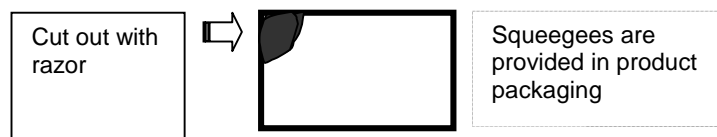


ARCOR® International

a Division of AEC Corp.

PROCEDURE FOR INSTALLATION OF THE ARCTHANE JOINT SYSTEM ON TUBESHEET/CHANNEL HEAD INTERFACE

1. De-water channel head and tubes. Blow down all tubes to remove residual water.
2. Grit-blast interface region i.e. 2 inches of the sheet; the crevice; and two inches onto the channel head. An SSPC-SP-5 white metal, 3-5 mil profile is recommended.
3. If there is an existing coating on the channel head, brush blast 1-1/2 to 3" of the existing coating directly next to the 2" strip that is prepared to bare metal.
4. Thoroughly clean the area by vacuum, brush and vacuum.
5. Install a 20 mil of ARCOR® S-30 Prime. Refer to the product Data/Application sheet. The S-30 Prime should completely cover the prepared region feathering into the brush blasted region of the existing coating. There should be no visible skips or "holidays."
6. Allow the ARCOR® S-30 Prime to set up tack-free. Consult the Data/Application sheet for overcoat window and/or the S-30 Cure Schedule chart.
7. Install a 20 mil coat of ARCOR® S-30. Refer to the product Data/Application sheet. The S-30 should completely cover the S-30Prime and should feather into the existing coating insuring no ridge exists between coated areas and that unprepared surfaces are not coated. There should be no visible skips or "holidays."
8. Allow the ARCOR® S-30 to set up tack-free. Consult the Data/Application sheet for overcoat window and/or the S-30 Cure Schedule chart.
9. Install a bead of ARCOR® ARCTHANE into the crevice filling the joint. Use a caulking gun or similar device to force material into the crevice. Insure that the bead bridges from the tubesheet to the channel completely with no skips or voids. Cutting a plastic applicator corner off in a half-moon shape creates a useful tool to smooth the ARCTHANE in the joint.



10. Allow to fully cure before subjecting to a spark test or immersion service. Consult the ARCTHANE Data/Application sheet or the ARCTHANE Cure Schedule chart.
11. Force cure with addition of heat as needed. Allow the surface (and the ARCOR®) to cool down to 95 degrees F or less before spark testing or immersion after a force cure.

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