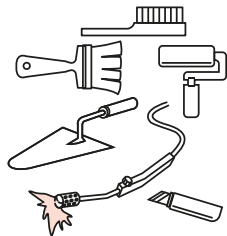


# External coating repairs

The contractor is responsible for analyzing and eliminating any risks during installation (especially the use of personal protective equipment).

## 1 EQUIPMENT AND TOOLS REQUIRED

- Gloves, protective mask and goggles
- Brush, abrasive paper and cutter
- Spatula, mastic knife
- Paintbrushes, roller
- Gas burner
- Adhesive roller



## 2 PIPES WITH A BIOZINALIUM AND ZINALIUM EXTERNAL COATING: Natural, Integral, Blutop, Topaz, Tag 32

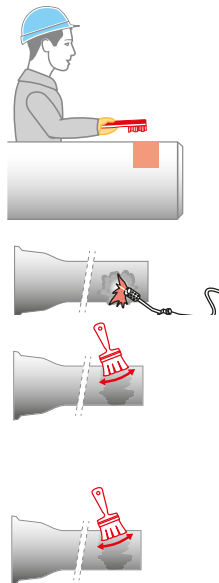
**Brush** to remove any dirt or loose particles.

**Dry** the surfaces to be coated (in case of low temperatures or high humidity, use a gas burner).

If the iron is exposed, **apply** high-zinc anticorrosion primer NATZINC (ref. **251222**) with a paintbrush with vertical and horizontal strokes.

Allow to **dry** for a few minutes.

**Apply** AQUACOAT paint with a paintbrush (NATURAL/BLUTOP Blue ref. **240991**) - INTEGRAL/TAG32/TOPAZ Red ref. **240990**) with vertical and horizontal strokes.



## 3 FITTINGS WITH AN EPOXY EXTERNAL COATING: Natural, Blutop, Integral, Topaz (all versions).

**Brush** and clean the area to be touched up and then **dry**.

**Apply** the epoxy paint with a paintbrush or spatula with vertical and horizontal strokes.

•**Natural / Blutop:** EUROKOTE 4820 Blue (1 kg dose: ref. **158255**)

•**Integral / Tag32 / Topaz:** EUROKOTE 4820 Red Brown (1 kg dose: 184653 or kit of five 50 ml syringes: ref. **220817**)

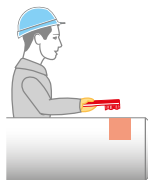
•**Standard TT PUX and Integral TT PUX:** Eurokote 4820 Ivory (ref. **220818**)



# External coating repairs

## 4 PIPES WITH A ZINC AND SYNTHETIC PAINT EXTERNAL COATING

**Brush** to remove any dirt or loose particles.



**Dry** the surfaces to be coated (in case of low temperatures or high humidity, use a gas burner).

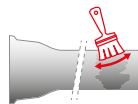


If the iron is exposed, **apply** high-zinc anticorrosion primer NATZINC (ref. **251222**) with a paintbrush with vertical and horizontal strokes.



Allow to **dry** for a few minutes.

**Apply** ENDOLAC 245-30 FGC paint (ref. **158134**) with a paintbrush with vertical and horizontal strokes.



## 5 PIPES WITH A POLYETHYLENE EXTERNAL COATING

### 5.1 Significant damage

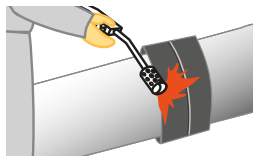
**Roughen** the area to be repaired with abrasive paper.

**Clean and dry** the area.

**Preheat** to approximately 60°C.

**Fit** an open heat-shrink sleeve (reference on request).

**Wrap** the sleeve all around the pipe's circumference using a gas burner and then fit the closing strip.

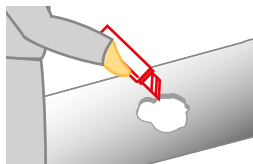


### 5.2 Moderate damage

Repair kit ref. **111216** comprising abrasive paper, mastic and a repair strip.

**Clean and dry** the exposed area.

**Cut off and remove** the damaged PE.

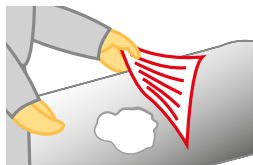


# External coating repairs

**Preheat** to approximately 60°C.

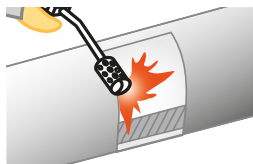
**Apply** the mastic and smooth with a knife.

**Place the repair strip** with a 50 mm overlap on the edges of the cut area.



**Heat** the strip with a gas burner until the heat-sensitive paint changes color.

**Press** the strip down wearing appropriate gloves.



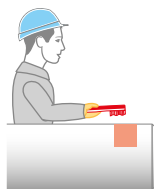
## 5.3 Minor damage

In case of minor damage to the TT coating, use the **PE repair stick** (ref. **175507**). Using a brazing torch, heat the stick until it drips onto the damaged area and then smooth over.

## 6 PIPES WITH A POLYURETHANE EXTERNAL COATING

**Brush** to remove any dirt or loose particles and then **sand** to clean and roughen the surface.

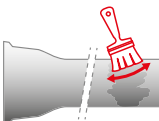
**Remove** any dust from the surface to be coated.



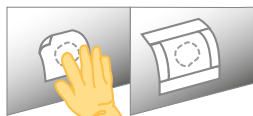
**Heat** with a gas burner to remove any traces of humidity.



**Apply** the product to the surface with a syringe (kit of five syringes - Eurokote 4820 Ivory - ref. **220818**).



**Cover** with a sheet of PVC to smooth out and protect the product.  
Close with adhesive.

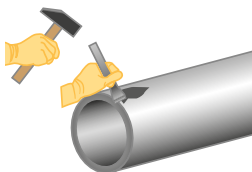


*In case of major damage to the PUX coating, follow procedure 5.1 in the previous chapter.*

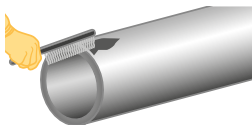
# External coating repairs

## 7 PIPES WITH A CEMENT EXTERNAL COATING

**Prepare** the affected surface by removing the damaged and loose mortar.



**Brush** to remove any dirt or loose particles and then **clean** the surface.

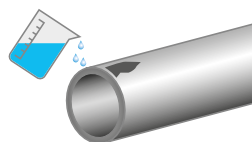


**Prepare** the ZMU repair kit (DN 80 to 600: ref. 218842).

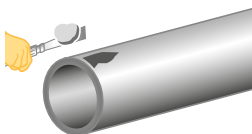
- Mix the dry components
- Add the liquid while stirring vigorously
- Leave for five minutes and then mix again



**Dampen** the surface.



**Fill** with mortar using a spatula and then smooth the surface.



(DN ≥ 700: ref. 158009)

**Prepare** the SIKADUR 31DW mixture with three parts R (resin) and one part H (hardener). **Mix** to an even consistency.

Preferably **position** the area to be repaired facing downwards.

**Remove** any damaged and loose mortar.

**Clean** until spotless.

**Apply** the mixture and compact to ensure the correct thickness.

**Smooth** the surface.



**Minimum application temperature: + 5°C.**

**Cover** with plastic film or a damp cloth to maintain a high level of humidity and ensure that the mixture sets properly.

Optimal drying time: 2 hr 30 min.

