Nitto

NITOHULLMAC XG Series Key to Application



Cautions for use

•Please apply under good weather.

- •If rain, cloud of dust, freezing, or dew condensation is expected, please avoid application.
- •If the above is expected to occur when beginning or ending the application, please prepare an appropriate covering.
- •When applying indoors, make sure to ventilate the room well.

Nitto Denko Corporation

Tokyo Sales Branch: 10th Fl., East Tower, Gate City Ohsaki, 1-11-2, Ohsaki, Shinagawa-ku, Tokyo 141-0032, Japan TEL: +81-3-5740-2035 FAX: +81-3-5740-2251 http://www.nitto.com/jp/en/ CATALOG CODE: 11206 Issued in October 2013

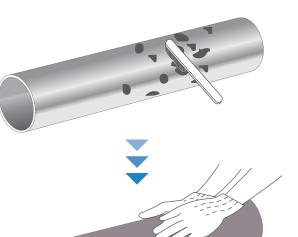


Straight pipes

Straight pipes	Elbows	Tees	Flanges	Valves
Around the base of tanks	Around the base of tanks reinforcing member	Around the base of tanks welding bead	H section steel	Angle section steel / Channel section steel

Cleaning

Remove rust from the pipe surface using wire brush, hammer etc. When preparation of the surface is finished, wipe away dirt, moisture and oil thoroughly with waste cloth.



Application procedure

Undercoat

Evenly apply Nitohullmac XG-PN (primer) by gloves. Make sure that the primer is mixed well before use. The standard amount applied per coat is 0.2kg/m²-0.3kg/m².

Application of tape

Gently pulling the Nitohullmac XG (tape), wind it around the pipe by 55% lapping.

Smoothing

After winding the tape, smoothen thoroughly the tape applied with tools such as rubber gloves, pressing roller, rubber spatula etc. Carefully smoothen the tape especially on the edges and lap areas.

Topcoat

Evenly apply Nitohullmac XG-T or XG-TLW (topcoat) with a brush or a roller brush. The standard amount applied per coat is XG-T:0.3kg/m², XG-TLW:0.5kg/m².

Inspection

Check visually and by hand touch to find any flaw, lift or disbondment. Especially, carefully check the lower side and back side which are less visible.

Elbows

Straight pipes	Elbows	Tees
Around the base of tanks	Around the base of tanks reinforcing member	Around the bas welding b

Cleaning

Remove rust from the pipe surface using wire brush, hammer etc. When preparation of the surface is finished, wipe away dirt, moisture and oil thoroughly with waste cloth.

Undercoat

Evenly apply Nitohullmac XG-PN (primer) by gloves. Make sure that the primer is mixed well before use. The standard amount applied per coat is 0.2kg/m²-0.3kg/m².

Application of tape

Gently pulling the Nitohullmac XG (tape), wind it around the pipe by 55% lapping.

Smoothing

After winding the tape, smoothen thoroughly the tape applied with tools such as rubber gloves, pressing roller, rubber spatula etc. Carefully smoothen the tape especially on the edges and lap areas.

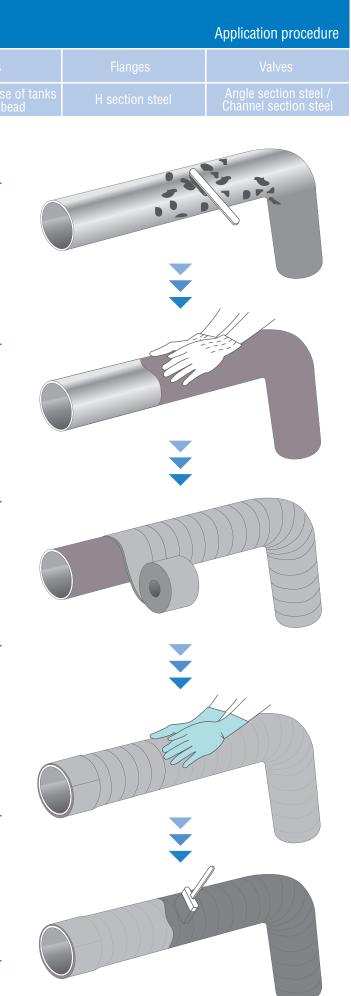
Topcoat

Evenly apply Nitohullmac XG-T or XG-TLW (topcoat) with a brush or a roller brush. The standard amount applied per coat is XG-T:0.3kg/m², XG-TLW:0.5kg/m².

