Tapecoat® Royston®

Application Guideline

1.0 SCOPE

This document contains general instructions and recommended practices for the application of Royston Handy Caps®. Handy Caps provide quick, field applied corrosion protection to anode and test wire leads welded onto metal substrates. They are available with or without an integrated primer (IP) in the adhesive. The Handy Cap IP is also available in a larger size (XL IP). The product specifics are detailed in Section 2.0. For assistance in coating selection, surface preparation, application or inspection, please contact a Chase Representative.

2.0 MATERIALS

2.1 Handy Cap - A durable plastic sheet that has a dome filled with a moldable compound to assure complete encapsulation of the item being protected. The sheet is then capped with an adhesive layer for easy and permanent application. Roybond 747 Primer is required in order to provide a permanent application. Capable of sealing wires as large as 8 AWG.

2.2 Handy Cap IP - A durable plastic sheet that has a dome filled with a moldable compound to assure complete encapsulation of the item being protected. The sheet is then capped with an adhesive layer for easy and permanent application. The Handy Cap IP uses the Tapecoat gray elastomeric adhesive that has an integrated primer. This exclusive formulation allows for faster application as there is no need to apply a separate primer when application temperatures are above 40°F. Capable of sealing wires as large as 8 AWG.

2.3 Handy Cap XL IP - A similar construction as the Handy Cap IP, but it is designed for larger wires and welds. Capable of sealing wires as large as 2 AWG.

2.4 Royston Roybond 747 – Liquid Adhesive/Primer required for the application of Royston Handy Cap. Available as a brush applied liquid or in a spray can. For use at service temperatures up to 185°F (85°C).

2.5 Tapecoat Omniprime® – Liquid Adhesive/Primer required for the application of Handy Cap IP and XL IP when application temperatures are below 40°F (4°C).

2.6 Royston Key Hole Tool – Convenient tool for applying all versions of the Royston Handy Caps.

3.0 SURFACE PREPARATION

3.1 All substances that will impede bond or otherwise be detrimental to the performance of the coating system must be removed prior to the coating application. This includes all loose surface material, rust, dirt, dust, moisture, grease, oil, sharp edges, burrs, mill scale, welding splatter and shop lacquer.

3.2 For all Handy Caps applications the pipe cleaning must meet either SSPC-SP 2 or SSPC-SP 3 at a minimum, but SSPC-SP 6/NACE No. 3 can also be used.

3.2.1 SSPC-SP 2 HAND TOOL CLEANING: Scrapers, files and wire brushes.

3.2.2 SSPC-SP 3 POWER TOOL CLEANING: Power brushes and grinders

3.2.3 SSPC-SP 6 / NACE No.3 COMMERCIAL BLAST CLEANING
Important to note: Clean the grit or shot off the pipe surface after blasting.

3.3 The coating must be applied as soon as practical after cleaning to keep dirt and rust bloom from re-contaminating the pipe surface.

3.4 Before coating application the surface must be dry. Preheating the surface to 120°F will dry the surface and increase adhesion. Be cautious not to damage the existing coating during this step by always keeping the torch moving.

4.0 APPLICATION

4.1 When using the Omniprime or Roybond 747, stir the primer until the product appears uniform using a paint stick or similar tool. A thin (4 mil wet/1.0-1.5 mil dry) coating applied by brush is recommended. The Roybond 747 is also available in an aerosol can. The primer must be given enough time to dry before the Handy Cap is applied. A simple touch test can be used to indicate when the primer is dry. A touch without transfer of the primer to a gloved hand is considered a successful touch test.

4.2 Hand Application

4.2.1 Remove the release liner from the bottom of the Handy Cap. Bend the Handy Cap inward at the serration when applying to a small diameter pipe. Position and place the Handy Cap over the weld so that the lead wire is lined up with the tunnel area of the Handy Cap.

4.2.2 Push the dome of the Handy Cap firmly into the weld area. Lift the lead wire away from the pipe slightly. Push and mold the Handy Cap adhesive so that it forms a seal completely around the wire.

4.2.3 Push the lead wire back down on the pipe and press the edge of the cap firmly so that the area around the wire is completely sealed.

4.3 Key Hole Tool Application

4.3.1 Remove the release liner from the top of the Handy Cap and apply it to the end of the applicator.

4.3.2 Remove the release liner from the bottom of the Handy Cap. Position the Handy Cap over the key hole so that the lead wire is lined up with the tunnel area of the Handy Cap.

4.3.3 Carefully lower the Handy Cap into the key hole and apply it to the pipe. Push the Handy Cap firmly into the weld area. Slowly pull up on the Key Hole Tool until it releases from the Handy Cap.

5.0 INSPECTION AND TESTING OF FIELD APPLIED COATING

5.1 Visual Inspection: The Handy Cap should cover all bare metal. If some bare metal is visible the area must be coated with tape or other suitable coating. When wrapping or coating over the Handy Cap, the small release liners on the top of the Handy Cap should be removed first. This will help to assure that the Handy Cap and the coating bond together; keeping the area watertight.

5.2 Electrical Continuity Test (Holiday Detector): A coil spring electrode or brush-type electrode should be used. The voltage should be set at 5000V unless the existing coating will be damaged at that setting. If the existing coating is to be tested at less than 5000V then that same setting should be used for the Handy Caps.

6.0 REPAIR OF DAMAGED COATING

6.1 All damaged and loose coating must be removed. If this removal results in the metal surface becoming visible it must be prepared as discussed in Section 3 and a primer and Handy Cap must be applied as discussed in Section 4. If Handy Cap IP or XLIP are used the primer is not required.

7.0 BACKFILL

7.1 Backfill should be free of large rocks, stones, scrap, and debris that could damage the coating.

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