



## SPECIFICATION TC ENVIROCOAT COATING SYSTEM

### 1.0 SCOPE

1.1 SCOPE: General instruction and recommended practices for the application of a petrolatum wax coating system for corrosion protection of pipe, piling, steel and concrete surfaces, and irregular segments with a maximum operational temperature of 250°F.

### 2.0 MATERIALS

2.1 TAPECOAT TC ENVIROPRIME - a thick petrolatum wax primer that exhibits preferential wetting capabilities to readily coat surfaces prior to application of TC Enviro Products.

Meets Standards: ANSI/AWWA C-217

2.2 TAPECOAT TC ENVIROTAPE - a 70 mil wax and fiber tape. Consisting of a high tensile **non-woven** synthetic fabric completely saturated with a specially formulated corrosion-inhibiting petrolatum.

Color – Grayish Brown

Thickness – 70 mils

Widths – 2" to 6"

Bacteria Resistance – Excellent

Weight per square (100sf) – 25 lbs

Fabric – Non-Woven

Meets Standards: ANSI/AWWA C217

2.3 TAPECOAT TC ENVIRO-SEAL MASTIC - UV resistant high solids acrylic elastomeric mastic coating. Resistant to solutions of acids, alkaline and salts. Applied over TC ENVIROTAPE for above grade exposure. Colors: Gray or White.

3.0 SURFACE PREPARATION All substances that will impede or otherwise be detrimental to the performance of the coating shall be removed prior to the coating application. This is to include removal of all loose or non-bonded material, rust scale, dirt, mill scale, burrs, sharp edges and weld splatter. Remove excessive moisture when ever practical.

3.1 REFERENCE: STEEL STRUCTURES PAINTING COUNCIL:

SP-1 SOLVENT CLEANING

SP-2 HAND TOOL CLEANING

SP-3 POWER TOOL CLEANING

### 4.0 PRIMER APPLICATION

4.1 TC Enviroprime - Apply TC Enviroprime Primer a minimum of 4 mils thick with gloved hand. Prime the total surface to be coated.

## 5.0 TAPE APPLICATION

- 5.1 Tape shall be applied by hand with a 50% overlap.
  - 5.1.1 Preferred method: Apply tape in a Spiral Wrap for round sections or in layered strips for flat surfaces with a 50% overlap.
  - 5.1.2 Cigarette Wrap tape strips when conditions do not allow for spiral wrapping.
- 5.2 Tape is applied use hand pressure to seal the overlap and smooth out wrinkles, assuring that the tape has contact with the substrate and the tape overlap has melded and sealed.
- 5.3 Tape can be used as a filler to fill crevices, indentations or other areas that might require to be smoothed, feathered out or filled in. Tape can be rolled or layer to smooth out these areas.
- 5.4 Tape wrap shall extend at least 4" over the existing coating.
- 5.5 The tape wrap shall be free of gaps, voids and holidays.
- 5.6 Coating vertical pipe or surfaces: start wrapping at the low end of the surface then wrap or coat in an upward direction.

## 6.0 OUTER COATING FOR TC ENVIROTAPE

- 6.1 Apply two coats of TC Enviro-Seal Mastic over the entire TC Envirotape coated area. Using a brush or roller apply TC Enviro-Seal Mastic in the same direction that TC Envirotape was applied. Minimum thickness of 20 mils wet, 12 mils dry
- 6.2 Seal the edge of the tape by coating 1" of the edge of the tape and also coating 1" of the base surface with TC Wet Bond Epoxy Mastic

## 8.0 INSPECTION OF COATED SEGMENTS:

- 8.1 A visual inspection shall be made to assure the coating is free of all gaps, voids and holidays.
- 8.2 An internal physical inspection can be made at anytime by using a knife to cut open the coating exposing the condition of the substrate. Repair by smoothing out the cut edges and recoating area with original outer coating material.

Read and be familiar with this coating specification and the manufacturer's recommendations. Apply the coating in accordance with the specification. When unfamiliar with the application, manufacturer authorized training or instruction may be required.

An effective coating system will reduce the potential for product loss, environmental contamination, and the related hazards to life, property and damage to the surrounding environment caused by active corrosion.

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## The Material Appendix

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TC ENVIROTAPE - a 70 mil petrolatum and fiber tape for ambient to 250°F (300°F-available) temperature application. Appropriate for coating dry or wet surfaces; particularly suited for coating fittings, flanges, valves, mechanical couplings and other irregular configurations. Recommended overcoating with either TC ENVIRO-SEAL MASTIC or TC EPOXY MASTIC for above grade applications and TC ENVIRO-STRETCHWRAP for below grade.

TAPECOAT TC ENVIROPRIME - a thick petrolatum wax primer applied by hand prior to the application of any of the ENVIROTAPE products.

ENVIRO PROFILING PUTTY- a blend of petrolatum wax, inert fillers and expanded polystyrene beads, used to contour surfaces such as nuts and bolts and fill voids prior to overwrapping with TC ENVIROTAPE. (For ambient temperatures application)

TAPECOAT TC ENVIRO-STRETCH WRAP - a 1-mil below grade plastic outer wrap to be applied over TC ENVIROTAPE prior to backfill.

T/R RUGGED WRAP – a 30 mil UV resistant, mesh weave fiberglass, tape wrap. This moisture activated non- shielding overwrap offers wax coatings systems increased protection from exposure to potentially destructive forces such as mechanical damage, abrasion and soil stress both above and below grade. Maximum operating temperature is 350°F. Available in Silver and other colors upon request.

TAPECOAT V6 OUTERWRAP - a 6 mil heavy duty below grade plastic outer wrap to applied over TC ENVIROTAPE prior to backfill.

TAPECOAT TC ENVIRO-SEAL MASTIC - a UV resistant, acrylic elastomeric, high solids, mastic. Apply over TC ENVIROTAPE to stabilize and enhance the coating when exposed to above grade environments. Colors: Gray or White.

TC FLANGECOAT – a thixotropic corrosion preventative coating for application between the annular space of the flange interface; applied with the use of a caulking gun.

TAPECOAT TC 2025-1 (TERRASHIELD) ROCKSHIELD- a 3/8" closed cell polyethylene foam rock shield with 1/4" perforations 1 1/4" off center, can be purchased non-perforated. Protecting the pipe coating by cushioning the impact of the backfill as it is reintroduced into the ditch and keeping deleterious backfill from direct contact with the pipe coating after the ditch has been closed. Rolls 5' X 140'