

No.59 Series Key to Application



- Petrolatum is dissolved by organic solvents. Avoid using in areas where there is a risk of coming into contact with organic solvents.
- When applying a finish coating, make sure to check the coating's characteristics.
- The application procedures described in this Key To Application are the standard work procedures for small- to medium-diameter piping. It does not apply to piping of sizes that deviate significantly or to structures in a shape that is not referred to.



CAUTION

Thoroughly consider whether this product is suitable for the intended use (objective/conditions) before using.

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CATALOG CODE: 05300 Issued in January 2020

Straight pipes

Application procedure

Straight pipes Elbows Tees Flanges Valves Welding joints

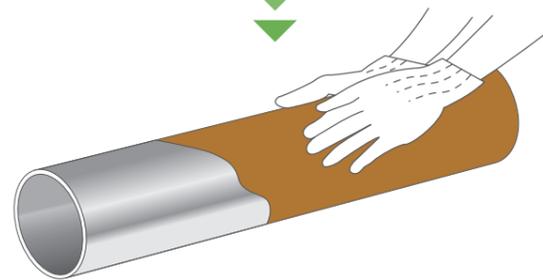
1 Cleaning

Remove rust from the pipe surface using wire brush, hammer etc. When preparation of the surface is finished, wipe away dirt, moisture and oil thoroughly with waste cloth.



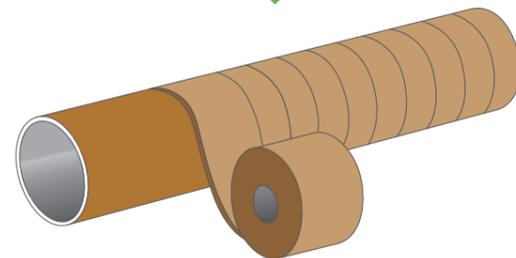
2 Undercoat

Evenly apply No.59PW (primer) by gloves. The standard amount applied per coat is 0.2kg/m²-0.4kg/m².



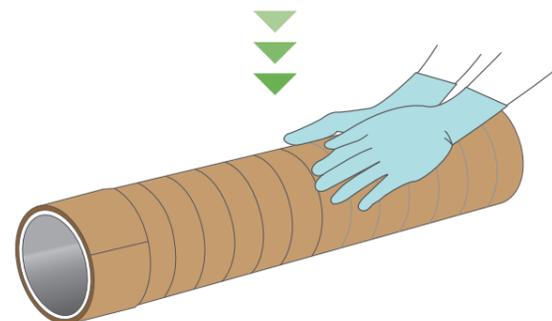
3 Application of tape

Gently pulling the petrolatum tape No.59, wind it around the pipe by 55% lapping.



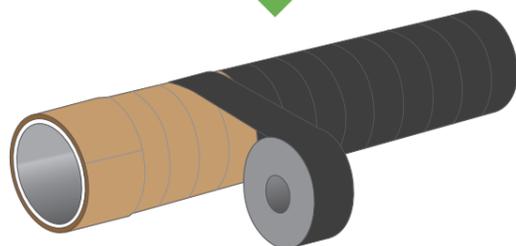
4 Smoothing

After winding the tape, smoothen thoroughly the tape applied with tools such as rubber gloves, pressing roller, rubber spatula etc. Carefully smoothen the tape especially on the edges and lap areas.



5 Application of protecting tape

Wind the protecting tape No.55 to cover wholly the applied tape.



6 Inspection

Check visually and by hand touch to find any flaw, lift or disbondment. Especially, carefully check the lower side and back side which are less visible.

