Quick application guide

300 SERIES PIPE WRAPPING

Solvent free epoxy repair system
Suitable for manual/ mechanical prepared surfaces
Repair ½" to 42" diameter pipework

Cure Times

Resimac 300 series pipe wrapping system is based on 2 epoxy based materials.
302 Epoxy Repair Cement is used to rebuild or resurface badly corroded surfaces.
301 Epoxy Resin and Hardener is used in-conjunction with Glass tape to create a GRP pipe encapsulation system around problematic pipework.

At 20°C (68F°) each product will have the following cure times –

302 Epoxy Repair Cement

Usable Life	30 minutes
Touch dry	6 hours
Ready for overcoat	6 hours
Hard dry	16 hours

301 Epoxy Resin & Hardener

Usable Life	25 minutes
Touch dry	2 hours
Hard dry	6 hours
Full pressure	24 hours

Maximum Heat Resistance

150°c (500°f)

Maximum Service Pressure

1mm of 302 Epoxy Repair Cement with 3 wraps of 301 Epoxy Resin & Hardener
Manual Surface Preparation
75psi
Mechanical Surface Preparation
150psi
Abrasive Blast Cleaning
300psi

Easy to apply, requiring no special tools or equipment

Suitable for manual or mechanically prepared surfaces
Wire brush
Emery paper
Mechanical wire brush
Mechanical grinder with coarse pad
MBX Bristle Blaster
Alternatively this system can be applied to abrasive blast cleaned surfaces.

Surface Preparation

Hand tools,
use a wire brush or coarse sand paper to abrade the surface. Ensure all loose material and as much surface contamination is cleaned from the surface. Ensure the surface is wiped with an appropriate solvent cleaner such as MEK prior to and after abrading the surface.

Mechanical tools,
use a handheld mechanical grinder with a coarse grinding pad or rotary wire brush. Ensure all loose material and as much surface contamination is cleaned from the surface. Do not polish the surface, ensure that the surface has a cross hatch pattern. Ensure the surface is wiped with an appropriate solvent cleaner such as MEK prior to and after abrading the surface.

MBX bristle blaster, for the best mechanical surface preparation results use an MBX bristle blaster.

Abrasive Blast Cleaning, all surfaces must be abrasive blast cleaned to ISO 8501/4 Standard SA2.5 (SSPC SP10/ NACE 2) and with a minimum blast profile of 75 microns using an angular abrasive.

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Mixing of 302 Epoxy Repair Cement

Measure equal amounts of base and activator

Mix the 2 components using the spatula provided

Check the material is a consistent mix

Apply to the pipe surface using the applicator tool

Mixing of 301 Epoxy Resin & Hardener

Pour the activator into the base component container

Mix using the spatula provided

Ensure the product is a consistent mix

Apply by brush to the repair surface

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300 SERIES PIPE WRAPPING

Surface Preparation – Manual

Surface of the pipe is badly corroded and pitted

Abrade the surface with coarse sandpaper

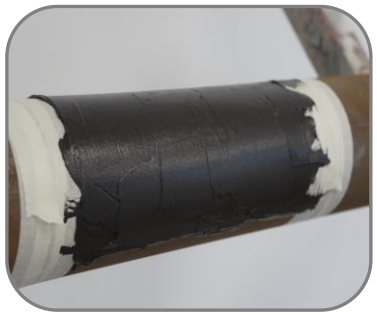
All loose materials and corrosion must be removed

Wipe the surface with solvent or with a damp cloth

Rebuilding and filling of the repair surface using 302 Epoxy Repair Cement

Mix 302 Epoxy Repair Cement on a clean surface

Apply the mixed material to the abraded pipe surface



Ensure all pitting and scarring is filled

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300 SERIES PIPE WRAPPING

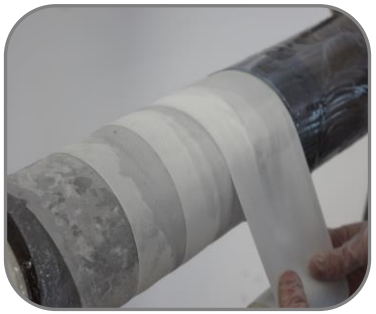
Encapsulation of pipework using 301 Epoxy Resin & Hardener and Glass Tape

Mix 301 Epoxy Resin and Hardener

Apply the mixed material at 1mm WFT using a brush

While the resin is still wet begin to wrap glass tape around the pipe

Wrap the glass tape around the pipe 3 times to create an anchor point



Then wrap the glass tape along the length of the pipe ensuring you overlap the glass tape by 50%

Once the entire length of pipe has been wrapped apply mixed resin to the pipe surface, wrap the tape 3 times around the pipe to terminate the repair

After the pipe wrap has been terminated, apply another layer 301 Epoxy Resin & Hardener at 500 microns WFT and repeat the glass tape wrapping

After the 2nd wrap of glass tape has been terminated. Apply 301 Epoxy Resin & Hardener at 500 microns WFT and repeat the glass tape wrapping process for a 3rd and final time

The completed system will range from 2-5mm dry film thickness depending how much 302 Epoxy Repair Cement has been applied.

After 24hours at 20˚C this repair system will be ready for service

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