



**CLEXO**  
*Life of Construction*

## **CLEXOPIPE-SELF (1.5MM/2MM)** (SELF-ADHESIVE ANTI-CORROSIVE PIPE WRAPPING TAPE)

CECPL-6004

### OVERVIEW

CLEXOPIPE-SELF is Self-Adhesive Anti-Corrosive tape a high quality bitumen or coal tar based wrapping and coating anticorrosive tapes which confirm to IS: 10221-1982. It incorporates a center core of 45gsm of fiber glass tissue and HMHDPE film of 20 micron which lends mechanical strength, dimensional stability to the product. These centre cores are laminated with 3 layers of coal tar or bitumen mix. The final product has a top and bottom layer of thermo fusible HMHDPE Film. All the seven layers are calendared together to create this revolutionary 1.5mm/2mm thick tape. The material conforms to IS: 15337-2003 and AWWA: C203-2008.

CLEXOPIPE-SELF also comes with five layer system having center core and also comes with 3 layer system without center core. These Membranes are manufactured under the IS code specified and used for underground pipeline in India.

CLEXOPIPE-SELF is on available in 1.5mm, 2mm thickness.

### PROPERTITES

Excellent resistance to positive water & vapor pressure.

Good heat resistance.

Moisture resistance

Good dimensional stability under tension.

Easy to apply with low cost.

Corrosion prevention.

### INSTRUCTIONS FOR USE

The application temperature should be between 5°C to 45°C. Application procedures may vary slightly depending upon site conditions. The general recommended guidelines for the application of the waterproofing system are as follows:

#### **SURFACE PREPARATION**

The surface shall be cleaned thoroughly of all contaminants like dust, traces of curing compound, oil and grease. All surface imperfections and protrusions shall be removed and repaired.

#### **PRIMING**

Apply Solvent based CLEXOTHETIC-PRIME @ 0.3-0.4L /Sqmt as per ASTM D 41 & IS: 3384-1986 and BS 4147-1980 to a clean smooth and dry surface by brush, roller or spray. Allow the primer to dry prior to the application of the membrane. As the viscosity of the primer is low, it easily creates adhesion between the membrane and the pipe surface. In addition to that the primer also acts as a binder for the dust which gets accumulated on the pipe surface even after cleaning.

#### **ALIGNMENT & TORCHING**

After CLEXOTHETIC-PRIME, next step is followed; CLEXOPIPE-SELF 1.5MM/ 2MM Pipe Wrap Coating is then wrapped around the pipe in spiral fashion and bonded to pipe by peeling the polythene/paper from one side. An overlap of 10mm is to be allowed. The overlaps are to be sealed by thermo fusion process if required.

For further details visit: [www.clexoengineering.com](http://www.clexoengineering.com)

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A second coat of primer is applied over the first layer of CLEXOPIPE-SELF and allowed to dry till it becomes tacky.

CLEXOPIPE-SELF second layer is spirally wound over the first layer in spiral fashion and the overlaps are thermo fused.

An area of 250 mm at the end of the Pipes is to be left uncoated to permit installation and welding. This area is to be coated after welding.

### **CAUTION**

Do not peel out the membrane before laying it will be peel out while doing same time.

All angles and abutments should be sealed with extra care to ensure full bonding. All brushes and tools should be cleaned by water immediately after use.

### **PRECAUTION:**

Wash all the tools and tackles with industrial solvent immediately after the application is completed.

### **HEALTH & SAFETY**

As with all chemicals, caution should always be exercised. avoid prolonged contact with eyes and skin. Protective clothing such as gloves and goggles should be worn. See the relevant material safety data sheet for more information.

### **PACKING & STORAGE**

PACKING & STORAGE CLEXOPIPE-SELF is available in (1.00 Mtr W x 10.00/15.00 Mtr L) as per given details:-

#### **THICKNESS:-**

**1.5MM** – (1Mx10M/15M), **Weight** - 2.0 Kg-2.3 Kg /sqmt

**2.0MM** – (1Mx10M/15), **Weight** – 2.5 Kg-2.9 Kg /sqmt

Store Rolls in a clean dry area protected from direct sunlight and extreme heat and cold. Unopened Rolls can be stored for 12 months

