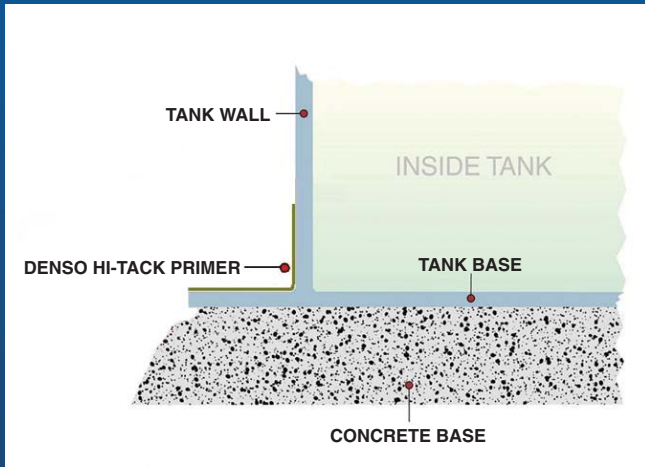




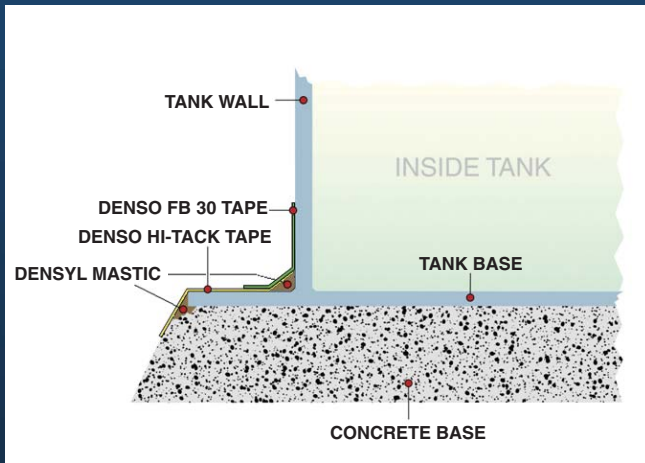
# Tank Base Protection System

## Apply Denso Primer



1. Prime the tank surface with Denso® Hi-Tack Primer.

## Apply Denso Mastic & Tapes

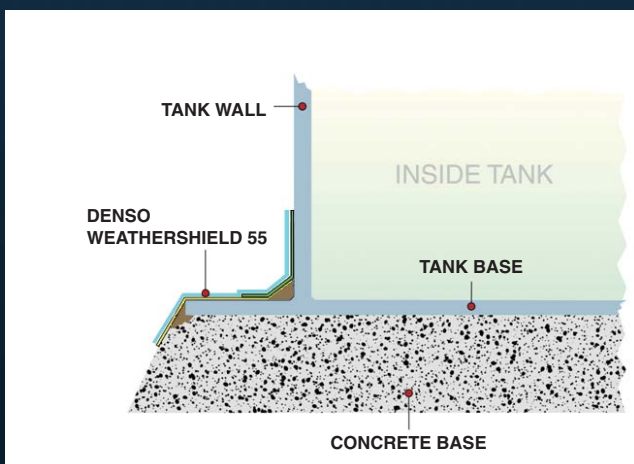


2. Apply Denso® Mastic to fill all voids

4. Apply Denso® FB 30 Tape (Outer Tape)

3. Apply Denso® Hi-Tack Tape (Inner Tape)

## Apply Denso Topcoat



5. Apply Denso® Weathershield 55



# Tank Base Protection System Specification Guide

## 1.0 Scope

- 1.1 This specification may be used for protecting tank bases and chimes with Denso petrolatum 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 or 90 Ironside Crescent Unit 12, Toronto, Ontario, Canada M1X1M3, Tel: 416-291-3435. E-mail: info@denso.com.

