

Instructions

Stop It[®] Pipe Repair System



Installation Videos

Important

Read the entire set of instructions before beginning!

Pipe Preparation

Reduced performance to be expected if directions are not explicitly followed!

Step 1: Follow instructions below specific to the type of pipe being prepared.

Steel and Metal Alloys

- 1: Remove any loose scale, existing pipe coating, or paint with 80 grit sandpaper, coarse file, rasp or grinder to produce a bright metal finish.
- 2: Remove dust by blowing with compressed air or rinsing with water.
- 3: Clean and/or degrease the pipe surface with a suitable solvent or water-based degreaser.
- 4: For best results, prepare an area around the entire pipe circumference, with a width equal to that of the intended repair (pg 3).

PVC and ABS

For optimal pressure sealing performance, apply InduMar Adhesion Promoter, AP125 (sold separately)

- 1: Remove the external mold release on the pipe surface with sandpaper. The resulting surface will appear dull (not shiny) with a roughened texture.
- 2: Remove dust by blowing with compressed air or rinsing with water.
- 3: Clean and/or degrease the pipe surface with a water-based degreaser. Do not use common PVC / ABS cleaners, primers or cements.
- 4: For best results, prepare an area around the entire pipe circumference, with a width equal to that of the intended repair (pg 3).
- 5: (If using) immediately apply InduMar Adhesion Promoter, AP125 (sold separately) according to the instructions included with AP125.

HDPE, Polypropylene, and PVDF

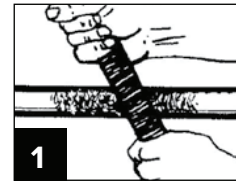
InduMar Adhesion Promoter, AP125 MUST be used to achieve successful leak repair.

- 1: Sand pipe surface with sandpaper to remove the gloss finish.
- 2: Remove dust by blowing with compressed air or rinsing with water.
- 3: Clean and/or degrease the pipe surface with a water-based degreaser.
- 4: Dry pipe surface if wet. For best results, prepare an area around the entire pipe circumference, with a width equal to that of the intended repair (pg 3).
- 5: Immediately apply InduMar Adhesion Promoter, AP125 (sold separately) according to the instructions included with AP125.

Fiberglass Reinforced Pipe (FRP)

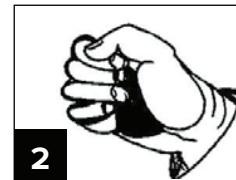
For optimal pressure sealing performance, apply InduMar Adhesion Promoter, AP125 (sold separately)

- 1: Sand pipe surface with sandpaper to remove the gloss finish. To further promote adhesion, score pipe surface with a coarse file.
- 2: Remove dust by blowing with compressed air or rinsing with water.
- 3: For best results, prepare an area around the entire pipe circumference, with a width equal to that of the intended repair (pg 3).
- 4: (If using) immediately apply InduMar Adhesion Promoter, AP125 (sold separately) according to the instructions included with AP125.



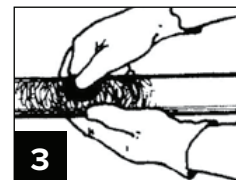
Prepare surface

Prepare la superficie
(véase más arriba)



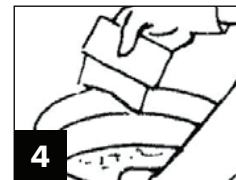
Knead epoxy until
uniform color

Amase el epoxi hasta que
tenga un color uniforme



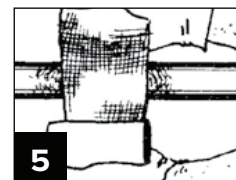
Apply epoxy to
damaged area*

Aplique epoxi al área
dañada*



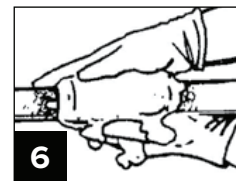
Dip roll for 5 sec. While
squeezing 3 times

Sumerja el rollo durante
5 segundos mientras
estruja 3 veces



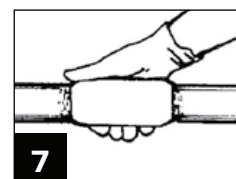
Wrap STOP IT[®] tightly

Envuelva STOP IT[®]
de manera apretada



Rub and polish thoroughly

Frote y pula
minuciosamente



Finished application

Aplicación finalizada

* See instructions (page 2) if pressure or fluid remains in pipe.