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| Product                                      |  |             | Self-Adhesive Anti-Corrosive Pipe Wrapping Tape                     |   |                         |
|--|--|-------------|---|---|-------------------------|
| <b>RAW COAL TAR PITCH</b>                    |  |             | <b>PHYSICAL PROPERTIES OF COAL TAR TAPE</b>                         |   |                         |
| Characterization Values                      | Standard   |             | Property  | Requirement   | Test method             |
| Softening point 0°C                          | 65 121   | ASTM D36    |   | Min. Max.   |                         |
| Specific gravity                             | 1.30±0.05  | ASTM D71    | Service temperature ( 0°C)  | -   | 60                      |
| Ash content, %                               | 0.5 Max.   | ASTM D2415  | Tape thickness mTl  | 2.0   | 2.5                     |
| Physical state                               | Solid at ambient temperature   |             | Weight average (kg/sq.m/mm)   | 1.25  | -                       |
| <b>FILLER</b>                                |  |             | Breaking strength in longitudinal direction kN/m                    | 0.7   | -                       |
| Characteristics                              | Requirement  | Test Method | Adhesion  | AWWA C-203.   |                         |
| Fineness: %                                  | Shall pass through   |             | Insoluble content % by wt. in                                       | 93 minimum (procedure given in ANNEXURE-I)  |                         |
| w/w, minimum                                 | mesh size of 75  |             | Petrol  |   |                         |
|  | microns  | ASTM D1366  |   |   |                         |
| Loss on ignition                             |  |             |   |   |                         |
| at 800° C, w/w max.                          | 10   | ASTM D1208  |   |   |                         |
| <b>FABRIC</b>                                |  |             | <b>PHYSICAL PROPERTIES OF COAL TAR COMPONENT IN THE FINISH TAPE</b> |   |                         |
| Type   | The fabric shall be a thin, flexible, uniform mat or tissue composed of glass fibers in an open structure bonded with a suitable resinous inert material compatible with coal tar.                             |             | Property  | Requirement   | Test method             |
|  |  |             |   | Min. Max.   |                         |
| Weight (m in g/m2)                           | 30   |             | Softening point ( 0C)   | 65 121  | ASTM D36                |
| Thickness (min.) mm                          | 0.3  |             | Penetration at 250C/ 100g/ 10 ' mm/5sec                             | 1 9   | ASTM D5/BS-4164         |
| Breaking load in the longitudinal direction. | 2.28KN/m (min.)  |             | Filler %  | 20 35   | ASTM D 2415 or AWWA 203 |
| Porosity                                     | When related to pressure difference across the sample, the glass fiber fabric shall have porosity of not less than 0.6mm and not more than 1.9mm of water at an average air velocity of 61 m/minute (1 m/sec.) |             | <b>TECHNICAL CHARACTERISTICS FOR PIPE WRAP PRIMER</b>               |   |                         |
| Temperature Resistance                       | The fabric shall be unaffected under load in hot coal tar at 288°C for one minute. It shall not shrink length wise or width wise.  |             | Type  | Fast drying, synthetic, chlorinated rubber-synthetic plasticizer-solvent based              |                         |
| Pliability test                              | No cracking shall take place when bent over a mandrel of 3mm radius through 90° arc at a uniform speed of approximately 2 seconds after immersing in water for 10 to 15 minutes.                               |             | Drying time (tack free)   | 15 minutes (approx.) (ASTM D1640)   |                         |
|  |  |             | Flash point   | > 230C (ASTM D93/D3941)   |                         |
|  |  |             | Volatile matter (105-11 OOC) percent by mass                        | 75 (maximum) (ASTM D2369)   |                         |
|  |  |             | Viscosity, on FORD CUP NO. 4 (4mm nozzle) at 230C                   | 35-60 seconds (ASTM D1200)  |                         |
|  |  |             | DFT   | 25 microns/coat (minimum)   |                         |
|  |  |             | Coverage (Theoretical)  | 10 M2/Lit/Coat  |                         |
|  |  |             | Coverage (Practical) @ 25 microns DFT coat                          | 6 M2/ Lit/Coat (minimum) (ASTM D344)  |                         |
|  |  |             | Application properties  | By brush/ spray should produce an effective bond between metal and subsequent coal tar tape |                         |
|  |  |             | Adhesion test ( after 72 hours)                                     | The primer shall be tested after applying tape coating as per AWWA C-203.                   |                         |

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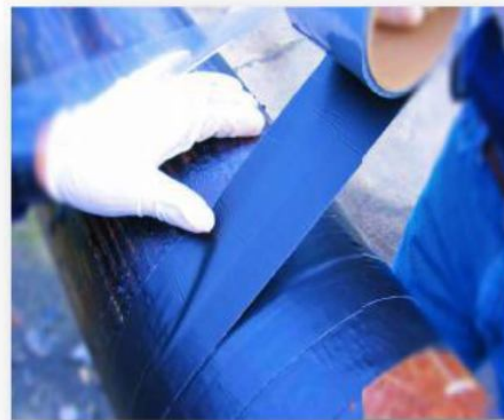


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### **PICTURES/IMAGES AT GLANCE**



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[An ISO 9001: 2015 Company]

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