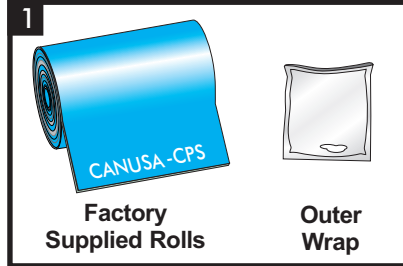


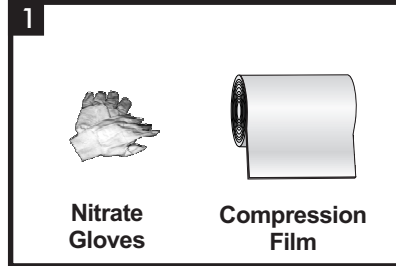
## TBK-VE-XL

Visco-Elastic corrosion and mechanical protection system for pipeline field joints during horizontal directional drilling

### Product Description

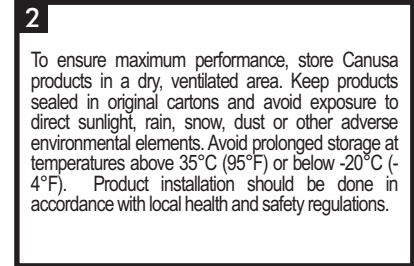


Wrapid Bond™ is typically shipped in pre-cut rolls and is protected from damage and contamination by an inner roll core and a special release liner. Wrapid Coat™ XL is supplied within the kit and is contained in a heat-sealed foil pouch.



**Installer Kit**  
An Installer Kit is supplied separately and includes Compression Film and Nitrile gloves.

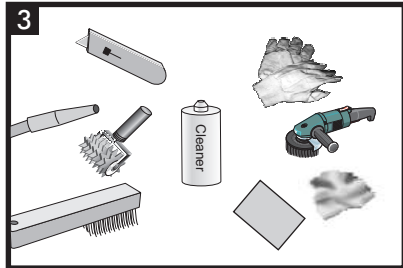
### Storage & Safety Guidelines



These installation instructions are intended as a guide for standard products. Consult your Canusa representative for specific projects or unique applications.

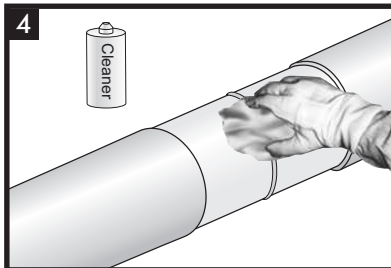
**Wrapid Coat™ XL will set and cure much faster in hot weather.** At temperatures above 30°C (86°F) one or all of the following steps may be taken to cool the product and gain more application time: Submerge unopened foil pouches in cool water before opening. Use cool water to activate. Spray cool water on Wrapid Coat XL™ as it is wrapped rather than immersing entire roll in water to activate.

### Equipment List

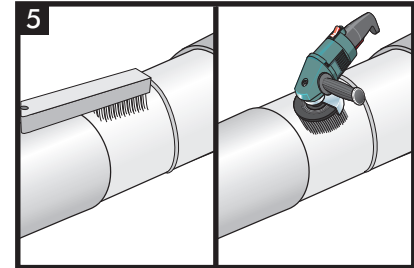


Appropriate tools for surface abrasion and preparation (wire brush/power wire brush or grit blaster, abrasive paper (40-80 grit), Knife, lint free rags, and approved solvent. Standard safety equipment: gloves, safety glasses, hard hat, etc.

### Surface Preparation

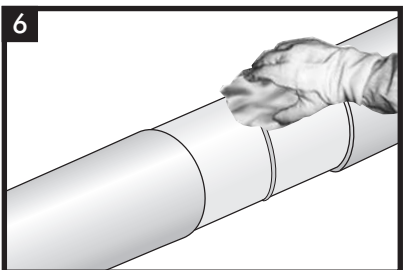


Clean exposed steel and adjacent pipe coating with an approved solvent (Acetone, MEK, Alcohol >96%) to remove the presence of oil, grease, and other contaminants if present. Ensure that the pipe is dry prior to mechanical cleaning.

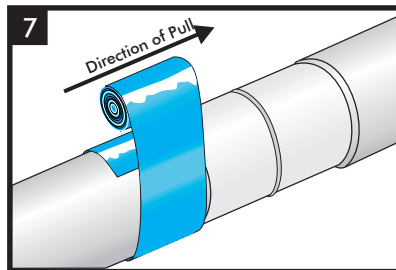


The steel surface should be cleaned using a hand or power wire brush to a minimum St 2 finish prior to coating application. Severely contaminated surfaces should be thoroughly cleaned by abrasive blasting to a "medium blast" Sa 2 surface. Factory coating edges should be abraded for a minimum width of 225mm (9") from the cutback edge or tie-ins to existing coatings using abrasive paper or a grinder with a 40-60 grit flap wheel disc and should be beveled to eliminate the vertical edge.

