

**POLYKEN® 932**

**Product Information**

**Product description:** The Polyken® 932 is a cold applied tape coating system designed for the corrosion protection of field joints, fittings and specialty piping. The high tack butyl rubber adhesive is designed for high initial adhesion, even during extreme cold weather applications. The Polyken® 932 tape has a very tacky adhesive and comes with a plastic release liner to enable proper unwinding of the roll. Coupled with the highly conformable polyethylene backing, the 932 adhesive optimally flows, fills and instantaneously bonds to the substrate. The versatile tape system can be applied by hand or with a wrapping machine.

**Features:**

- Heavy duty adhesive.
- Conformable to irregular shapes.
- High tack adhesive.
- Worldwide reference lists.
- Complies with AWWA standard C-209, EN12068, DIN30672.
- Compatible with generic plant coatings systems.

**Benefits:**

- Ensures a strong bond & impervious seal.
- Offers a solution for nearly every application.
- Very useful in extreme cold weather applications..
- Established in-ground history.
- Reliable, high performance corrosion protection.
- Versatile.

**Product selection guide**

<b>Max. operating temperature</b>	50°C (122°F)
<b>Recommended primer</b>	102-ISO or 1033A
<b>Additional mechanical layer</b>	955 or 954
<b>Compatible line coatings</b>	PE, FBE, PP, Cold Tape, CT, CTE
<b>Recommended pipe preparation</b>	SSA-ST2 (SSPC-SP3) or SSA-SA 2 (SSPC-SP6) 1 – 3 mil anchor profile (25 – 76 micron anchor profile)
<b>Performance</b>	AWWA C209 EN 12068 DIN 30672 class B30

**Product construction**

	<b>932-35</b>
Backing	6.5 mils (0.165 mm)
Adhesive	28.5 mils (0.724 mm)
Backing color	Black

**Product properties**

Property	Method	Typical values	
		932-35	Units
<b>Tensile strength</b>	ASTM D 1000	15 2.6	pli N/mm
<b>Elongation</b>	ASTM D 1000	150	%
<b>Peel adhesion to primed steel</b>	ASTM D1000	9.3 1.6	pli N/mm
<b>Peel adhesion to primed steel</b>	EN 12068*	0.8	N/mm
<b>Cathodic disbondment</b>	ASTM G 8	0.25 6.4	in radius mm
<b>Cathodic disbondment</b>	EN 12068*	0.10 2.5	in radius mm
<b>Water vapor transmission</b>	ASTM E 96B	0.07	perm
<b>Water vapor transmission rate</b>	ASTM E 398	0.04 0.6	g/100 in <sup>2</sup> / 24 hr g/m <sup>2</sup> /24 hr
<b>Volume resistivity</b>	ASTM E 257	2.5 x 10 <sup>16</sup>	Ω cm
<b>Dielectric breakdown</b>	ASTM D 1000	650 25.6	V/mil kV/mm
<b>Dielectric strength</b>	ASTM D 149	21	kV
<b>Insulation resistance</b>	ASTM D 1000	1.4 x 10 <sup>7</sup>	MΩ
<b>Impact resistance*</b>	EN 12068	> 8	J
<b>Indentation resistance*</b>	EN 12068 class B30, 1 N/mm <sup>2</sup>	> 0.6	mm remaining coating thickness

\* For 932-35 tape installed with 66% overlap.

**Equation for Pipe Coating Requirements**

<b>Squares** of coating required</b>	$\frac{(\text{width of coating in inches}) \times (\text{area of pipe in square feet})^*}{(\text{width of coating in inches} - \text{overlap in inches}) \times 100}$
* Area of pipe in ft <sup>2</sup> = (diameter in inches / 12) x 3.1416 x length in feet ** One Square = one hundred square feet = 9.29 square meters	
<b>Square meters of coating required</b>	$\frac{(\text{width of coating in mm}) \times (\text{area of pipe in square meter})^*}{(\text{width of coating in mm} - \text{overlap in mm})}$
* Area of pipe in m <sup>2</sup> = (diameter in mm / 1000) x 3.1416 x length in meter	
<b>Squares** per roll</b>	$\frac{(\text{width of roll in inches}) \times (\text{length of roll in feet})}{(12) \times (100)}$
<b>Square meters Per roll</b>	$\frac{(\text{width of roll in mm}) \times (\text{length of roll in m})}{(304.8) \times (30.48)}$
<b>Rolls Required</b>	$\frac{(\text{squares of coating required})}{(\text{squares per roll})}$
<b>Rolls Required</b>	$\frac{(\text{square meters of coating required})}{(\text{square meters per roll})}$

**Ordering information**

Polyken® 932 Tape Coatings are available in roll form.  
Example **932-35 BLK 2X50 ft 4.1cm**

932	Product type	Standard Ordering options
35	Total tape thickness in mils	35 mils (0.89 mm)
BLK	Tape backing color	Black (BLK)
2	Tape width in inches	2" (50 mm), 4" (101 mm), 6" (152 mm)
50	Tape roll length in feet	50 ft (15 m)
4.1	Tape inner core diameter	4.1 cm (1.6")

For other ordering options please contact your Seal For Life representative.

