



Product Information



Special Advantages

- improved adhesion
- versatile use
- application suited packing units

DENSOLEN® Primer HT

Solvent based primers for DENSOLEN-Tape systems, for

the corrosion protective coating of underground pipelines, tanks

and installations in combination with DENSOLEN Tapes.

Description

DENSOLEN-Primer HT is a solution of butyl rubber and unsaponifiable resins in petroleum spirit.

DENSOLEN Primer HT

- improves the peel strength of DENSOLEN-Tapes on the metal surface and supports their corrosion protection performance.
- encloses dust and moisture traces and neutralises same

- is suitable for steel and for non-ferrous metal surfaces
- is compatible with coatings of PE, PP, Epoxy, PU and bitumen/coaltar

Properties

Property	Unit	Typical value	Standard
Solvent	-	petroleum spirit	-
Flash point	°C	-14	DIN EN 57
Density @ 23°C	g / cm ³	0,79	DIN 51757
Solid contents body	% by weight	29	ISO 1515
Contents of aromatic compounds	% by weight	< 0,0005	GC
Viscosity (nozzle 4 mm) at 23°C	sec.	40±5	DIN 53211
Drying time for hand application ¹⁾	min app.	10	-
DENSOLEN-Tape to be wrapped within	h	< 8	-
Consumption app.	l / m ²	0,2	-
Operating temperature ²⁾	°C	-60°C up to +100°C	-

1) Depending on temperature, humidity, air movement and pipe surface temperature

2) Depending on DENSOLEN-System used

Method of Application

The surface has to be carefully prepared for application of the corrosion protection material. Rust, moisture, grease and all foreign matter must be removed. Prior to application of DENSOLEN Primers the surface has to be cleaned thoroughly. Moisture and ice have to be removed by drying with a propane or butane gas flame. Rust, dirt, residuals of welding electrodes or of varnishes, temporary corrosion protective material and other foreign matters must be removed totally. In case of slight rust on descaled pipes it may be sufficient to work with a manual steel brush only. For mill coated pipes the descaling is state-of-the-art so that removal of slight surface

rust with steel brushes is sufficient. On pipe surfaces which are not descaled, the entire scale on the metal surface has to be removed, especially when the pipeline will have a cathodic protection and will be operated at temperatures higher than 30°C. Mill coatings, adjacent to the joint areas, must be cleaned as well but only in circumferential direction to avoid later stress cracking of the coating. To remove grease and oil use an organic solvent, e.g. petroleum spirit or ethanol. Under unfavourable climatic conditions an additional drying of the pipe may be necessary.

Vigorously stir DENSOLEN Primer in the original container prior to application.

Apply a uniform coat of DENSOLEN Primer to the pipe surface (metal and 100 mm of adjacent mill coating) by brush or roller. Seal the original container carefully after use. Clean brush and roller thoroughly with petroleum spirit. The primer has to be dry prior to application of DENSOLEN Tapes. Depending on type of primer, ambient temperature, air movement and humidity, drying will take approx. 5 - 30 minutes. The primer must be overwrapped with DENSOLEN Tape within 8 hours after application.

Application temperatures	
Ambient	-20 up to +70°C
Pipe surface	-10 up to +70°C
DENSOLEN-Primer HT	-10 up to +40°C

Units and Packing

Packing	Contents [l]	Gross weight [kg]
4 Tins packed in carton	4 x 1	4 x 0,92
Drum	5	4,70
Drum	10	8,70
Drum	180	168,0

Transport Codes

Valid codes given upon request.

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