



McWANE
DUCTILE

IRON STRONG

HOW TO PATCH PROTECTO 401™ TIP SHEET

Protecto 401™ Touch-Up Kit is a product of



PROTECTO 401™ has often been the specified lining for ductile iron pipe sewer applications for more than 50 years. There may be occasions in the field when patching of the Protecto 401 lining may be necessary.



1. GATHER MATERIALS

- Paint Stick
- Sand paper
- Stir Stick
- Touch-Up Part A (Small Can)
- Touch-Up Part B (Larger Can)
- Kit Instructions
- Scraper or Grinder
- Wire Brush
- Gloves
- Clean Rag



2. REMOVE BURRS

To avoid cutting yourself, smooth edges before starting the process. Remove all burrs and damaged lining caused by field cutting or by bad handling. You can do this with a scraper and a wire brush. Remove all asphalt, grease, dirt, dust, etc.



3. SAND EDGES

After removing the burrs, be sure to file the exposed area down to bare, clean metal. This ensures epoxy adheres and creates a smooth transition from factory applied material to new material. Roughen up the metal with sand paper, similar to roughening up a piece of wood prior to painting it.



4. MIX PART A & B

Protecto 401 Touch-Up is a 2-part epoxy. Mix the contents of small container (A) and contents of large container (B) into 1 gallon can provided. Thoroughly mix the contents together and use within 1 hour. If using less than full contents, see mix ratios printed on can.



5. APPLY MATERIAL

After mixing, apply materials to clean, dry, prepared surface using a brush. Be sure temperature is above 40°F. Dab brush to fill in rough spots then smooth out. Overlap new material over factory-applied material by 1 inch for a smooth transition and to ensure proper sealing.



6. ALLOW TO DRY

Allow at least one hour before handling as material will be tacky. For more detailed instructions and to view a helpful video, check out our blog at McWaneDuctile.com/Blog. Good practices are also included in the Touch-Up Kit technical data sheet.