Application instruction: Job preparation	
<b>Tools, equipment and auxiliaries</b>	Temperature gauge, DFT/WFT gauge, Primer application equipment/agitator, Tape application equipment, Coating "hot box"
<b>Additional coating materials</b>	933-25 weld seam coating, 931 or 939 filler material, and 905, 954, or 955 mechanical protection layers
<b>High humidity</b>	Polyken® 932 can be applied in a humid atmosphere. The substrate should be free from condensing water which can be reached by keeping the temperature at least 5°F (3°C) above dew point.
<b>Work area and substrate</b>	The substrate surface should be dry, clean and protected against negative weather influences.
<b>Product conditions</b>	The Polyken® 932 shall be stored and/or transported in a dry, ventilated location. Storage temperature shall be a minimum of 60°F (16°C) and a maximum of 120°F (49°C). The minimum primer and roll body temperature for application will be 60°F (16°C).

Application instruction: Surface preparation	
<b>General</b>	The area to be coated has to be clean, dry, and free from oil, grease and dust. All contamination including mill-scale has to be removed.
<b>Degreasing</b>	Degrease surfaces with Toluene or Heptane and e.g. a lint-free cloth.
<b>Preventing condensation of water</b>	Prior to and during the application, the temperature of the substrate(s) must be at least 5°F (3°C) above the dew point.
<b>Substrate temperature</b>	Temperature of the substrate should preferably be between 68°F and 104°F (20°C / 40°C). Preheating may be required.

Application instruction: Brief version	
<b>Step 1</b>	Clean substrate to SSA-ST2, SSPC-SP3 (power wire brush) or SSA-SA 2, SSPC-SP6 (commercial blast). Surface (anchor) profile depth shall be no less than 1.0 mils (25 micron) and no greater than 3 mils (76 micron).
<b>Step 2</b>	Uniform primer application achieving 2 to 3 mil WFT. Primer should be "dry to touch" before application of inner layer.
<b>Step 3</b>	If required, apply weld seam coating or filler material

\* For further detailed information, please view the corresponding Application Guideline \*

<b>Step 4</b>	Spirally or circumferentially apply the 932 with a 1% to 2% neckdown. A minimum of two layers of the 932 shall be applied.
<b>Step 5</b>	If a single 932 layer is required, then a mechanical protection outerwrap layer (905, 954, 955) shall be applied over the single layer of 932.
<b>Step 6</b>	Perform holiday detection per NACE SP0274

Handling and commissioning	
<b>Exposure to loads</b>	Objects coated with Polyken® 932 should not be exposed to loads e.g. from supports- or lifting equipment.
<b>Backfill</b>	Backfill is possible immediately after completion of the coating application. Consult application guidelines for specific instructions. Backfill should be clean and not contain any foreign items that can cause damage to the coating system.

Information	
<b>Documentation</b>	Extensive information is available on our website. Application instructions and other documentation can be obtained by contacting our offices, from our local distributor or by sending an email to <a href="mailto:info@sealforlife.com">info@sealforlife.com</a>
<b>Certified staff</b>	Application of the described coating system should be carried out by certified personnel.

OFFICIALLY DISTRIBUTED BY:



**TESI S.p.A.** - Sede Amministrativa/Head Office : Via Piave 20/11 - 20071 Vermezzo con Zelo (MI) ITALY  
 TEL +39 02 944.05.01 FAX +39 02 944.90.87  
 Cap.Soc. €200.000,00 R.E.A.MI 1034861 Reg. Imp. 04745310153 MI C.F. e P.IVA / VAT Number IT 04745310153  
[www.tesigroup.com](http://www.tesigroup.com) e-mail: [info@tesigroup.com](mailto:info@tesigroup.com) [info@pec.tesigroup.eu](mailto:info@pec.tesigroup.eu)  
 Sede Legale/Registered Office : Via Meravigli, 16 - 20123 Milano, ITALY