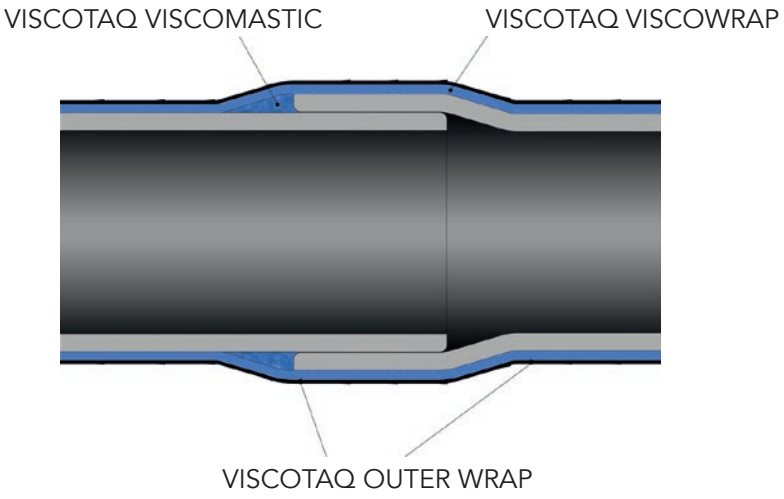
VISCOTAQ™ BELL & SPIGOT SEALING SYSTEM

The Viscotaq™ Bell & Spigot Sealing System is based upon the use of Viscomastic™ in combination with Viscowrap™ and Viscotaq™ Outer Wrap. For applications that require additional hydrocarbon resistance or mechanical protections, Viscotaq™ Glass Wrap is recommended.

The system is applied to prevent water infiltration at the bell and spigot pipe connection. This system will also provide corrosion prevention when applied on metallic piping.

The Viscotaq Bell & Spigot Sealing System can be installed on new and existing joints of most materials (HDPE, PVC, Ductile, Steel, Concrete).



COMPOSITION

Viscotaq™ is a non-crystalline a-polar viscous elastic (viscoelastic) semi-solid polyolefin coating for corrosion prevention & waterproofing of underground and aboveground substrates.

Viscotaq's molecular chemistry is unique and designed in such a way that the viscosity gives it permanent wetting characteristics and the elasticity of the product provides the strength and feeling of a semi-solid. The Viscotaq compound bonds to the substrate by means of Van der Waals principles, penetrating the pores and anomalies of the substrate. The compound remains in intimate contact with the substrate creating an impermeable homogeneous corrosion prevention/waterproof coating.

COMPONENTS

Viscotaq Viscomastic™

Viscotaq Viscowrap™

Viscotaq™ Outer Wrap

Viscotaq™ Glass Wrap (optional)

METHOD OF APPLICATION

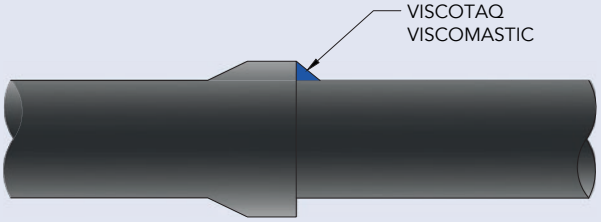
1. Surface Preparation:

All surfaces shall be cleaned of mud, mill lacquer, wax, tar, oil, grease, or other foreign contaminants.

- Edges of the plant/existing coating shall be bevelled, and the plant coating shall be roughened over a minimum length of 6"/15 cm.
- Surface preparation may be carried out by a wire-brush cleaning to a minimum degree of cleanliness of ISO 8501-1, grade St 2 (SSPC SP 2), but preferably power brush cleaning, grade St 3 (SSPC SP 3 / SSPC SP11) or commercial blast-cleaning to a minimum degree of cleanliness of ISO 8501-1, grade Sa 2, SSPC 6.
- Dust contamination shall be grade 3 or better measured in accordance with ISO 8502-3. Remove any grease and dust with industrial alcohol (SP 1, solvent cleaning) using lent free wiping rags.
- All cleaned areas shall have protective coating applied before end of shift. If a cleaned surface does not get coated, it shall be re-cleaned on the shift.
- An alternative peel test procedure is recommended prior to application. Please refer to the Viscotaq Technical Manual for full surface preparation and peel test requirements.