Instructions

Stop It[®] Pipe Repair System

Important

Read the pipe preparation instructions (pg 1) first! Fully prepare pipe surface before opening foil pouch. Choose proper repair width, kit size and quantity with product selection guide on page 3 (improper kit size can result in repair failure). For best performance, remove all pressure and fluid from the system.

Installation Instructions

IF ALL PRESSURE AND FLUID REMOVED FROM PIPE THEN -

Step 1: Prepare pipe surface (see pg 1).

Step 2: Fill a container with water.

Step 3: Put on gloves. Remove FIX STIX™ epoxy from plastic bag. Peel off protective wrap. Knead FIX STIX™ until it is a uniform dark grey color.

Step 4: Apply FIX STIX™ to damaged area. Fill in holes, cracks, or offsets.

Step 5: Tear open foil pouch at notch- Remove roll. Immediately immerse roll in water for about 5 seconds – while squeezing firmly 3 times.

****WORK QUICKLY – WORKING TIME is 3 – 5 minutes****

Step 6: Wrap STOP IT[®] roll around the repair as tightly and evenly as possible. Build the wrap UP on top of itself; if the repair width exceeds the tape width, a spiral wrap technique will be required.* Apply entire roll. If additional rolls are required apply over the end of the previous roll while the foam is still expanding. (See tips below for applying multiple rolls).

Step 7: Wet gloves in water and immediately compress the wet expanding resins back into the fiberglass wrap by rapidly and firmly stroking the surface, always in the same direction that you wrapped. KEEP HANDS MOVING QUICKLY. WET GLOVES FREQUENTLY TO AVOID STICKING.

Step 8: Continue polishing action until ALL bubbling has stopped (3 – 5 minutes). Your repair should now have a smooth, hard cap and an ivory-like appearance.

Step 9: Allow at least 30 minutes before pressurizing to let STOP IT[®] cure – for optimal results allow 2 hours.

IF ALL PRESSURE AND/OR FLUID REMAINS IN PIPE THEN -

Step 1: Prepare pipe surface (see pg 1).

Step 2: Fill a container with water.

Step 3: Put on gloves. Remove FIX STIX™ epoxy from plastic bag. Peel off protective wrap. Knead FIX STIX™ until it is a uniform dark grey color.

Step 4: Roll a portion of the FIX STIX™ into a ball and set aside.

Step 5: Tear open foil pouch at the notch. Remove roll. Unroll about 6 inches and firmly press the FIX STIX™ epoxy ball directly into the STOP IT[®] roll 4 inches from the end. Press the FIX STIX™ epoxy ball into the STOP IT[®] roll until the epoxy penetrates through the roll.

Step 6: Immediately immerse roll (with FIX STIX™ on the end) in water for 5 seconds while squeezing firmly 3 times. ****WORK QUICKLY – WORKING TIME IS 3–5 MINUTES****

Step 7: Position the roll over the leak such that FIX STIX™ will be pulled into and fully cover the leak site when you begin wrapping. Wrap quickly around the pipe, pulling the roll as tightly and evenly as possible to cinch it down and compress the FIX STIX™ epoxy into the active leak site to stop or control the leak. Do not allow the FIX STIX™ to rotate off the leak area as you wrap. Build the wrap UP on top of itself; If the repair width exceeds the tape width, a spiral wrap technique will be required.* Apply entire roll. If additional rolls are required apply over the end of the previous roll while the foam is still expanding. (See tips below for applying multiple rolls).

Step 8: Finish by following steps 7 – 10 from instructions to the left.

