



Product Information



Special Advantages

- improved adhesion
- for hand and machine application
- for steel and non-ferrous metal surfaces

DENSOLEN® Primer HT, HT25, MT25

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-Primers are solutions of butyl rubber and unsaponifiable resins in petroleum spirit.

DENSOLEN Primers

- improve the peel strength of DENSOLEN Tapes on the metal

surface and support their corrosion protection performance.

- enclose dust and moisture traces and neutralise same.
- are suitable for steel and for non-ferrous metal surfaces.

- are compatible with coatings of PE, PP, Epoxy, PU and bitumen/coaltar.

Use

- For hand application by brush or roller: DENSOLEN-Primer HT, HT25 and MT25
- For machine application: DENSOLEN Primer HT25 and MT25

Properties

Property	Unit	Typical values, DENSOLEN-Primer			Standard
		HT	HT25	MT25	
Solvent	-	petroleum spirit	petroleum spirit	petroleum spirit	-
Flash point	°C	-18	-18	≥ 23	DIN EN 57
Density at 23°C	g / cm ³	0,79	0,78	0,80	DIN 51757
Solid contents	% by weight	29	25	24	ISO 1515
Contents of aromatic compounds	% by weight	< 0,0005	< 0,0005	< 0,01	GC
Viscosity (nozzle 4 mm) at 23°C	sec.	40±5	25±5	25±5	DIN 53211
Drying time for hand application ¹⁾	min app.	10	5	25	-
DENSOLEN-Tape to be wrapped within	h	< 8	< 8	< 8	-
Consumption app. by hand	l / m ²	0,2	0,2	0,2	-
Consumption app. by machine	l / m ²	-	0,1	0,1	-
Operating temperature ²⁾	°C	-60°C to +100°C	-60°C to +100°C	-60°C to +100°C	-

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

²⁾ Depending on DENSOLEN tape system used

Method of Application

General

The surface has to be carefully prepared for application of the DENSOLEN Tape System. 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 torch flame. Rust, dirt, residues of welding electrodes, varnishes, temporary corrosion protective coatings and other foreign matters must be completely removed. 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 has to be removed, especially when the pipeline will have

a cathodic protection and will be operated at temperatures above 30°C. Mill coatings adjacent to the joint areas must be also , which shall only be done 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.

Welded Joints

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 app. 5 to 30 minutes. The primer must be overwrapped with DENSOLEN Tape within 8 hours after application.

Machine Application

Fill storage tank of priming machine and seal original container carefully after use. The uniform thin coating achieved by machine applied DENSOLEN Primer allows the immediate wrapping of DENSOLEN Tapes. DENSOLEN Primer can be applied by distributing felts. MT25 can also be airless sprayed. Take care that clean or new distributing felts are in use and that spray nozzles are in good condition. After use, all equipment must be cleaned thoroughly with petroleum spirit.

Application temperatures

Ambient	-40 up to +60°C
Pipe surface	above dew point up to +85°C

Units and Packing

Packing	Dimensions [mm]	Contents [l]	Gross weight [kg]		
			HT	HT25	MT25
Tin Packing unit: 4 tins per carton	108 x 132	1	0,92	-	-
Drum	257 x 180	5	4,70	-	-
Drum	257 x 280	10	8,70	8,60	9,0
Drum	590 x 890	180	168,0	168,0	170,0

Transport Codes

Valid codes given upon request.

DENSO GmbH

P.O.Box 150120 • 51344 Leverkusen • Germany
tel: +49-(0)214-2602-0 • fax: +49-(0)214-2602-318
www.denso.de • info@denso.de

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