## 3.0 Materials

- 3.1 Denso Hi-Tack Primer
  - 3.1.1 The Primer shall be comprised of saturated petroleum hydrocarbons (petrolatum) inert fillers and special blend of adhesive compounds.
  - 3.1.2 The Primer will be an integral component of the Denso Tank Base Protection System for the preparation of metal / concrete surfaces application. Denso Hi-Tack Primer will displace moisture, passivate surface oxides, fill surface imperfections and ensure intimate contact between Denso Petrolatum Tape.
- 3.2 Denso Mastics
  - 3.2.1 The Denso Mastics shall be comprised of saturated petroleum hydrocarbons (petrolatum) inert fillers, reinforcing fibers and thermal extenders.
  - 3.2.2 Denso Mastics shall be cold applied self supporting Mastics for molding around irregular shaped fittings to provide a suitable profile for applying anti-corrosion tapes.
  - 3.2.3 The physical specification values shall meet the values given on the data sheet.
- 3.3 Denso Hi-Tack Tape
  - 3.3.1 Denso Hi-Tack Tape shall be composed of a non-woven synthetic fabric impregnated and coated with a special adhesive compound based on petrolatum polymers and inert siliceous fillers. Adhesion qualities are higher compared other Denso Petrolatum Tapes.
  - 3.3.2 The physical specification values shall meet the values given on the data sheet.
- 3.4 Denso FB 30 Tape

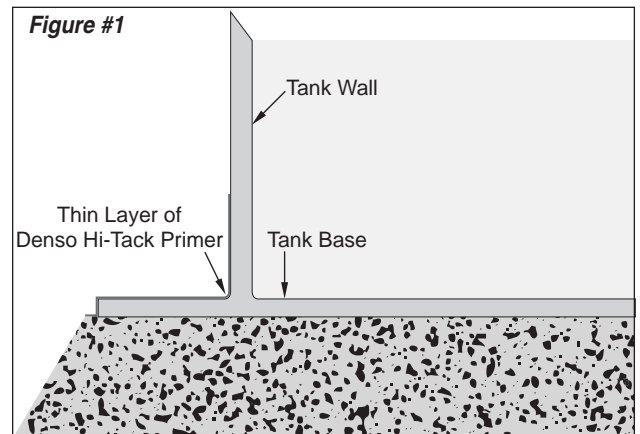
- 3.4.1 Denso FB 30 Tape shall be comprised of butyl adhesive with a polyester fabric backing.
- 3.4.2 The physical specification values shall meet the values given on the data sheet.
- 3.5 Denso Weathershield 55
  - 3.5.1 Denso Weathershield 55 shall be a high build flexible acrylic topcoat.
  - 3.5.2 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 Denso Hi-Tack Primer

- 5.1 Apply Denso Hi-Tack Primer by gloved hand, brush, rag or roller. See Figure #1.



- 5.2 Apply a thin uniform film over the entire surface to be wrapped.
- 5.3 Apply a liberal coating to threads, cavities, shoulders, pits, etc.

## 6.0 Application of Densyl Mastic

- 6.1 Densyl Mastic shall be used to provide a smooth transition between the tank base and tank wall. Mold the compound into a round configuration and apply around the circumference of the tank. The same procedure shall be used for the transition of the tank base and concrete transition. The Densyl Mastic can also be used to fill voids and reduce sharp edges. See Figure #2.

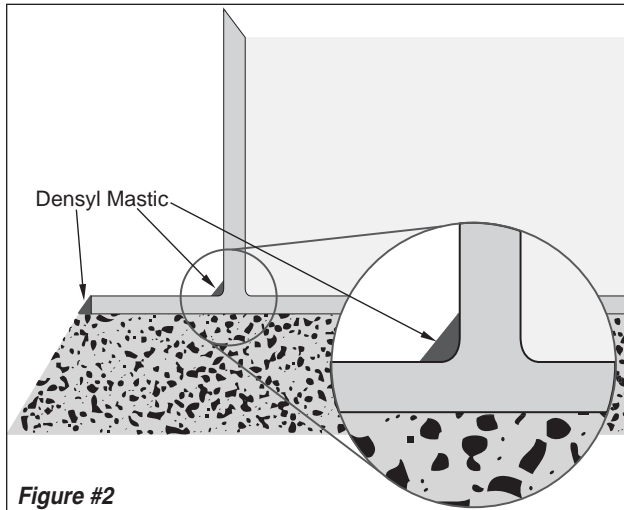


Figure #2

## 7.0 Application of Denso Hi-Tack Tape

- 7.1 Apply first layer of Denso Hi-Tack Tape starting at a minimum of ½" (12.5 mm) onto the concrete base applying circumferentially around the concrete and tank base. The next layer shall be applied with a minimum of a 1" (25 mm) overlap onto the first layer. The second layer shall be applied on the tank base proceeding upwards with a minimum 1" up the tank wall. Smooth out all wrinkles and overlaps. See Figure #3.