Inspection

Check visually and by hand touch to find any flaw, lift or disbondment. Especially, carefully check the lower side and back side which are less visible.





Tees

Application procedure

Straight pipes	Elbows	Tees	Flanges	Valves
Around the base of tanks	Around the base of tanks reinforcing member	Around the base of tanks welding bead	H section steel	Angle section steel / Channel section steel

Cleaning

Remove rust from the pipe surface using wire brush, hammer etc. When preparation of the surface is finished, wipe away dirt, moisture and oil thoroughly with waste cloth.

Undercoat

Evenly apply Nitohullmac XG-PN (primer) by gloves. Make sure that the primer is mixed well before use. The standard amount applied per coat is 0.2kg/m²-0.3kg/m².

Application of tape

(1)Apply the Nitohullmac XG (tape) to the corner.
(2)Apply the wide tape to the irregularly shaped parts.
(3)Wind the tape around the tee in the form of a cross.
(4)Wind the tape around the riser starting from the bottom.

Smoothing

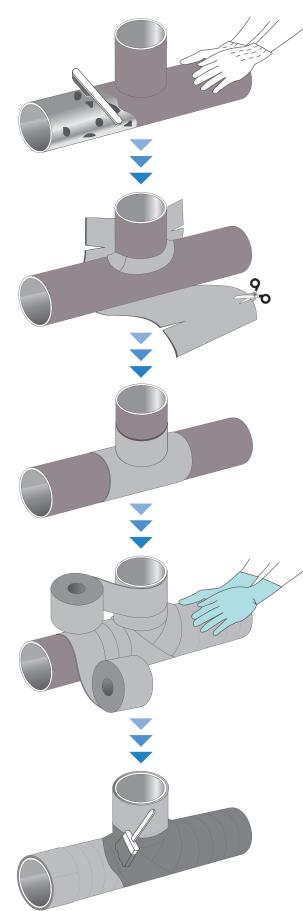
After winding the tape, smoothen thoroughly the tape applied with tools such as rubber gloves, pressing roller, rubber spatula etc. Carefully smoothen the tape especially on the edges and lap areas.

Topcoat

Evenly apply Nitohullmac XG-T or XG-TLW (topcoat) with a brush or a roller brush. The standard amount applied per coat is XG-T:0.3kg/m², XG-TLW:0.5kg/m².

Inspection

Check visually and by hand touch to find any flaw, lift or disbondment. Especially, carefully check the lower side and back side which are less visible.



Flanges

Straight pipes	Elbows	
Around the base of tanks	Around the base of tanks reinforcing member	Around the bas welding b

Cleaning

Remove rust from the surface using wire brush, hammer etc. When preparation of the surface is finished, wipe away dirt, moisture and oil thoroughly with waste cloth.

Undercoat

Evenly apply Nitohullmac XG-PN (primer) by gloves. Make sure that the primer is mixed well before use. The standard amount applied per coat is 0.2kg/m²-0.3kg/m².

Application of tape

- (1)Fill the gap of flange with a strip of Nitohullmac XG (tape) or XG-M (filler).
- (2)Cover the bolts and nuts with XG-M (filler).
- (3)Wind the wide tape from the center of the flange, covering the left and right fillers, and gather up at each side. Make a cut in where the tape is gathered, to prevent undue lift of tape.
- (4)Wind the tape additionally around the center of flange.(5)Wind the tape around the straight pipe.

