



Procedures for Sealing Cut Ends and Repairing Field Damaged Areas of SG-14™ Glass Lined Pipe and Fittings

Field cutting, field grooving, and /or fabrication of glass lined pipe is NOT acceptable, except for an occasional closure piece where a final field measurement is necessary. Welding on glass lined pipe is NOT acceptable at any time.

Each repair kit will contain part A & B epoxy containers, a brush, two utensils, and a piece of sandpaper. Rags and cleaning solvent are NOT included.

Instructions:

1. Field cuts should be made using a high speed cut-off saw, diamond blade saw, or power hacksaw type cutter to minimize any chipping at the cut edge.
 - a. Any chipping of the glass lining should be limited to 1/16th to 1/8th of an inch.
2. Remove burrs caused by field cutting of ends or handling damage and smooth out the edge of the lining if rough.
3. Remove all traces of oil, grease, asphalt, dust, dirt, etc. using a clean rag and cleaning solvent.
4. Remove any damaged lining caused by field cutting operations or handling and clean any exposed metal by sanding or scraping. Sandblasting or power tool cleaning or roughening is also acceptable although care should be used to not further damage the glass surface with blast media. Remove any loose lining.
5. The area to be sealed or repaired must be absolutely clean and roughened, apply a coat of SG-14™ Glass Repair Epoxy using the following procedure:
 - a. The repair kit contains two small cans of a two-component epoxy, marked as Part "A", and part "B".
 - b. Mix thoroughly one part of the activator to 4 parts of the "base" material using the wooden paddle included in the kit.
 - Do NOT use the same utensil to take material from the "A" and "B" containers. That will cause contamination of the containers and reduce the shelf life.
 - c. Only mix as much material as will be needed within 1 hour. Once mixed, the activator will limit the usable life of the material.

- d. Apply to surface to be repaired using the brush provided, overlapping onto the glass at least 1 inch onto sound SG-14™ Glass Lining.
- 6. It is recommended that the repair epoxy be allowed to dry for 30-45 minutes, then apply a thin second coating. After 30-35 minutes (depending on weather conditions), the piece can be installed.
- 7. Technical Data for SG-14™ Glass Repair Epoxy
 - a. Description- A brush able polyamide epoxy designed for sealing ends and repairs when pipes are lined with SG-14™ Glass Lining.
 - b. Limitation- Glass repair epoxy should be used over glass or bare metal for repairing cut ends of pipe or small damaged areas. The glass repair epoxy must be used over properly prepared ductile iron or steel surfaces or roughened glass surface.
 - c. The surface preparation shall be equal to the specifications for the project or as outlined above. Do not apply glass repair over wet or frozen surfaces or glass surfaces that have not been roughened.
 - d. Dry film thickness should be per specifications standards, usually 3.0-5.0 mils per coat in two coats, or 6.0-10.0 mils dry film thickness.