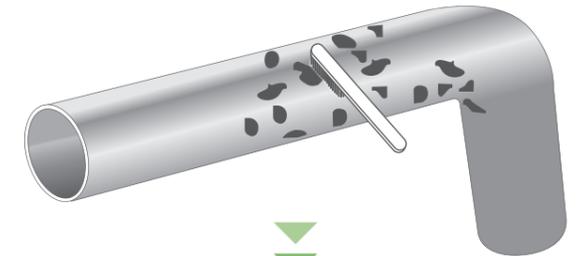
Elbows

Application procedure

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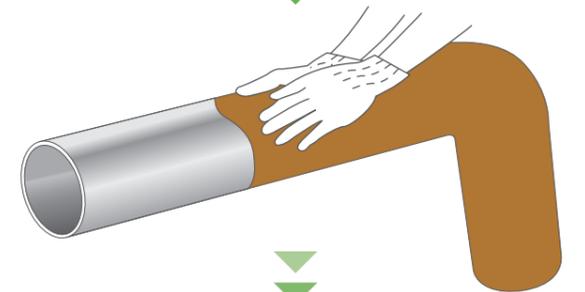
1 Cleaning

Remove rust from the pipe surface using wire brush, hammer etc. When preparation of the surface is finished, wipe away dirt, moisture and oil thoroughly with waste cloth.



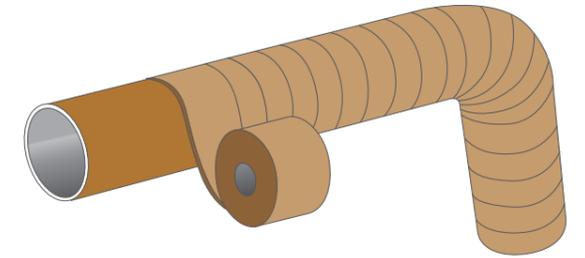
2 Undercoat

Evenly apply No.59PW (primer) by gloves. The standard amount applied per coat is 0.2kg/m²-0.4kg/m².



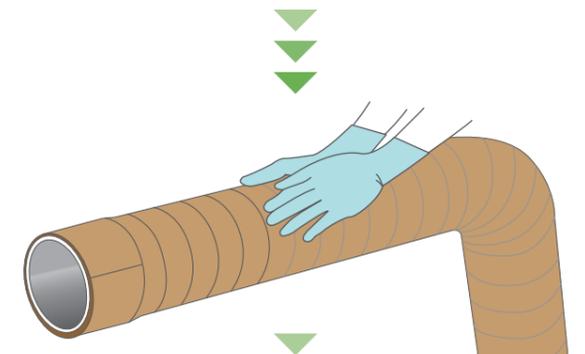
3 Application of tape

Gently pulling the petrolatum tape No.59, wind it around the pipe by 55% lapping.



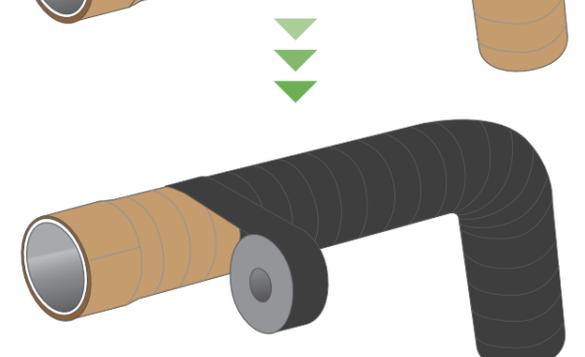
4 Smoothing

After winding the tape, smoothen thoroughly the tape applied with tools such as rubber gloves, pressing roller, rubber spatula etc. Carefully smoothen the tape especially on the edges and lap areas.



5 Application of protecting tape

Wind the protecting tape No.55 to cover wholly the applied tape.



6 Inspection

Check visually and by hand touch to find any flaw, lift or disbondment. Especially, carefully check the lower side and back side which are less visible.