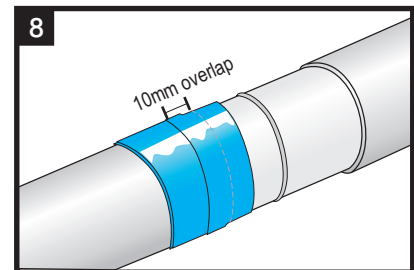
### Product Application



After cleaning, wipe clean or air blast the steel surface and pipe coating to remove foreign contaminants.

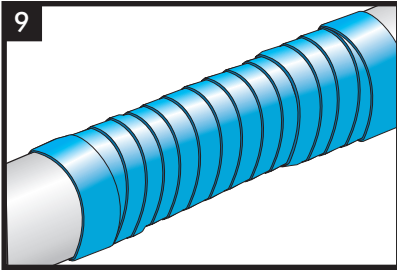


Apply the first wrap of Wrapid Bond™ circumferentially around the pipe at a 90° angle to the pipe and overlapping the factory coating by 50mm (2 inches). Start the wrap in the direction of the pull.

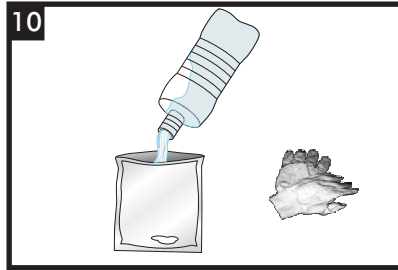


Apply subsequent wraps with a minimum overlap of 10mm (3/8"), or as otherwise specified by either spiral wrapping or circumferential wrapping the material.

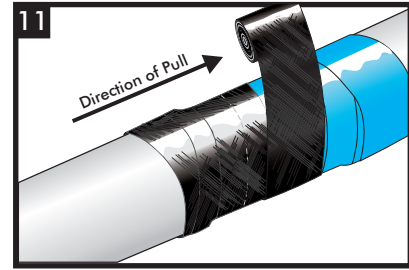
## Outer Wrap Application Wrapid Coat™ XL



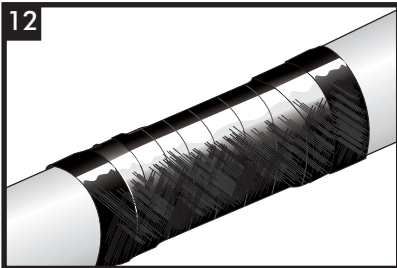
End with a circumferential wrap applied at 90° to the pipe. Ensure the Wrapid Bond™ overlaps the coating by 50mm (2"). Press or roll lightly over the entire coated area.



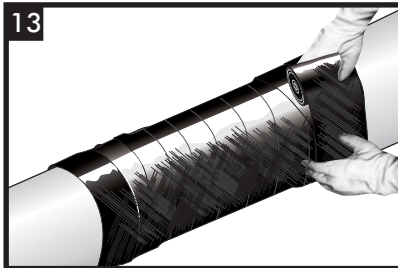
Water is needed to activate Wrapid Coat™ XL. Open the foil pouch, remove the roll, and submerge in tepid water for 10 seconds. Alternatively, water can be poured into the pouch. Once opened, the product cannot be repackaged. For applications in temperatures above 30°C (86°F) use cold water to activate roll. When working on large diameter pipe in hot temperatures Wrapid Coat™ XL may be activated using a water sprayer to mist and wet each layer as it is wrapped.



Begin the application at a distance of 100mm (4") past the inner wrap. Apply the first layer circumferentially around the pipe at a 90° angle then begin spiral wrapping subsequent layers following the wrapping guideline that is printed on the roll. Apply pressure during application by pulling firmly on the roll as it is applied. Squeeze and mold firmly in the direction of the wrap until tight.



End with a circumferential wrap applied at 90° to the pipe. For high shear or impact requirements, additional layers may be specified.

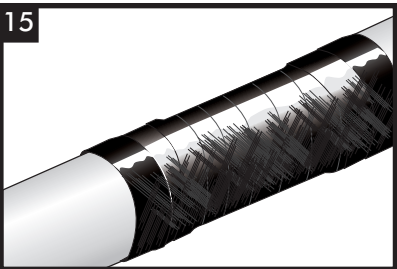


Apply compression film in the same direction as the previous layers with a 50% overlap. Start min. 50mm (2") beyond the outer edge of the Wrapid Coat™ XL, pulling firmly during application. **NOTE: Compression film should be applied before excess foaming is observed from the Wrapid Coat™ XL. A second installer should begin this step and follow the Wrapid Coat™ XL installer(s) as they progress with the wrapping of the pipe. The resin should be compressed and the film perforated as quickly as possible.**



Perforate the compression film using a wire brush (or other perforating device) by tapping firmly on the tape with the metal bristles. Perforation allows the CO<sub>2</sub> gas generated by the curing process to escape. Compression film may be removed after material hardens and either discarded or left in place.

## Prior to Pulling



Allow the Wrapid Coat™ XL to reach a Shore D Hardness of 70 prior to pulling. Wrapid Coat™ XL is fully cured at a Shore D Hardness of 80.

**Note: If holiday inspection is required it must be done after installation of the corrosion coating product is installed because the holiday detector with jeep on residual moisture in the Wrapid Coat™ XL installed product.**



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