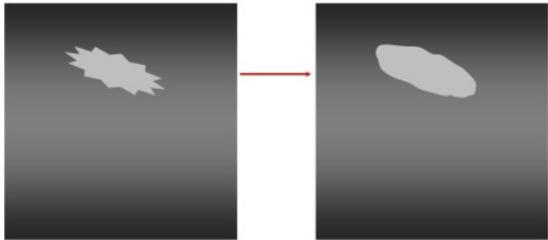


1

At the damaged spot, verify whether the steel substrate is also damaged. Do not repair the coating until supervisors have inspected the damaged steel surface and have approved coating repair.



2

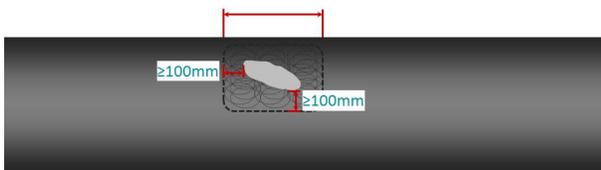


3

Remove loose coating and bevel all sharp edges of the coating damage.



4

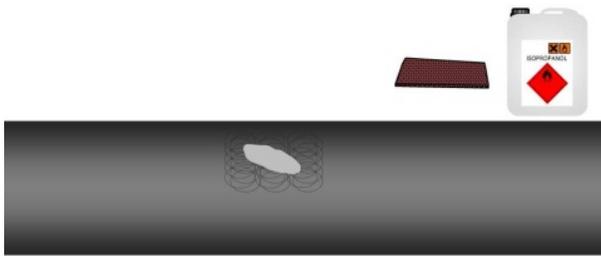


5

Roughen the surface of the plant coating around the damaged spot with an abrasive pad or sand paper. Remove all contaminations.



6

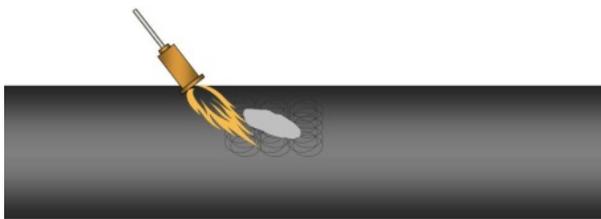


7

Degrease with isopropyl alcohol. Do not use a thinner.



8

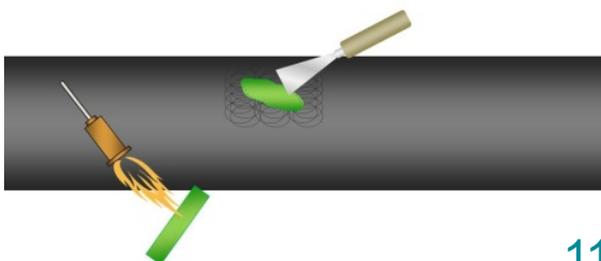


9

Preheat the area until approx. 70°C.



10

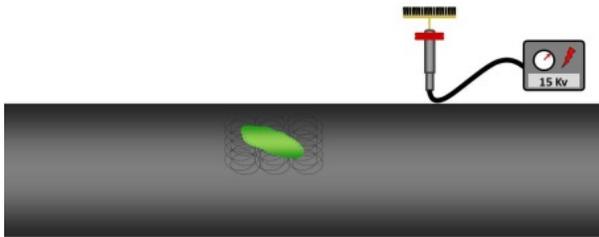


11

Preheat some Paste and mould it into the damaged area without air inclusions. Avoid smearing Paste beyond the damaged area.



12



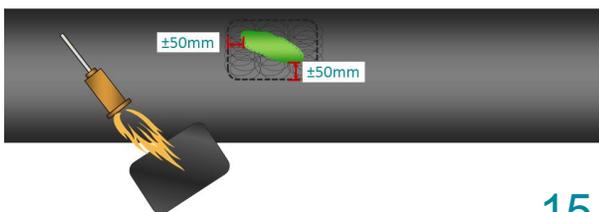
13

A holiday test using a high voltage tester must be carried out on the green Stopaq Paste prior to the application of any Outerwrap. The test must be carried out at a minimum of 15kV.



14

Always use approved and certified holiday test equipment.



15

Cut a Repair Patch with dimensions of at least 50mm bigger than the damaged area. Preheat the patch and place it over the Paste.



16

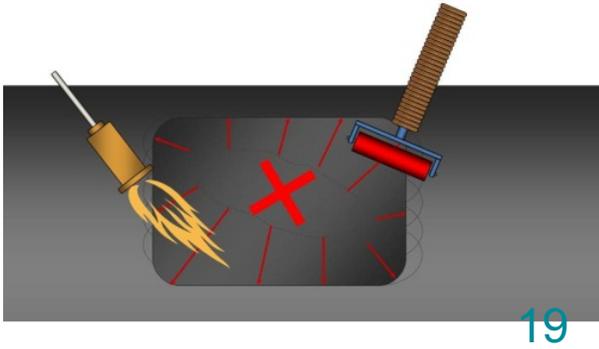


17

Heat the patch with a torch (moderate flame), use a siliconized roller to press the patch onto the surface and remove eventual air inclusions.