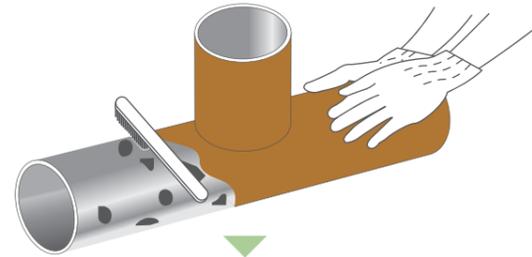
Tees

Application procedure

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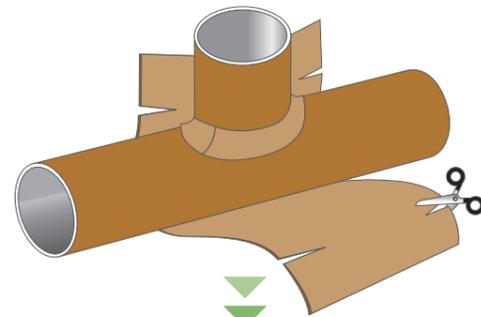
1 Cleaning

Remove rust from the pipe surface using wire brush, hammer etc. When preparation of the surface is finished, wipe away dirt, moisture and oil thoroughly with waste cloth.



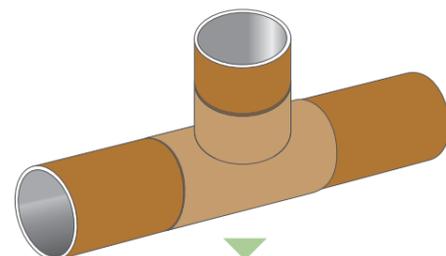
2 Undercoat

Evenly apply No.59PW (primer) by gloves. The standard amount applied per coat is 0.2kg/m^2 - 0.4kg/m^2 .



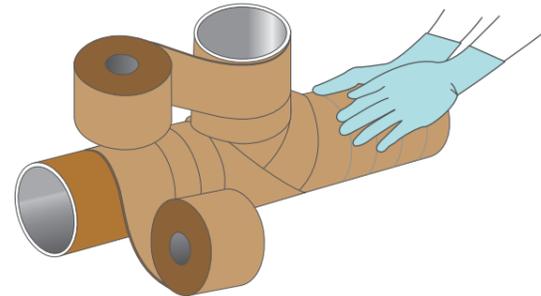
3 Application of tape

(1) Apply the petrolatum tape No.59 to the corner.
(2) Apply the wide tape to the irregularly shaped parts.
(3) Wind the tape around the tee in the form of a cross.
(4) Wind the tape around the riser, starting from the bottom.



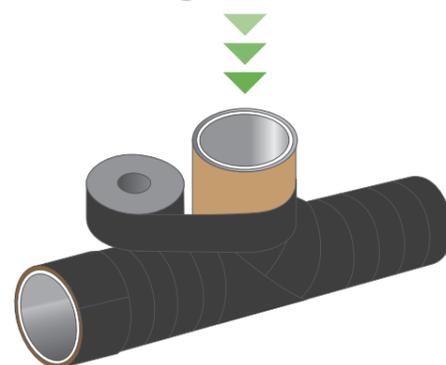
4 Smoothing

After winding the tape, smoothen thoroughly the tape applied with tools such as rubber gloves, pressing roller, rubber spatula etc. Carefully smoothen the tape especially on the edges and lap areas.



5 Application of protecting tape

Wind the protecting tape No.55 to cover wholly the applied tape.



6 Inspection

Check visually and by hand touch to find any flaw, lift or disbondment. Especially, carefully check the lower side and back side which are less visible.

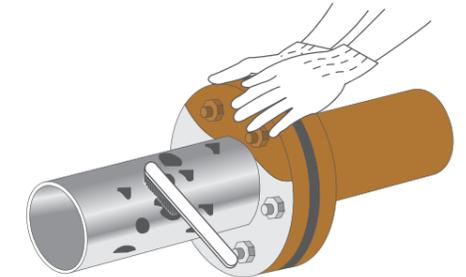
Flanges

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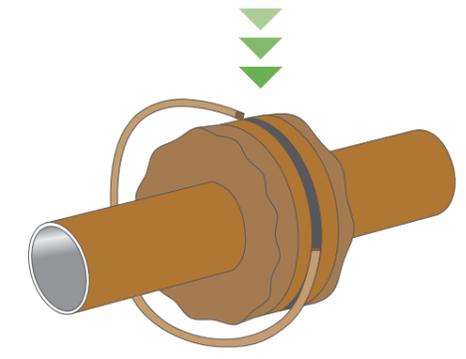
1 Cleaning

Remove rust from the pipe surface using wire brush, hammer etc. When preparation of the surface is finished, wipe away dirt, moisture and oil thoroughly with waste cloth.



