



Tank Base Protection System Specification Guide

1.0 Scope

- 1.1 This specification may be used for protecting tank bases and chimneys with Denso products.
- 1.2 The Engineer shall select appropriate sections of the specification to ensure that the specification is comprehensive for specified work.

2.0 General Requirements

- 2.1 Contractor shall comply with all written recommendations of the manufacturer regarding applications of the specified system.
- 2.2 To obtain the specified materials contact Denso North America, 9747 Whithorn Drive, Houston, TX 77095 (Tel) 281-821-3355 (Fax) 281-821-0304 or 90 Ironside Crescent Unit 12, Toronto, Ontario, Canada M1X1M3 (Tel) 416-291-3435 (Fax) 416-291-0898. E-mail: info@densona.com.

3.0 Materials

3.1 Densyl Mastic

- 3.1.1 The Densyl Mastic shall be comprised of saturated petroleum hydrocarbons (petrolatum) inert fillers, reinforcing fibers and thermal extenders.
- 3.1.2 Densyl mastic shall be cold applied self-supporting Mastics for molding around irregular shaped fittings to provide a suitable profile for applying anti-corrosion tapes.
- 3.1.3 The Physical specification values shall meet the values given on the data sheet.

3.2 Denso Hi-Tack Tape

- 3.2.1 Denso Hi-Tack Tape shall be comprised of a non-woven synthetic fabric impregnated and coated with an adhesive compound based on petrolatum, polymers and inert siliceous fillers. Adhesion qualities are higher compared to other Denso Petrolatum Tapes.
- 3.2.2 The physical specification values shall meet the values given on the data sheet.

3.3 Denso FB 30 Tape

- 3.3.1 Denso FB 30 Tape shall be comprised of a butyl adhesive with a polyester fabric backing.
- 3.3.2 The physical specification values shall meet the values given on the data sheet.

3.4 Denso Weathershield 55

- 3.4.1 Denso Weathershield 55 shall be a high build flexible acrylic topcoat. It is a high impact topcoat that provides excellent UV & abrasion resistance and flexibility when applied over the Denso FB 30 Tape.
- 3.4.2 The physical specification values shall meet the values given on the data sheet.

4.0 General Surface Preparation Requirements

- 4.1 Remove dirt, grease and oil including excessive moisture and frost in accordance with the requirements of SSPC-SP-1, "Solvent Cleaning".
- 4.2 Remove weld spatter, sharp points and edges.
- 4.3 Remove loose rust, paint and foreign matter by hand and/or power tools cleaning in accordance with SSPC-SP-2, or SP-3, "Hand Tool Cleaning" or "Power Tool Cleaning" respectively.
- 4.4 High pressure water blasting may be used to prepare the surface.

5.0 Application of Densyl Mastic

- 5.1 Densyl Mastic shall be used to provide a smooth transition between the tank base and the concrete.
- 5.2 Mold the compound into a round configuration and apply around and in between the circumference of the tank edge and concrete base to fill voids and reduce sharp edges. See Figure #1.

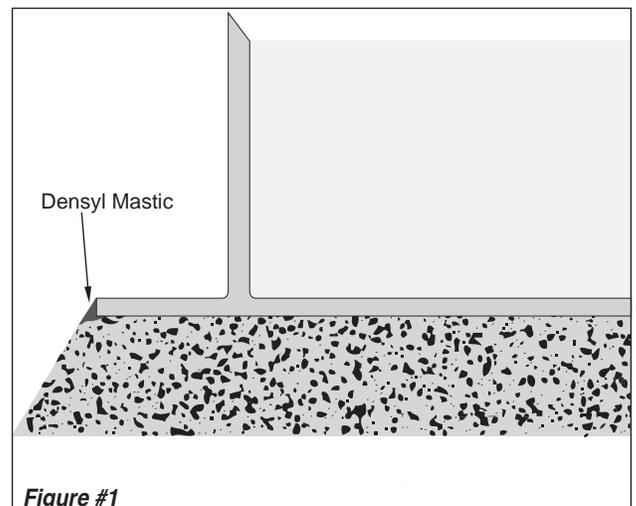
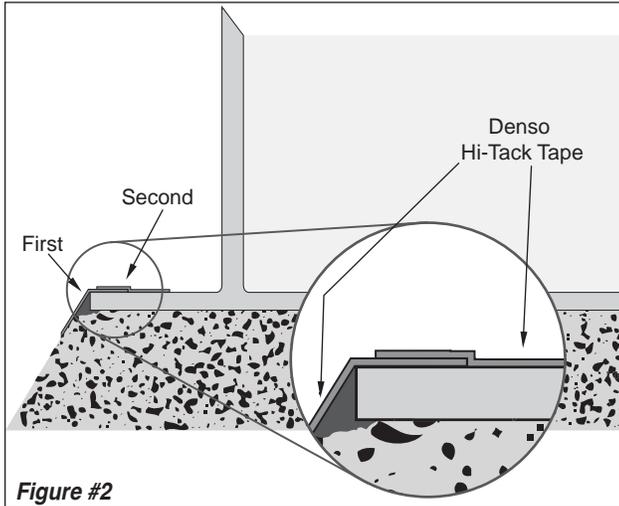


