

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 selection guide

Max operating temperature	85°C (185°F).
Compatible line coatings	PE
Min. preheat temperature	60-70°C (140-158°F)
Recommended pipe preparation	Brush
Soil stress restrictions	None

Product dimensions

Length	305 mm (12 in)
Diameter (mm)	25 mm (1 in)

Product properties

Adhesive

Property	Test method	Typical value
Softening point	ASTM E28	120°C (248°F)
Shear strength	ASTM D1002	750 psi
	@ 23°C (73°F)	65 psi
	@ 80°C (176°F)	

Installed sleeve

Property	Test method	Typical value
Peel to PE	ASTM D1000	16 lb/in

Product order information

Covalence® PE-MELT-STICK type products are available

– As a stick

Example PERP-MELT-STICK(S50)

Standard ordering options

PERP-MELT-STICK	Ø 25 mm x 305 mm
(S50)	Packed per 50 pc in a bag

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 web-site. 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.