Smoothing

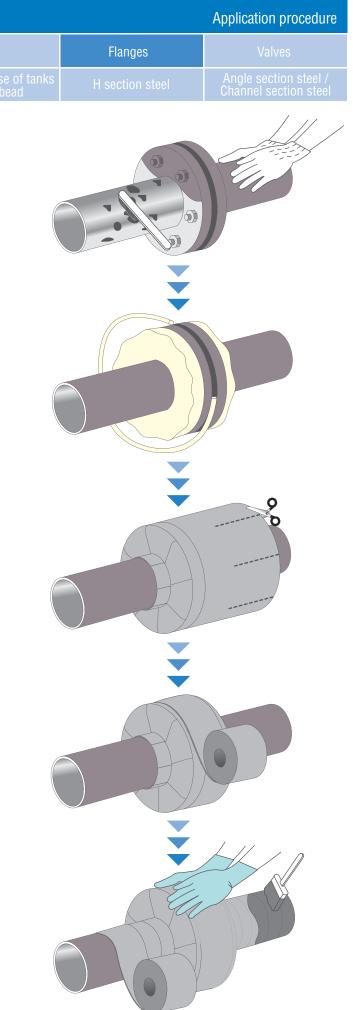
After winding the tape, smoothen thoroughly the tape applied with tools such as rubber gloves, pressing roller, rubber spatula etc. Carefully smoothen the tape especially on the edges and lap areas.

Topcoat

Evenly apply Nitohullmac XG-T or XG-TLW (topcoat) with a brush or a roller brush. The standard amount applied per coat is XG-T:0.3kg/m², XG-TLW:0.5kg/m².

Inspection

Check visually and by hand touch to find any flaw, lift or disbondment. Especially, carefully check the lower side and back side which are less visible.



Valves

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	phoa			

Straight pipes	Elbows	Tees	Flanges	Valves
Around the base of tanks	Around the base of tanks reinforcing member	Around the base of tanks welding bead	H section steel	Angle section steel / Channel section steel

Cleaning

Remove rust from the surface using wire brush, hammer etc. When preparation of the surface is finished, wipe away dirt, moisture and oil thoroughly with waste cloth.

Undercoat

Evenly apply Nitohullmac XG-PN (primer) by gloves. Make sure that the primer is mixed well before use. The standard amount applied per coat is 0.2kg/m²-0.3kg/m².

Application of tape

(1)For the valve flanges, apply the tape following the procedure specified for the flanges (P.4).

- (2)Wind the wide tape around the valve body.(3)When winding tape around the irregularly shaped part, make a cut in the tape to prevent undue lift of tape.
- (4) Wind the tape additionally around the left and right sides of the flange, its upper and lower sides, and the center.

Smoothing

After winding the tape, smoothen thoroughly the tape applied with tools such as rubber gloves, pressing roller, rubber spatula etc. Carefully smoothen the tape especially on the edges and lap areas.

Topcoat

Evenly apply Nitohullmac XG-T or XG-TLW (topcoat) with a brush or a roller brush. The standard amount applied per coat is XG-T:0.3kg/m², XG-TLW:0.5kg/m².

Inspection

Check visually and by hand touch to find any flaw, lift or disbondment. Especially, carefully check the lower side and back side which are less visible.

		base

Straight pipes	Elbows	Tees	
Around the base of tanks	Around the base of tanks reinforcing member	Around the base of tanks welding bead	Н

Cleaning

Prepare the side surface and flange of the tank as with the straight pipe section. Remove the unevenness and flatten the mortar surface. When preparation is finished, remove dust, water and oil completely with waste cloth.

Undercoat

After mixing the primers well, evenly apply NITOHULLMAC XG-PN (primer) on the side / flange of the tank by gloves, and NITOPRIMER AF (primer) on the mortar surface using a brush or a roller brush. Apply two coats of AF on the mortar surface (apply the second coat when the first coat is dry to the touch). The standard amount applied per coat is XG-PN:0.2kg/m²-0.3kg/m², AF:0.2kg/m².

Application of tape

(1)Embed NITOHULLMAC XG-M (filler) in the corner area.

(2)Cut a wide tape (200mm-300mm) into approx.
500mm-1000mm strips in advance, and apply them radially from the circumference of the tank.
(3)Apply a wide tape (150mm) around the side of the

(3)Apply a wide tape (150mm) around the side of the tank.

Smoothing

After applying the tape, smoothen thoroughly with tools such as rubber gloves, pressing roller, rubber spatula etc. Carefully smoothen the tape especially on the edges and lap areas.

Topcoat

Evenly apply Nitohullmac XG-T or XG-TLW (topcoat) with a brush or a roller brush. The standard amount applied per coat is XG-T:0.3kg/m², XG-TLW:0.5kg/m².