Figure #1

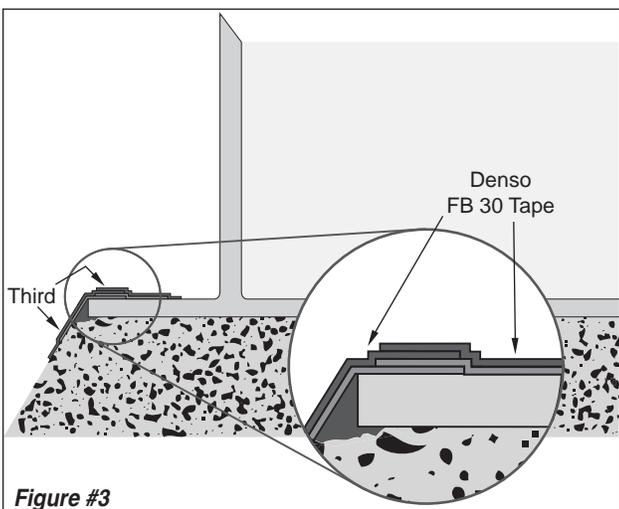
6.0 Application of Denso Hi-Tack Tape

- 6.1 Apply Denso Hi-Tack Tape starting at a minimum 1" onto the concrete base applying circumferentially around the concrete and steel tank base.
- 6.2 If an additional layer is required to cover at least 1" onto the steel tank base, it shall be applied with a minimum 1" overlap onto the first layer of Denso Hi-Tack Tape. See figure #2.



7.0 Application of Denso FB 30 Tape

- 7.1 Peel back interleaving and apply adhesive side of the tape to the surface and press down. Apply Denso FB 30 Tape starting a minimum 1" below the Denso Hi-Tack Tape and proceed circumferentially around the concrete and steel tank base. (Note: Denso FB 30 Tape is easier to apply when product is kept between 60°F and 90°F).
- 7.2 If a second layer of Denso FB 30 Tape is required to cover at least 1" over the Denso Hi-Tack Tape onto the steel tank base, it shall be applied with a minimum 1" overlap onto the first layer of Denso FB 30 Tape. Make sure all seams and overlaps are pressed out and adhered.

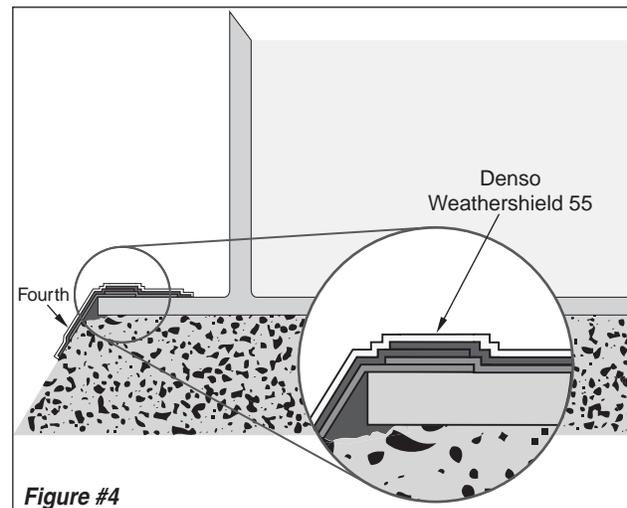


8.0 *Application of Denso Weathershield 55

- 8.1 Mix each of the base and hardener to an even consistency. Pour Part B (Hardener) into Part A (Base) and mix until an even color is achieved while ensuring all sides and the bottom of the container are scraped.
- 8.2 Immediately begin applying mixed material onto the Denso FB 30 Tape by brush or roller while maintaining a wet film thickness of 18 - 20 mils per coat.

* The above procedures are used when applying Tank Base Protection System as part of an exterior paint project.

The Denso Tank Base Protection System meets the API-653 standard for tank chime inspection.



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