

APPLICATION INSTRUCTIONS

ARCap Corrosion Protection Caps

LDPE Series | HDPE Series

PRIOR TO APPLICATION

Store the product in accordance with the requirements of the relevant Technical Data Sheet prior to use.

Tools & Equipment

- Temperature probe
- Dew point meter
- Rags
- Solvent
- Polyisobutene (PIB) corrosion filler compound — refer to the PIB filler material data sheets for additional tooling requirements and application instructions

Environmental & Substrate Conditions

- The substrate must be free of moisture. Substrate temperature must be maintained at a minimum of 3°C above the dew point throughout the application process until installation is complete.
- ARCap caps must be kept dry and free of dirt, oils, grease, and other contaminants prior to and during installation.

SURFACE PREPARATION

- The application area must be free of dirt, oil, grease, dust, or any other particulate that could affect direct contact between the substrate and the polyisobutene filler material.
- Refer to the PIB filler material data sheets for any additional surface preparation requirements specific to the filler product in use.
- Removal of any oils or grease must be carried out in accordance with the requirements of the PIB filler material data sheets and SSPC-SP1 (Solvent Cleaning).
- Remove all debris from the application area by vacuuming, sweeping, or blowing down with clean, dry compressed air free of airborne oil contaminants.
- Perform a visual inspection to confirm that surface preparation requirements have been met before proceeding.

APPLICATION INSTRUCTIONS

1. Fill the cavity of the ARCap with polyisobutene filler material to the required amount to provide full coverage of the application area. It is recommended to test the required fill amount prior to full production installation. Successful application will have PIB filler material visibly exposed at the lower edge of the cap uniformly with some squeeze-out. Do not overfill caps, as excess material will be displaced by the bolt as the cap is pressed into place. Underfilled caps will not exhibit uniform, adequate squeeze-out from the bottom edges.
2. Push the filled cap onto the fastener assembly. ARCap tolerances are tight by design to provide a friction fit at the edges in addition to the chamfer-lip interface. In many cases the friction fit alone is sufficient to retain the cap in service, as loading on the cap during service life is minimal.

NOTE: Do not twist the cap while pushing it into place. Twisting will cause excess deformation of the lip edge and may result in premature failure if the cap becomes loose.

3. In cold weather conditions or where material rigidity makes hand installation difficult, mechanical assistance may be used. Clamps or similar devices fitted with a soft interface are acceptable. Exercise care to ensure that mechanical devices do not exert excessive force on the cap, which may cause cracking or other physical damage.
4. Verify that adequate squeeze-out of filler material is present uniformly around the entire circumference of the installed cap.

NOTE: ARCap caps are single-use. The lip interface sustains necessary deformation during installation and an installed cap cannot be removed and reinstalled. If a cap must be removed, replace it with a new cap.

Contact Arcon Industrial Supply if you encounter application concerns not addressed within this document or the relevant Technical Data Sheet.

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