

Instructions

Stop It® HP™

Important

Read the entire set of instructions before beginning! The application of this composite repair product involves a number of time sensitive steps that need to be executed in the order described below.

Site Preparation

- The system should be relieved of all pressure until the product is fully applied and cured.
- Before applying STOP IT® HP™, the surface must be prepared by removing any loose scale and any lubricant or grease. This process may involve the use of a wire brush, sandpaper, or solvent cleaner as required (Fig. 1). At a minimum, the surface should be degreased with soap and water and rinsed with clean water.
- Surfaces should be dried prior to application of the first component. The pipe surface should be warmed if less than 50°F (10°C).

Application Procedure

Step 1: Lay out the fabrics to be used in the repair. Use the box lid as a wetting trough and a convenient site for preparing the composite materials (Fig. 2).

Step 2: Remove the plastic end cap from the cartridge assembly and attach the static mixer to the cartridge with the plastic threaded cap. Retain the green plug and attached retaining clip for resealing if entire contents of cartridge are not to be used. Load the dual cartridge assembly into the dispensing gun*.

Note: Do not dispense any resin until immediately before application.

Step 3: Fully depress the cartridge gun trigger four times to load the static mixer and dispense a small quantity of epoxy. Discard this initial material as waste.

Note: The epoxy in the static mixer is now activated and must be expelled within an eight-minute time frame. If the epoxy cures in the mixer, it should be detached and discarded. Attach a new static mixer to the cartridge to use the remaining contents.

Step 4: Apply the indicated amount of epoxy (see cartridge markings) to the surface of the white fabric (Fig. 3a), dispensing the epoxy at even rate. With gloved hands, gently massage the fabric in order to assist the wicking process (Fig. 3b). The fabric should be fully wetted, taking on a translucent appearance. Set aside.

Step 5: Fold the advanced woven tape in half and place into the wetting trough. Dispense the indicated amount of epoxy on to the tape (see cartridge markings). With gloved hands, fold the tape multiple times and knead the tape until fully wetted. (Fig. 4) Unfold the tape, roll from one end, and set aside in the wetting trough for later use.

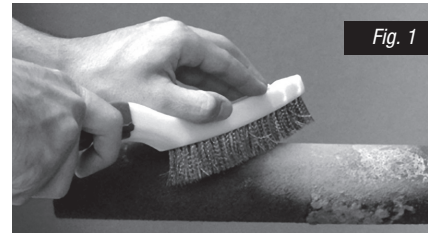


Fig. 1



Fig. 2



Fig. 3a



Fig. 3b

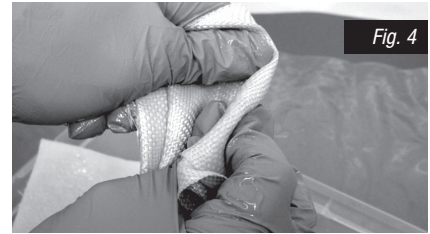


Fig. 4

* Dispensing gun sold separately

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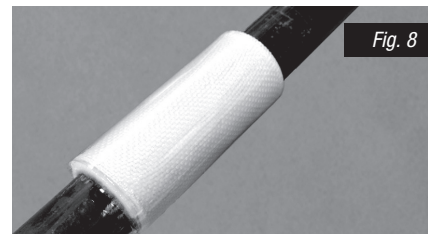
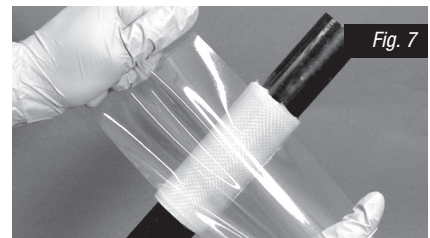
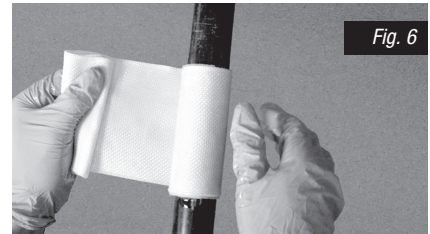
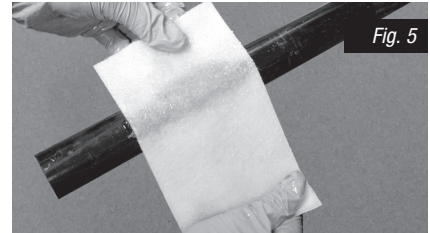
Step 6: Apply a small amount of epoxy directly to the leak site using the spatula provided. Gently work the epoxy across the pipe surface to ensure all features of the repair area are fully wetted. Avoid forming bubbles during this process.

Step 7: Apply the epoxy-soaked white fabric directly over the leak site. (Fig. 5) Gently massage the patch from the center out to the edges to remove any trapped air. Avoid any significant movement of the tape across the pipe's surface.

Step 8: Wrap the epoxy-soaked woven tape around the pipe, directly over the underlying white fabric (Fig. 6). Begin the wrap with one end away from the leak site, securing the underlying fabric during the application of the first layer of tape. Wrap the tape snugly around the pipe, directly overlapping each layer. Do not pull tight.

Step 9: Snugly wrap the clear plastic strip over the woven tape while still wet (Fig. 7), forming multiple layers. Avoid disturbing the underlying layers. The plastic wrap serves to fix the repair composite in place while curing.

Allow to cure for 4 hours (ambient temperature of ~80°F or ~27°C). (Accelerated cures are possible with the STOP® IT HP™ Annealing Kit). Once cured, the plastic strip can be easily removed (Fig. 8). Trim or file any remaining rough edges. Retain the box lid should future repairs be planned for this repair kit.



For technical support contact InduMar:
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