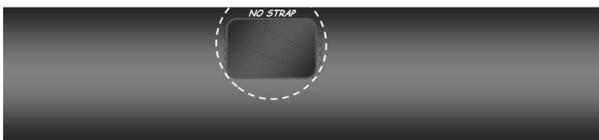
18



19 Do not roll over the area where the Paste has been applied.

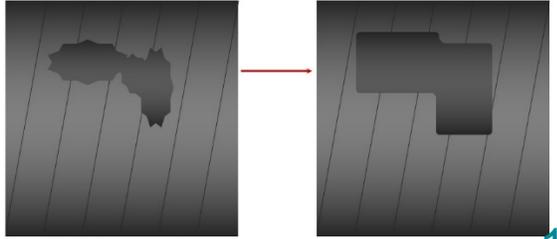


21 The dimpled pattern will disappear when sufficient heat has been applied and some hot melt will protrude from underneath the patch.



23 Mark the repaired area to indicate that straps must not be put around the repaired area.





Detailed damage views

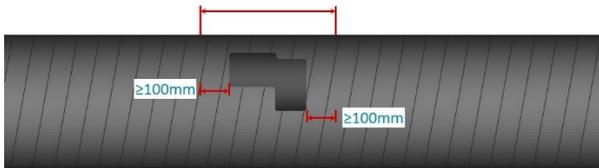
1

At the damaged spot, verify whether the steel substrate is also damaged. Do not repair the coating until supervisors have inspected the damaged steel surface and have approved coating repair.



2

Remove loose coating and bevel all sharp edges of the coating damage.



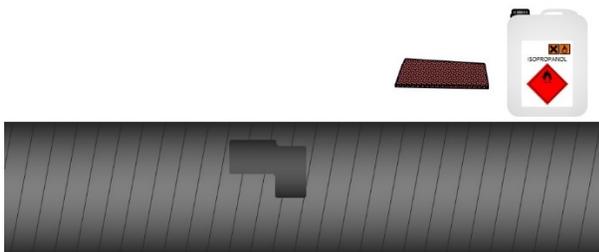
3

Roughen the surface of the plant coating around the damaged spot with an abrasive pad or sand paper. Remove all contaminations.



4

...



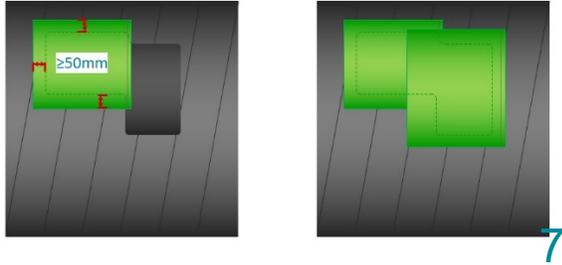
5

Degrease with isopropyl alcohol. Do not use a thinner.

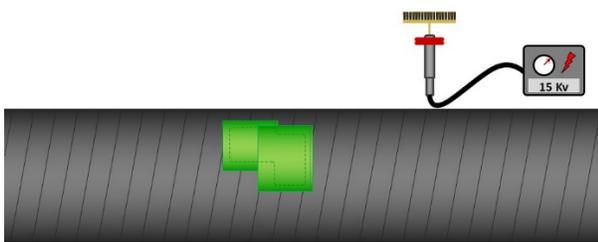


6

...



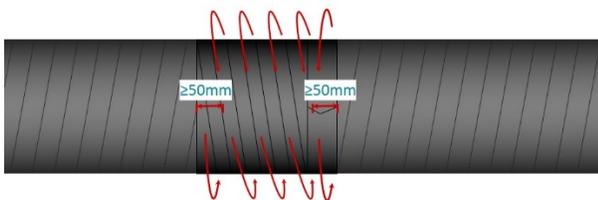
Depending on the size and depth of the damage, Paste might be necessary to fill the damage. Apply strips of Wrappingband over the damaged area with a minimum overlap of 50mm on the factory applied coating.



A holiday test using a high voltage tester must be carried out on the green Stopaq Wrappingband prior to the application of any Outerwrap. The test must be carried out at a minimum of 15kV.



Always use approved and certified holiday test equipment.



Apply Outerwrap over the Wrappingband with tension and avoid air inclusions. Start and finish with an overlap of at least 50mm on plant coating adjacent to the 50mm outside the Wrappingband.

