COVALENCE® PE MELT STICK

Product Information

Repair system for damaged mill-applied PE coating.

Product description: PE MELT-STICK is a heat-sensitive, PE copolymer-based stick used for small superficial, damage (scratches) to PE-coatings where the damage does not extend to the bare metal. Maximum damaged area can be 25 mm by 25 mm or 6.25 cm².

Installation is done with a standard gas torch. After eliminating all sharp edges, cleaning and preheating, PE-MELT-STICK is heated above the damaged area until becoming glossy. No filler is required. The molten adhesive is spread onto the scratches, forming a tight bond with the substrate. After cool down, the hardening adhesive is smoothed flush with the PE line coating using a paint scraper.

Features:
- Versatile and adaptable repair system.
- Resistant to high shear forces.
- Excellent adhesion to commercial PE mill-applied coatings.
- Simple stick form.
- No special equipment required.

Benefits:
- Highly economical.
- Double reconstruction of the damaged coating.
- Guarantees a virtually monolithic coating repair of high quality.
- Makes installation faster and more convenient – saves time.
- Makes installation fast and easy. Keeps installation costs low.

Product properties

Adhesive

<table>
<thead>
<tr>
<th>Property</th>
<th>Test method</th>
<th>Typical value</th>
</tr>
</thead>
<tbody>
<tr>
<td>Softening point</td>
<td>ASTM E28</td>
<td>120°C (248°F)</td>
</tr>
<tr>
<td>Shear strength</td>
<td>ASTM D1002</td>
<td>@ 23°C (73°F) 750 psi</td>
</tr>
<tr>
<td></td>
<td></td>
<td>@ 80°C (176°F) 65 psi</td>
</tr>
</tbody>
</table>

Installed sleeve

<table>
<thead>
<tr>
<th>Property</th>
<th>Test method</th>
<th>Typical value</th>
</tr>
</thead>
<tbody>
<tr>
<td>Peel to PE</td>
<td>ASTM D1000</td>
<td>16 lbf</td>
</tr>
</tbody>
</table>

Product order information

Covalence® PE-MELT-STICK type products are available
- As a stick

Example PE-MELT-STICK(S50)

PE-MELT-STICK
- 25 mm x 305 mm

(S50) Packed per 50 pc in a bag

Product selection guide

Max operating temperature 80°C (176°F).
Compatible line coatings PE
Min. preheat temperature 60-70°C (140-158°F)
Recommended pipe preparation Brush
Soil stress restrictions None

Product dimensions

<table>
<thead>
<tr>
<th>Length</th>
<th>Diameter (mm)</th>
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</thead>
<tbody>
<tr>
<td>305 mm (12 in)</td>
<td>25 mm (1 in)</td>
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</table>

General Information

Installation guide
For proper product installation, see latest installation instruction.

Handling
Handle with care. Keep boxes upright.

Storage
Store indoor, clean and dry, away from direct sunlight in a cool place below +50°C. Unlimited shelf life.

Documentation
Extensive information is available on our website. Application instructions and other documentation can be obtained by contacting our head office, from our local distributor or by sending an email to info@sealforlife.com

Certified staff
Application of the described coating system should be carried out by certified personnel.