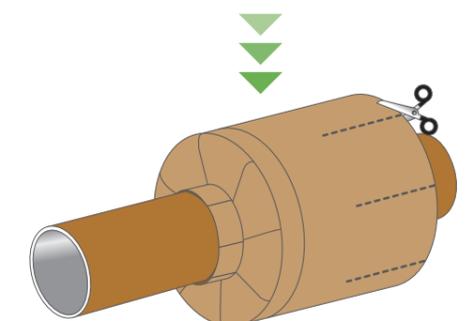
2 Undercoat

Evenly apply No.59PW (primer) by gloves. The standard amount applied per coat is 0.2kg/m^2 - 0.4kg/m^2 .



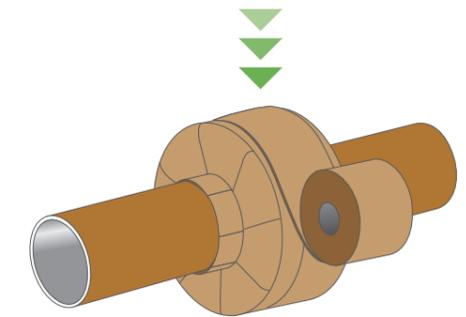
3 Application of tape

(1) Fill the gap of flange with a strip of petrolatum tape No.59 or No.59M (filler).
(2) Cover the bolts and nuts with No.59M (filler).
(3) Wind the wide tape from the center of the flange, covering the left and right fillers, and gather up at each side. make a cut in where the tape is gathered, to prevent undue lift of tape.
(4) Wind the tape additionally around the center of flange.
(5) Wind the tape around the straight pipe.



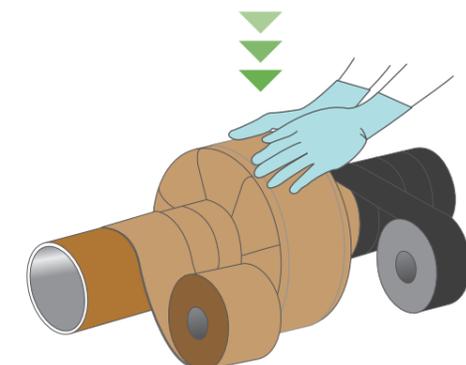
4 Smoothing

After winding the tape, smoothen thoroughly the tape applied with tools such as rubber gloves, pressing roller, rubber spatula etc. Carefully smoothen the tape especially on the edges and lap areas.



5 Application of protecting tape

Wind the protecting tape No.55 to cover wholly the applied tape.



6 Inspection

Check visually and by hand touch to find any flaw, lift or disbondment. Especially, carefully check the lower side and back side which are less visible.

Valves

Application procedure

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1 Cleaning

Remove rust from the pipe surface using wire brush, hammer etc. When preparation of the surface is finished, wipe away dirt, moisture and oil thoroughly with waste cloth.

2 Undercoat

Evenly apply No.59PW (primer) by gloves. The standard amount applied per coat is 0.2kg/m^2 - 0.4kg/m^2 .

3 Application of tape

- (1) For the valve flanges, apply the tape following the procedure specified for the flanges.
- (2) Wind the wide tape around the valve body.
- (3) When winding tape around the irregularly shaped part, make a cut in the tape to prevent undue lift of tape.
- (4) Wind the tape additionally around the left and right sides of the flange, its upper and lower sides, and the center.