** For assistance with spiral wrap techniques for applications involving a length of pipe such as corrosion proofing, contact InduMar technical support.*

Tips for Multiple Rolls and Large Diameter Pipe

- Read the pipe preparation instructions (pg 1) first!
- Fully prepare the pipe surface before opening the first foil pouch.
- Determine the number of kits required before beginning. Contact InduMar for assistance if needed.
- If through wall conditions exist, remove all pressure and fluid from the system for best performance.
- Preparedness is the key to a successful installation. Ensure all materials needed are present before you begin.
- When the **Product Selection Guide** dictates multiple rolls, it is important to apply the rolls in succession one immediately after another. Apply the first roll as per direction but DO NOT POLISH. Immediately apply the second and subsequent rolls directly on top of the previous roll.

DO NOT OPEN FOIL POUCHES UNTIL READY TO APPLY EACH INDIVIDUAL ROLL

- When the **Product Selection Guide** indicates a repair width greater than the tape width (2" or 4"), the product should be applied by spiraling the tape to achieve the desired width. Apply multiple rolls as described above.
- For large diameter pipes or longer lengths requiring multiple rolls- up to four installers may be required. Two installers one on each side of the pipe to wrap, one installer for prepping rolls and one installer wetting out the repair.
- Spray large repair areas with a spray bottle while applying STOP IT[®] to keep it wet.
- Resin pouches may be chilled to 50°F before opening to increase working time.



Instructions

Stop It[®] Pipe Repair System

Product Selection Guide

STOP IT[®] is produced in four sizes: 2"x4', 2"x12', 4"x 12' and 4"x 25'

The following recommendations satisfy the minimum required repair width as specified by the ASME Post Construction Committee-2. For other repair requirements, contact InduMar for selection guidelines.

Instructions: Find pipe diameter and line pressure to determine repair width, and number and size of kits to apply.

Nominal Pipe Diameter	Minimum Repair Width*	50 PSI (10 Plies)	150 PSI (15 Plies)	400 PSI (20+ Plies)
1/2"	2"	1 (2x4)	1 (2x4)	1 (2x4)
3/4"	2"	1 (2x4)	1 (2x4)	1 (2x4)
1"	2"	1 (2x4)	1 (2x4)	1 (2x12)
1-1/4"	2"	1 (2x4)	2 (2x4)	1 (2x12)
1-1/2"	2"	2 (2x4)	2 (2x4)	1 (2x12)
2"	2.1"	2 (2x4)	1 (2x12)	1 (2x12)
2-1/2"	2.6"	1 (2x12)	1 (4x12)	2 (4x12)
3"	2.9"	1 (2x12)	1 (4x12)	2 (4x12)
3-1/2"	3.2"	2 (2x12)	2 (4x12)	2 (4x12)
4"	3.5"	2 (2x12)	2 (4x12)	2 (4x12)
5"	4.1"	2 (4x12)	2 (4x12)	3 (4x12)
6"	4.5"	2 (4x12)	3 (4x12)	3 (4x12)
8"	5.8"	2 (4x25)	2 (4x25)	3 (4x25)
10"	6.9"	2 (4x25)	3 (4x25)	4 (4x25)
12"	7.5"	3 (4x25)	4 (4x25)	5 (4x25)
14"	8.1"	4 (4x25)	5 (4x25)	7 (4x25)
16"	8.6"	5 (4x25)	7 (4x25)	9 (4x25)
18"	9.2"	6 (4x25)	8 (4x25)	11 (4x25)
>18" diameter pipe	For all diameters over 18" contact InduMar for detailed application instructions.			

Note: These are suggestions only. This is a hand-applied product and results may vary depending on the expertise of the applicator. Always apply the entire roll. This information is presented in nominal sizes and actual diameters may vary with the type of pipe and thickness of fittings. Fitting repair may require additional product.

*Minimum repair widths represent the output of PCC-2 based calculations. Actual applications should approximate these widths to the nearest 1/2".

For technical support contact InduMar:
www.InduMar.com | 713.977.4100/800.523.7867


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