Inspection

Check visually and by hand touch to find any flaw, lift or disbondment.

of tanks

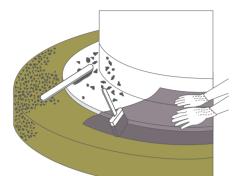
Application procedure

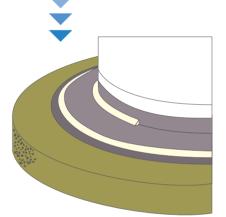
Flanges

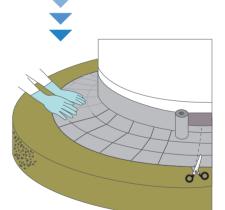
H section steel

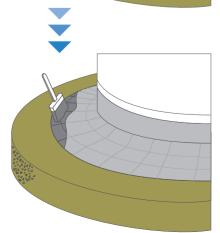
Valves

Angle section steel / Channel section steel









Around the base of tanks - reinforcing member

				Application procedure
Straight pipes	Elbows	Tees	Flanges	
Around the base of tanks	Around the base of tanks reinforcing member	Around the base of tanks welding bead	H section steel	Angle section steel / Channel section steel

Cleaning

Prepare the side surface and flange of the tank as with the straight pipe section. Remove the unevenness and flatten the mortar surface. When preparation is finished, remove dust, water and oil completely with waste cloth.

Undercoat

After mixing the primers well, evenly apply NITOHULLMAC XG-PN (primer) on the side / flange of the tank by gloves, and NITOPRIMER AF (primer) on the mortar surface using a brush or a roller brush. Apply two coats of AF on the mortar surface (apply the second coat when the first coat is dry to the touch). The standard amount applied per coat is XG-PN:0.2kg/m²-0.3kg/m², AF:0.2kg/m².

Application of tape

- (1) Embed NITOHULLMAC XG-M (filler) in the corner areas of the tank and reinforcing member.
- (2) Apply a wide tape (150mm) on the reinforcing member.
- (3)Cut a wide tape (200mm-300mm) into approx. 500mm-1000mm strips in advance, and apply them radially from the circumference of the tank. Cut off the section that overlaps the reinforcing member.

(4) Apply a wide tape (150mm) around the side of the tank.

Smoothing

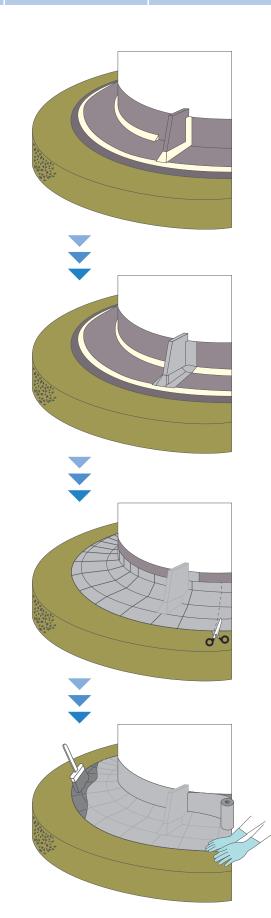
After applying the tape, smoothen thoroughly with tools such as rubber gloves, pressing roller, rubber spatula etc. Carefully smoothen the tape especially on the edges and lap areas.

Topcoat

Evenly apply Nitohullmac XG-T or XG-TLW (topcoat) with a brush or a roller brush. The standard amount applied per coat is XG-T:0.3kg/m², XG-TLW:0.5kg/m².

Inspection

Check visually and by hand touch to find any flaw, lift or disbondment.



