

Primerless Twist Tape

A Stretchable, Hand-wrapped Heat Shrink Band

Features



High adhesion



Wide compatibility coating



No primer needed



Flexible operation



Our Primerless Twist Tape features a cross-linked polyolefin backing material coated with a heat-resistant and corrosion-resistant protective adhesive. This ensures secure adhesion to steel substrates and common coatings, including PE, FBE, adhesive tapes, and coal tar. Specifically engineered for the protective repair of small-diameter pipelines, pipe fittings, elbows, tees, and other irregular structures, this product demonstrates superior performance.

Description

Its unique cross-linking process fully encapsulates substrates during heating, offering exceptional wear resistance and damage resistance. Additionally, it provides high resistance values, low water absorption, minimal moisture permeability, and outstanding resistance to acid, alkali, salt, and chemical corrosion. The tape is available in multiple width specifications for roll packaging, ensuring convenient application during construction.



Storage and Shelf Life

This product should be stored in a clean, dry, and well-ventilated indoor environment away from direct sunlight. During transportation, it must remain under identical conditions and be covered. The temperature range must not fall below -30°C (-22°F) or exceed $+50^{\circ}\text{C}$ ($+122^{\circ}\text{F}$), with humidity controlled at 75%. The shelf life is three years (re-inspection required after expiration).

| Properties | | Typical Value | Test Method |
|--------------------------------------|-------|---|-------------|
| Backing | | | |
| Backing as Supplied | | ≥0.5mm (≥0.020in) | ASTM D1000 |
| Adhesive as Supplied | | ≥0.7mm (≥0.028in) | ASTM D1000 |
| Elongation | | ≥600% | ASTM D638 |
| Tensile Strength | | ≥22MPa (324.47lbs/in) | ASTM D638 |
| Hardness | | 46 Shore D | ASTM D2240 |
| Specific Gravity | | 0.93g/cm ³ | ASTM D792 |
| Corrosion Resistant Adhesives | | | |
| Softening Point | | 95°C (203°F) | ASTM E28 |
| Lap Shear Strength @10mm/min | @23°C | 1.20N/mm ² (174psi) | EN 12068 |
| | @50°C | 0.51N/mm ² (74psi) | |
| Status After Installation | | | |
| Peel to Steel @10mm/min | @23°C | 7.6N/mm (694oz/in) | EN 12068 |
| | @50°C | 1.3N/mm (119oz/in) | |
| Cathodic Disbondment | | 6mm (0.236in) rad | ASTM G8 |
| Water Absorption | | <0.05% | ASTM D570 |
| Dielectric Voltage Breakdown | | 27kV/mm | ASTM D149 |
| Low Temp. Flexibility | | -20°C (-4°F) | ASTM D2671C |
| Operating Temperature | | 60°C (140°F) | ASTM D3359 |
| Minimum Installation Temp | | ≥65°C (≥150°F) | ASTM D3359 |
| Fully Recovered Thickness | | ≥1.5mm (0.59in) | ASTM D1000 |
| Compatibility Coating | | CT、PU、PE、PP、FBE | |
| Color | | Black | |
| Available Roll Size (width * length) | | 35 to 300mm X 10 to 20m (1.38 to 11.81in X 32.81 to 65.2ft). Customizable. | |

General Requirements for Applications

General: The area to be coated has to be cleandry, and free from oil, grease and dust. All contamination including mill-scale has to be removed.

Degreasing: Degrease surfaces with Toluene or Heptane and e.g. a lint-free cloth.

Working surface temperature Preheating of the working surface temperature +65°C to 90°C (150°F to 194°F).

For concave or irregular working surfaces, butyl rubber filler should be used to correct excessive treatment.

Application Instruction

Step 1

Clean the working surface to ST3 or SA2½.

Step 2

With spiral twist shrink tape, ensure that the overlapping width is 50% to 55%.

Step 3

Keep uniform overlap and remove the release film. Always use flame to shrink the outer surface of the belt. It is better to have less overflow of glue at the overlap.

Step 4

During the installation process, adjust the uniform heating of the flame according to the operating temperature requirements to avoid bulging and wrinkling. If wrinkling or bubbling occurs during operation, treat it with silica gel roller in time to achieve flatness and compaction.

Step 5

Perform holiday detection per NACE SP0274 Handling and commissioning.

Friendly Reminder

The backfill should be kept clean and should not contain any foreign matter that could damage the coating system.

For more technical inquiries, please visit our website.

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