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°C (+122°F), with humidity controlled at 75%. The shelf life is three years (re-inspection required after expiration).

Technical Data Sheet

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/mm² (174psi)	EN 12068
	@50°C	0.51N/mm² (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 SA21/2.

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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