2. Viscotaq Viscomastic™

- For optimum application of Viscomastic, the material should have a temperature of above 25°C/77°F.
- Apply Viscomastic at the outer edge of the bell (socket) pipe to create a seal and transition to the spigot pipe. Apply with pressure to force the Viscomastic into the void/joint where the pipes connect. Work the paste to eliminate as many air pockets as possible.
- Taper Viscomastic at an angle from the bell pipe to the spigot end pipe.



(Continued overleaf.)

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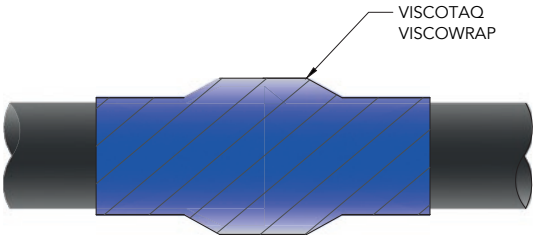
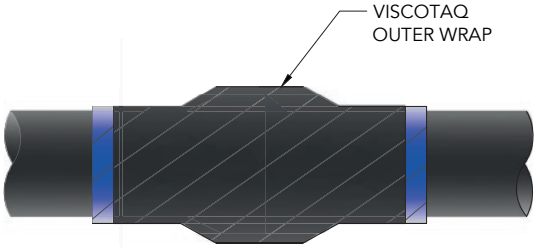
3. Viscotaq Viscowrap™

- Wrap the Viscowrap over the entire joint starting ≥ 8" from the pipe joint and extending ≥ 8" from the connection onto the connected pipe.
- Wrap Viscowrap with a 50% overlap.
- The first wrap should be a straight wrap, then wrap at an angle with slight tension to create a smooth overlap and to ensure no air pockets are formed during wrapping.
- End the wrapping of Viscowrap with a straight circumferential wrap.



4. Viscotaq™ Outer Wrap, HDPE, PE or PVC

- Outer Wrap should be wrapped with a minimum of 50% overlap.
- Outer Wrap should be wrapped in the opposite direction of which the Viscowrap was applied.
- The first wrap should be a straight circumference wrap; followed by wrapping with tension down the pipe.
- Wrapping should end on a 4 o'clock position and last wrap should be applied onto the pipe without tension.
- A 6 mm/ 1⁄4" section of Viscotaq Viscowrap material should be visible after the Outer Wrap has been applied, unless otherwise specified by the end user.

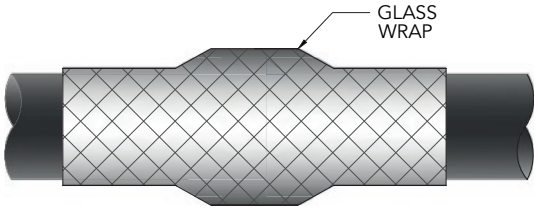


5. Viscotaq™ Glass Wrap

Viscotaq Glass Wrap is recommended for applications that require additional hydrocarbon resistance and/or mechanical protection.

Materials & Tools: Plastic wrap (shrink-wrap), Rubber gloves (heavy duty), Spray bottle (with water), and Scissors.

- Remove Glass Wrap from packaging wearing rubber gloves and spray the wrap with water.
- Glass Wrap cannot be applied at temperatures below freezing.
- Apply Glass Wrap over Viscowrap: Wrap with 50% overlap while continuing to spray with water while applying. A double thickness of the wrap is sufficient for most areas. When applying on uneven surfaces (i.e., casing end seals, flanges) wrap with sufficient tension to create a smooth transition.
- After Glass Wrap is applied, wrap with plastic wrap (shrink wrap) with tension to smooth wrinkles and folds to form one continuous cast.
- Gently poke holes in plastic wrap for ventilation with preferably a punch roller. If you are doing this manually, then poke holes gently at various locations. Holes should be every few inches around the circumference of the pipe.
- When desired, remove plastic wrap when Glass Wrap has cured. Average curing time is 1-3 hours. Glass Wrap can be painted if desired.



Note: Overlap a minimum of 10 cm/4" on the existing factory coating on both sides. Contact Denso for application specific guidelines.

VISCOTAQ™

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