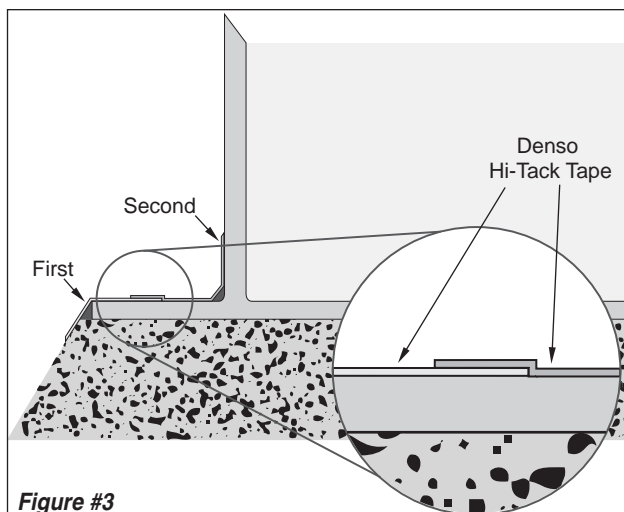


Figure #3

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## 8.0 Application of Denso FB 30 Tape

- 8.1 Apply first layer of Denso FB 30 Tape starting at a minimum of ½" (12.5 mm) below the Denso Hi-Tack Tape. The tape shall be adhered to the concrete base and proceed circumferentially around the concrete and tank base. The next layer shall be applied with a minimum of a 1" (25 mm) overlap onto the first layer of Denso FB 30 Tape. The second layer shall be applied on the tank base proceeding up the tank wall with a minimum ½" (12.5 mm) above the Denso Hi-Tack Tape to adhere to the steel tank wall. A third layer maybe required if the second layer does not adhere directly to the tank wall. See Figure #4.

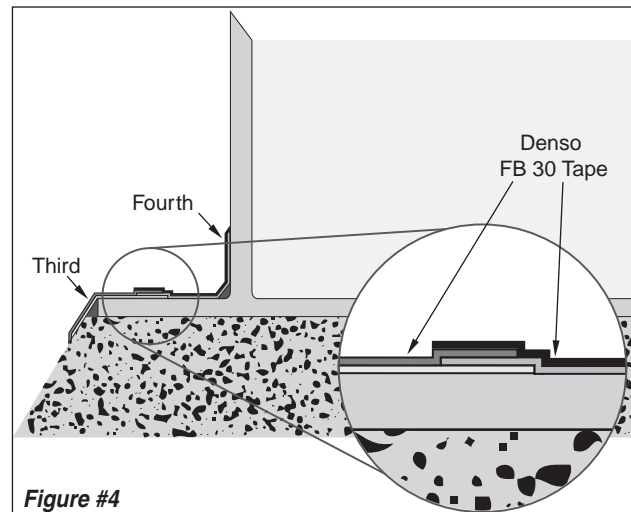


Figure #4

## 9.0 Denso Weathershield 55

- 9.1 Mix thoroughly prior to application. Apply Denso Weathershield 55 directly to the Denso FB 30 Tape as a top coat at approximately 18 to 20 mils per coat. The surface temperature shall be dry, above 40°F (4°C) and at least 5°F (3°C) above the dew point. If a second coat is needed it can be applied in 2 to 3 hours depending on temperature. See Figure #5.

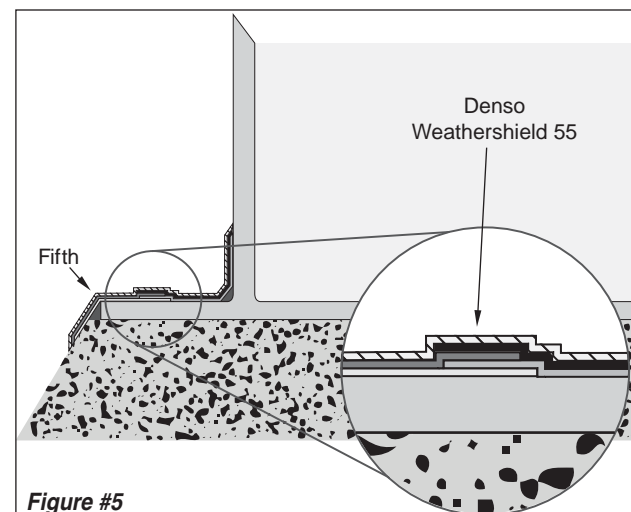


Figure #5

Depending on site conditions other Denso top coats can be used.  
Please call your Denso Representative.