Around the base of tanks - welding bead

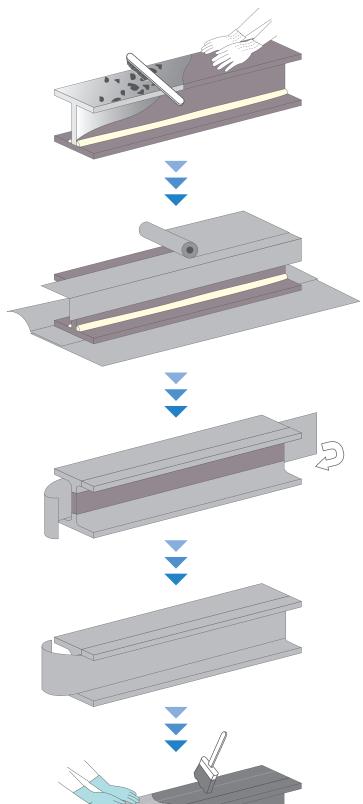
			.	Application procedure
Straight pipes	Elbows	Tees	Flanges	Valves
Around the base of tanks	Around the base of tanks reinforcing member	Around the base of tanks welding bead	H section steel	Angle section steel / Channel section steel
with the stra unevenness a preparation is completely with	de surface and flange c aight pipe section. I nd flatten the mortar si finished, remove dust, n waste cloth.	Remove the urface. When		
Undercoa	at			
NITOHULLMA of the tank (primer) on the roller brush. A surface (apply is dry to the to	the primers well, e C XG-PN (primer) on the by gloves, and NITO e mortar surface using apply two coats of AF of the second coat when ouch). The standard an -PN:0.2kg/m ² -0.3kg/m ² , A	e side / flange PRIMER AF a brush or a on the mortar the first coat nount applied		
Applicati	ion of tape			
area of the t (2)Apply a na bead. (3)Cut a wide 500mm-100 them radially	DHULLMAC XG-M (filler) ank and the welding bea rrow tape (100mm) on tape (200mm-300mm) 0mm strips in advance y from the circumference tape (150mm) around the s	d. the welding into approx. e, and apply of the tank.		
Smoothi	ng			ZTIT
tools such as	the tape, smoothen the rubber gloves, pressing arefully smoothen the ta and lap areas.	roller, rubber		
Topcoat			•	
with a brush or	litohullmac XG-T or XG- r a roller brush. The star at is XG-T:0.3kg/m²,XG-T	ndard amount		
Inspectio	on			
Check visually lift or disbondr	v and by hand touch to ment.	find any flaw,		

H section steel

Straight pipes	Elbows	Tees	Flanges	Valves
Around the base of tanks	Around the base of tanks reinforcing member	Around the base of tanks welding bead	H section steel	Angle section steel / Channel section steel

Cleaning

Remove rust from the surface using wire brush, hammer etc. When preparation of the surface is finished, wipe away dirt, moisture and oil thoroughly with waste cloth.



Application procedure

Angle section steel / Channel section steel

Straight pipes	Elbows	Tees
Around the base of tanks	Around the base of tanks reinforcing member	Around the base welding b

Cleaning

Remove rust from the surface using wire brush, hammer etc. When preparation of the surface is finished, wipe away dirt, moisture and oil thoroughly with waste cloth.

Undercoat

Evenly apply Nitohullmac XG-PN (primer) by gloves. Make sure that the primer is mixed well before use. The standard amount applied per coat is 0.2kg/m²-0.3kg/m².

Application of tape

(1)Embed NITOHULLMAC XG-M (filler) in the corner area.

(2)Apply a wide tape from both sides, making sure that it covers the corner area.

Smoothing

After applying the tape, smoothen thoroughly with tools such as rubber gloves, pressing roller, rubber spatula etc. Carefully smoothen the tape especially on the edges and lap areas.

Topcoat

Evenly apply Nitohullmac XG-T or XG-TLW (topcoat) with a brush or a roller brush. The standard amount applied per coat is XG-T:0.3kg/m², XG-TLW:0.5kg/m².

Inspection

Check visually and by hand touch to find any flaw, lift or disbondment. Especially, carefully check the lower side and back side which are less visible.

Undercoat

Evenly apply Nitohullmac XG-PN (primer) by gloves. Make sure that the primer is mixed well before use. The standard amount applied per coat is 0.2kg/m²-0.3kg/m².

Application of tape

- (1)Embed NITOHULLMAC XG-M (filler) in the corner area.
- (2)Apply a wide tape on the top and bottom surfaces. Make sure that the folded area covers the corner area.
- (3) Apply a wide tape on the side.

Smoothing

After applying the tape, smoothen thoroughly with tools such as rubber gloves, pressing roller, rubber spatula etc. Carefully smoothen the tape especially on the edges and lap areas.

Topcoat

Evenly apply Nitohullmac XG-T or XG-TLW (topcoat) with a brush or a roller brush. The standard amount applied per coat is XG-T:0.3kg/m², XG-TLW:0.5kg/m².

Inspection

Check visually and by hand touch to find any flaw, lift or disbondment. Especially, carefully check the lower side and back side which are less visible.

