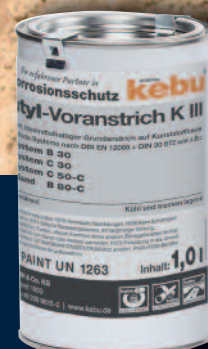
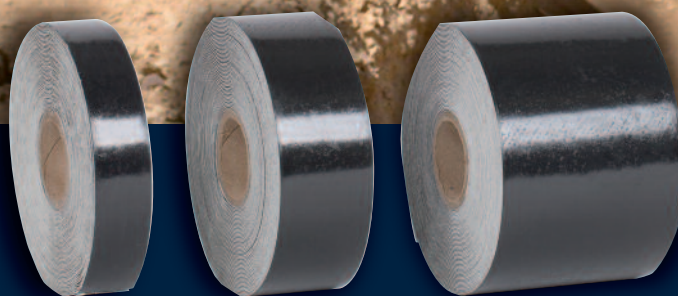


PRODUCT INFORMATION



KEBULEN- TAPE **B 80-C**

Three-ply corrosion protection tape

Corrosion protection system in accordance with DIN EN 12068 and DIN 30 672
load class C, max. operating temperature 50 °C

DIN-DVGW-Registration No. NV-5180AU0468



PRODUCT INFORMATION

GENERAL

Kebulen-Tape B 80-C is a cold-applied three-ply corrosion protection tape. It is used for coating steel pipelines as well as for coating of the welded joints of factory coated steel pipelines of which coating is mentioned in DIN EN 10329, table 2.

Kebulen-Tape B 80-C is constructed asymmetrically in a way that a sufficient amount of butyl rubber (grey) is present on the pipeline side of the tape. This structure almost fully prevents from building of voids. If there are offstanding welding beads or edges of factory coating, **Kebutyl-Kitt** can be used to even the substrate.

The coextruded contact layer (black or yellow) on the outer side of the tape provides the self-amalgamating of the overlaps in a way that they form a homogenous tube. **Kebulen-Tape B 80-C** provides reliable corrosion protection due to its low permeability to water vapour and oxygen.



STRUCTURE

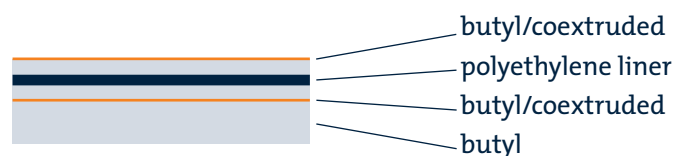
Kebutyl-Primer KIII

solvent based coupling agent
solvent made of butyl rubber and unsaponifiable
resins in organic solvent

Consumption: approx. 0.2 l/m²
Drying time: approx. 3 – 5 minutes.

Kebulen-Tape B 80-C

asymmetric three-ply corrosion protection tape
based on butyl rubber with stabilised polyethylene
liner and total thickness of 0.8 mm



KEBULEN-TAPE B 80-C



PACKAGE

Kebutyl-Primer K III

Consumption/m²

Package

approx. 0.2 ltr.

approx. 1 / 5 / 10 ltr.

Kebulen-Tape B 80-C

black or yellow, three-ply tape, polyethylene tape with asymmetric coating of butyl rubber on both sides.

Roll length

Rolls per box

Tape width

15 m

9

30 mm

15 m

6 or 12

50 mm

15 m

3 or 6

100 mm

Other lengths and widths upon request.

APPLICATION

The area to be coated must be dry. If necessary dry the surface by using a propane torch. **Kebulen-Tape B 80-C** does not require any preheating. Wire-brush the steel substrate thoroughly to remove rust, dirt, residuals of ultrasonic inspection coupling agent as well as temporary end and edge protection.

On steel pipes with a three-layer mill polyolefin coating, the layers of epoxy resin and bonding adhesive on the pipe surface may also be covered by the field coating. To ensure high peel strength roughen the epoxy resin or adhesive using a manual wire brush. Remove any traces of oil and grease by using suitable solvent.

When coating bare steel pipes take special care to ensure that no mill scale is present on the pipe surface. Any mill scale must be blasted to Sa 2.5 in accordance with DIN EN ISO 8501-1.

The edges of polyolefin mill coatings are normally bevelled. Take care to ensure that no voids are formed. Where voids may form, as in the case of straight edges, damages and reinforced factory coatings, prepare the

edges using suitable tools. Semi-circular rasps have proved to be suitable for this purpose. When working on coating edges take care to prevent damages such as notches and cuts in the factory polyolefin coating.

Clean about 100 mm of the factory coating adjacent to the cutback area and roughen it manually using a wire brush.

Apply **Kebutyl-Primer K III** all over the area to be coated using a paint brush or a paint roller. Drying time takes 3 – 5 minutes, depending on the weather.

Apply **Kebulen-Tape B 80-C** beginning and ending with a full circumferential wrap on about 50 mm of the factory coating. Proceed with 50 % overlapping, ensuring to work crease-free. While wrapping remove the release layer.

The wrapping of the second layer follows the same procedure as the first wrapping. Take care to overlap the first wrapping by a minimum of 25 mm.



CONSUMPTION TABLE

The table is valid for coating a field joint with a steel surface of 300 mm and 50 mm of adjacent factory coating on both ends (inner layer). The outer layer overlaps the inner layer by 25 mm on both ends.

DN	Diameter (nominal width)	Kebutyl Primer K III	Kebulen-Tape B 80-C 2 layers, 50% overlap	
			width	m ²
200	219.1 mm	0.06 ltr.	100 mm	1.17 m ²
250	273.0 mm	0.07 ltr.	100 mm	1.46 m ²
300	323.9 mm	0.09 ltr.	100 mm	1.73 m ²
350	355.6 mm	0.10 ltr.	100 mm	1.90 m ²
400	406.4 mm	0.11 ltr.	100 mm	2.17 m ²
	419.0 mm	0.11 ltr.	100 mm	2.24 m ²
500	508.0 mm	0.14 ltr.	100 mm	2.72 m ²
	521.0 mm	0.14 ltr.	100 mm	2.78 m ²
600	609.6 mm	0.17 ltr.	100 mm	3.26 m ²
700	711.2 mm	0.20 ltr.	100 mm	3.80 m ²
800	812.8 mm	0.23 ltr.	100 mm	4.35 m ²
900	914.4 mm	0.25 ltr.	100 mm	4.89 m ²
1000	1016.0 mm	0.28 ltr.	100 mm	5.43 m ²
1100	1120.0 mm	0.31 ltr.	100 mm	5.98 m ²
1200	1220.0 mm	0.34 ltr.	100 mm	6.52 m ²

All quantities are based on abstract calculations.

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- Petrolatum tapes and masses
- Bituminous tapes
- Shrinkable sleeves
- Shrinkable tubular sleeves
- Synthetic patches
- Synthetic resins:
Unsaturated vinyl ester resin
- Kebudur HT 80- System
Butyl rubber combined with GRP
(glassfibre reinforced plastic)

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The information given in this publication is based on our knowledge and experience. The hints and instructions for use given therein have been compiled to the best of our knowledge on the basis of our tests and experience. Best results will be obtained if our products are used in a proper and expert way. Any protected rights and existing laws and regulations must be complied with by the recipient of our products under own responsibility. In all other respects our general terms and conditions shall apply.

Kebulin-Gesellschaft Kettler GmbH & Co. KG

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Ostring 9 | D-45701 Herten | Tel. +49 209 9615-0 | www.kebu.de

