Polyken® Tape Technology SEALFORLIFE

PRODUCT DATA SHEET

POLYKEN® 931

Product Information

Product description: The Polyken® filler tapes are designed as an underlying filler material prior to the application of Polyken® coating systems, such as 908, 930, 980... The 931 filler tape can also be used as Heat Shield Material with the Covalence Waterwrap-IW HSS system. The elastomeric formulation is very conformable, making it also ideal for filling in transition areas around tees, elbows, valves, specials, welded and coupled field joints. The filler tapes maintain flexibility over a wide temperature range and under various conditions encountered in the field.
The Polyken® 931 is a 100% solids butyl rubber filler tape with a kraft liner to facilitate application. The butyl alloy composition maintains flexibility and will not flow at temperatures less than 250°F (121°C).

Features & Benefits:

- Flexible under various field conditions.
- Easy and simple application.
- Conformable and moldable.
- Compatible with Covalence and Polyken® coating systems.

Product selection guide	
Max. operating temperature	85°C (185°F)
Recommended primer	1019, 1027, 1033A, 1039
Compatible line coatings	PE, FBE, Cold tape, CT, CTE
Recommended pipe preparation	SSA-ST2 (SSPC-SP3) or SSA-SA 2 (SSPC-SP6) 1 – 3 mil anchor profile (25 – 76 micron anchor profile)

Product construction	
	931
Adhesive	35 mils (0.89 mm)
Backing color	Black

Ordering information

Polyken® filler tapes are available in roll form.
Example: **931-EU-100x7M-RL (C8)**
931-EU-50x7M-RL (C16)

931	*Product type*	*Standard Ordering Options*
100	Tape width in mm	50 mm (2"), 100 mm (4")
7	Tape roll length in meter	7 m (25 ft)
(C8)	Roll quantity per case = MOQ	Depends on roll width

For other ordering options please contact your Seal For Life representative.

Product properties of Polyken® 931

		Typical values	
Property	Method	931	Units
Elongation	ASTM D1000	> 600	%
Peel adhesion to primed steel	ASTM D1000	15.6 2.75	pli N/mm
Impact resistance*	EN12068	8	J
Indentation resistance*	EN12068, Class B30, 1 N/mm^2	> 0.6	mm remaining coating thickness

*For 931 installed with 50% overlap and 908 tape with 2x50% overlap.

Equation for Pipe Coating Requirements

Squares of coating required**

$$\frac{\text{(width of coating in inches) x (area of pipe in square feet)*}}{\text{(width of coating in inches – overlap in inches) x 100}}$$

* Area of pipe in ft² = (diameter in inches / 12) x 3.1416 x length in feet
** One Square = one hundred square feet = 9.29 square meters

Square meters of coating required

$$\frac{\text{(width of coating in mm) x (area of pipe in square meter)*}}{\text{(width of coating in mm – overlap in mm)}}$$

* Area of pipe in m² = (diameter in mm / 1000) x 3.1416 x length in meter

Squares per roll**

$$\frac{\text{(width of roll in inches)}}{(12)} \times \frac{\text{(length of roll in feet)}}{(100)}$$

Square meters Per roll

$$\frac{\text{(width of roll in mm)}}{(304.8)} \times \frac{\text{(length of roll in m)}}{(30.48)}$$

Rolls Required

$$\frac{\text{(squares of coating required)}}{\text{(squares per roll)}}$$

Rolls Required

$$\frac{\text{(square meters of coating required)}}{\text{(square meters per roll)}}$$

Application instruction: Job preparation	
Tools, equipment and auxiliaries	Temperature gauge, DFT/WFT gauge Primer application equipment/agitator, Tape application equipment, Coating “hot box”
Additional coating materials	Subsequent Polyken coating systems, 933-25, 939
High humidity	Polyken® 931 can be applied in a humid atmosphere. The substrate should be free from condensing water which can be reached by keeping the temperature at least 5°F (3°C) above dew point.
Work area and substrate	The substrate surface should be dry, clean and protected against negative weather influences.
Product conditions	The Polyken® 931 shall be stored and/or transported in a dry, ventilated location. Storage temperature shall be a minimum of 60°F (16°C) and a maximum of 120°F (49°C).The minimum primer and roll body temperature for application will be 60°F (16°C).

Application instruction: Surface preparation	
General	The area to be coated has to be clean, dry, and free from oil, grease and dust. All contamination including mill-scale has to be removed.
Degreasing	Degrease surfaces with Toluene or Heptane and e.g. a lint-free cloth.
Preventing condensation of water	Prior to and during the application, the temperature of the substrate(s) must be at least 5°F (3°C) above the dew point.
Substrate temperature	Temperature of the substrate should preferably be between 68°F and 104°F (20°C / 40°C). Preheating may be required.

Application instruction: Brief version	
Step 1	Clean substrate to SSA-ST2, SSPC-SP3 (power wire brush) or SSA-SA 2, SSPC-SP6 (commercial blast). Surface (anchor) profile depth shall be no less than 1.0 mils (25 micron) and no greater than 3 mils (76 micron).
Step 2	Uniform primer application achieving 2 to 3 mil WFT. Primer should be “dry to touch” before application of inner layer.
Step 3	Normally, if the raised girth weld is over 3/32” (.24mm) in height, the weld shall be coated with the Polyken® #933-25 seam tape or #931 or #939 solid mastic filler. A filler strip, 6 inches (15.2 cm) wide shall be centred, smoothed, and coat the entire surface of the raised girth weld.
Step 4	Apply the subsequent Polyken® coating system over the 931 layer in order to finalize the system.

*** For further detailed information, please view the corresponding Application Guideline ***

Handling and commissioning	
Exposure to loads	Objects coated with Polyken® 931 should not be exposed to loads e.g. from supports- or lifting equipment.
Backfill	Backfill is possible immediately after completion of the coating application and after the 939 has been coated with an additional coating system. Consult application guidelines for specific instructions. Backfill should be clean and not contain any foreign items that can cause damage to the coating system.

Information	
Documentation	Extensive information is available on our web-site. Application instructions and other documentation can be obtained by contacting our offices, from our local distributor or by sending an email to **info@sealforlife.com**
Certified staff	Application of the described coating system shall be carried out by certified personnel.

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