



## Application Procedure for SPLASHTRON Sleeves.

### Rev. 1

SPLASHTRON split wraparound sleeves are made of vulcanized elastomer, sized to fit specific pipe O.D.'s, normally in thickness of ¼", 3/8", and ½". They are installed in the field, over welded joints, where long, continuous SPLASHTRON coverage is required. Their sleeves are adhered to the pipe with Splash Cote 2216.

Splash Cote 2216 is a two-part compound that, when mixed, forms a gray, highly flexible epoxy adhesive, with high shear and peel strengths. Part A is gray in color, and Part B is white.

### Directions for use

#### Surface Preparation:

Splash Cote should be applied to clean, dry surfaces only. Metal should be sandblasted to SSPC-SP5 white metal, if possible, if sandblasting does not permit then use a power tool. For best results with power tool use a MBX Bristle Blaster this tool can be supplied by Mark Tool. Then cleaned to SSPC-SP1 Existing splashtron edges should be wrapped with shrink-rap & then duck-tape.

If pipe is FBE coated or has paint system applied to the pipe. The area needs to be abraded to 1.5 to 3.5 mil profile by using a power tool, MBX Bristle Blaster, or sandblasted.

#### Mixing

Mix part A and part B, using proper mixing ratio, either by weight or volume. Thoroughly blend the two components until a uniform gray color results.

	<u>By Volume</u>	<u>By Weight</u>
Part A (Gray)	3 parts	7 parts
Part B (White)	2 parts	5 parts

Splash cote should be mixed in a container with straight sides. Mix only as much as you expect to use in an hour and a half. Work life at 73.5 degrees F. is approximately 90 minutes, but higher temperature shortens this time.

#### Application:

For small quantities, a spatula or knife is suggested. Up to 1/8" of mixed material should be spread evenly on the prepared metal surface prior to laying on the SPLASHTRON sleeve. Apply adhesive at 60 degrees F., or above.

An alternate method, which is preferable, is to apply 1/16" to the inside of the SPLASHTRON sleeve, and 1/6" to the metal surface. Allow to sit 5 to 10 minutes, or until tacky, then apply the sleeve to the pipe.

### **Hardening:**

Only contact pressure is required for excellent adhesion. Parts must be kept aligned during cure. Mixed adhesive will harden overnight at room temperature. Faster cures are obtainable using elevated temperatures. Do not exceed 200 degrees F. or the quality of the bond may be affected.

### **Notes on Sleeve Application:**

After the split sleeve has been applied to the bare metal, it should be secured and held firmly in place by filament tape. Apply tape first around the middle of the sleeve. Twist the sleeve a quarter turn, to help spread the adhesive uniformly, and bring it back to the original position.

Work the adhesive toward each end of the sleeve with your hands, and then apply filament tape near each end. The tape is sufficient to hold the sleeve in place while the epoxy is curing, providing the sleeve is not subjected to any type of loading, twisting, or rough handling which could cause it to move on the pipe.

All gaps, cracks or crevices should be filled with the mixed epoxy compound. A putty knife is useful for this purpose. If the uncured epoxy is too thin, and tends to run, allow it to sit for 15 to 20 minutes after mixing and it will acquire sufficient viscosity and tackiness to make the application easier.

If the freshly applied sleeve is stressed or worked in any way, such as passing over rollers on a pipe lay barge, shrink sleeves should be applied over the SPLASHTRON sleeve.

The heat used to tighten the shrink sleeve, normally by torch, also accelerates the cure of the epoxy. The shrink sleeve bonds to the SPLASHTRON sleeve, helping prevent movement until it is securely bonded to the pipe.

It is recommended that shrink sleeves be used over all freshly applied SPLASHTRON sleeves to insure strong, continuous, holiday-free coating.

For instructions on how to apply shrink sleeves properly, see the literature available from your shrink sleeve supplier.