

## Installation Instructions

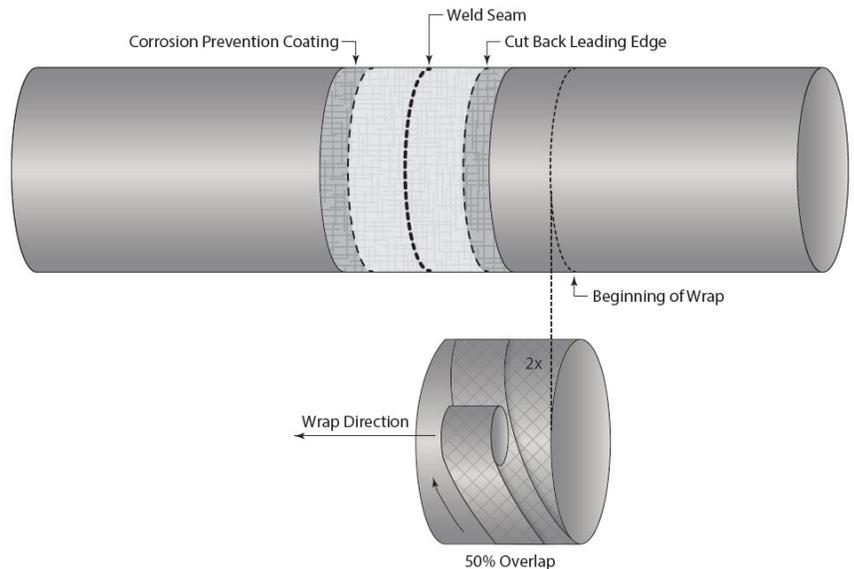
# Stop It® BoreShield ARO™

## Surface Preparation Instructions

When overwrapping girth welds, the adjacent factory-applied coating should be cleaned with denatured alcohol or acetone to remove any dust, grease and moisture. Surface prepped area should extend a minimum of 4" beyond both the leading and non-leading edges of the corrosion prevention coating.

## Installation Instructions

1. Fill a 3-5-gallon container with water.
2. Put on latex gloves.
3. Tear open foil pouch at notch and remove roll. Immediately immerse roll in water for approximately 10 to 15 seconds – while squeezing firmly 3 times.
4. Initiate installation of Stop It® BoreShield ARO™ on the leading edge of the cut back. A minimum of 4" in front of the corrosion prevention coating is required.
5. Wrap Stop It® BoreShield ARO™ as tightly and evenly as possible. The initial wrap should be a straight circumferential wrap, wrapping two times on top of itself; then spiraling the wrap with a 50% overlap towards the non-leading edge of the cut back.
6. Extend wrapping at least 4" past the non-leading side of the corrosion prevention coating before working back towards the leading edge with a 50% overlap. **(WORK QUICKLY – WORKING TIME IS 3-5 MINUTES)**
7. Continue adding additional rolls (beginning where previous roll ended) wrapping back and forth with a 50% overlap until all required rolls have been applied. **(See Stop It® BoreShield ARO™ Fiberglass Wrap Roll Requirement Chart on reverse side)**. Plan the application of the wrap in the vicinity of the edges in order to provide a tapered coating, avoiding excess thickness and a step edge.
8. Immediately after all required rolls have been applied, wet the gloves in water and compress the wet expanding resins back into the fiberglass material. This can be completed by rapidly and firmly stroking the surface. **Keep hands moving quickly and wet gloves frequently to avoid sticking.**
9. Continue this polishing action until the resins harden to the touch and **ALL** bubbling has stopped. (4-5 min). The composite wrap should now have a smooth, hard cap.
10. Wait 30 minutes for Stop It® BoreShield ARO™ to fully cure.



For technical support contact InduMar: 713.977.4100/  
800.523.7867 or visit [www.Indumar.com](http://www.Indumar.com).

  
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<b>Stop It® BoreShield ARO™ Fiberglass Wrap - Required Rolls Per Joint</b>			
<b>Pipe Outside Diameter</b>	<b>Size of Stop It® BoreShield ARO™ Wrap</b>	<b>Total Length of Coverage</b>	<b>Number of Rolls Required</b>
<b>4.625"</b>	<b>4" x 12'</b>	<b>16"</b>	<b>3</b>
		<b>18"</b>	<b>3</b>
		<b>20"</b>	<b>3</b>
		<b>22"</b>	<b>4</b>
		<b>24"</b>	<b>4</b>
<b>6.625"</b>	<b>4" x 25'</b>	<b>16"</b>	<b>2</b>
		<b>18"</b>	<b>2</b>
		<b>20"</b>	<b>3</b>
		<b>22"</b>	<b>3</b>
		<b>24"</b>	<b>3</b>
<b>8.625"</b>	<b>4" x 25'</b>	<b>16"</b>	<b>3</b>
		<b>18"</b>	<b>3</b>
		<b>20"</b>	<b>3</b>
		<b>22"</b>	<b>4</b>
		<b>24"</b>	<b>4</b>
<b>10.75"</b>	<b>4" x 25'</b>	<b>16"</b>	<b>3</b>
		<b>18"</b>	<b>4</b>
		<b>20"</b>	<b>4</b>
		<b>22"</b>	<b>4</b>
		<b>24"</b>	<b>5</b>
<b>12.75"</b>	<b>4" x 25'</b>	<b>16"</b>	<b>4</b>
		<b>18"</b>	<b>4</b>
		<b>20"</b>	<b>5</b>
		<b>22"</b>	<b>5</b>
		<b>24"</b>	<b>6</b>
<b>16.00"</b>	<b>4" x 25'</b>	<b>16"</b>	<b>4</b>
		<b>18"</b>	<b>5</b>
		<b>20"</b>	<b>5</b>
		<b>22"</b>	<b>6</b>
		<b>24"</b>	<b>6</b>

Each layer passes over the underlying layer at 50% overlap for a minimum of 6 ply's