4 Smoothing

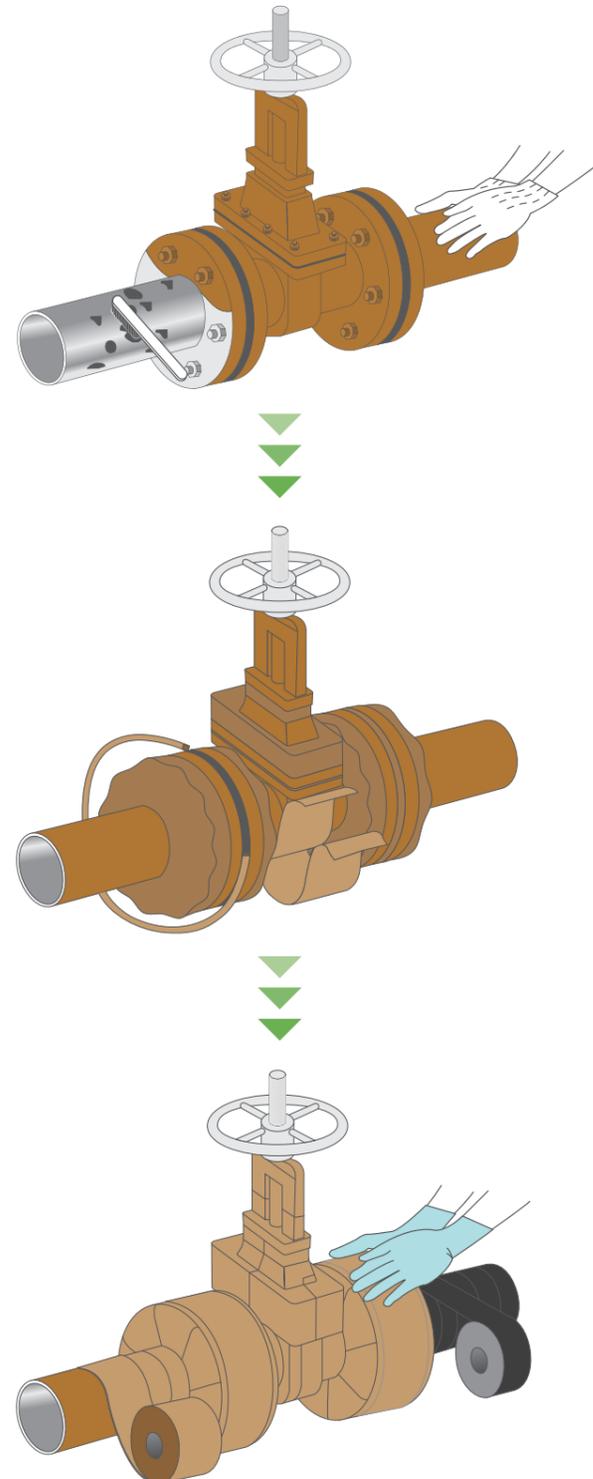
After winding the tape, smoothen thoroughly the tape applied with tools such as rubber gloves, pressing roller, rubber spatula etc. Carefully smoothen the tape especially on the edges and lap areas.

5 Application of protecting tape

Wind the protecting tape No.55 to cover wholly the applied tape.

6 Inspection

Check visually and by hand touch to find any flaw, lift or disbondment. Especially, carefully check the lower side and back side which are less visible.



Welding joints

Application procedure

Straight pipes Elbows Tees Flanges Valves Welding joints

1 Cleaning

Remove rust from the pipe surface using wire brush, hammer etc. Make sure there is no projection on the welding joint. When preparation of the surface is finished, wipe away dirt, moisture and oil thoroughly with waste cloth.

2 Undercoat

Evenly apply No.59PW (primer) by gloves. The standard amount applied per coat is 0.2kg/m^2 - 0.4kg/m^2 .

3 Application of tape

- (1) Wind the petrolatum tape No.59 to cover the welding joint.
- (2) Gently pulling the petrolatum tape No.59, wind it around the pipe by 55% lapping, starting from its ends.

4 Smoothing

After winding the tape, smoothen thoroughly the tape applied with tools such as rubber gloves, pressing roller, rubber spatula etc. Carefully smoothen the tape especially on the edges and lap areas.

5 Application of protecting tape

Wind the protecting tape No.55 to cover wholly the applied tape.

6 Inspection

Check visually and by hand touch to find any flaw, lift or disbondment. Especially, carefully check the lower side and back side which are less visible.

