

# TRENTON®

**Corporate Office:**  
The Trenton Corporation  
7700 Jackson Rd.  
Ann Arbor, MI 48103  
734/424-3600  
Fax: 734/426-5882

**Houston Div./Export Office:**  
1880 S. Dairy Ashford Rd.  
Suite 697  
Houston, TX 77077  
281/556-1000  
Fax: 281/556-1122

## Innercoat® Flange Fill™



*Flange filling is the process of pouring hot Innercoat between the flange faces to prevent corrosion.*

### **Application Procedures for Filling Flanges:**

*Supplies: Thermometer, duct tape, pail, heat source, funnel or 2" PVC pipe cup.*

### **For Vertical Flange Gaps:**

- 1) Heat Innercoat in pail to 200°F. using thermometer to monitor temperature. Once temperature is achieved, reduce heat and maintain temperature.
- 2) Wrap the flange gap with duct tape (two wraps). Make a hole in the top for inserting the funnel.
- 3) Pour Innercoat through the funnel slowly and continuously until the Innercoat has fully filled the flange gap. The level of Innercoat will decrease as it fills the voids in the flange. Continue to top-off the flange gap until the level of Innercoat no longer decreases.
- 4) After the flange gap has been completely filled, allow 20 to 30 minutes cooling time and remove the duct tape.

- 5) If an overwrap is desired after removal of the duct tape, use Trenton #1 Wax-Tape (for below ground) or #2 Wax-Tape (for above ground) to protect the outside flange bolts and to interface with the Innercoat wax at the flange gap seam.

### **For Horizontal Flange Gaps:**

- 1) Heat Innercoat following step 1 above, for filling a vertical flange gap.
- 2) Wrap the flange gap with duct tape (two wraps). Make a slot on the side for the 2" PVC pipe approximately 3" long which is cut in half along the longitudinal axis). Tape the 2" PVC pipe cup onto the flange, covering its bottom and sides but leaving the top open so Innercoat will flow into the flange, covering its bottom and sides but leaving the top open so Innercoat will flow into the flange.
- 3) With a small knife, cut four very small slits at the bottom of the top flange. Space the slits relatively evenly around the perimeter of the flange. This will allow any trapped air to escape.
- 4) Slowly pour Innercoat through the cup until the level of the Innercoat is above the flange gap. Continue to top-off the cup until the level of Innercoat no longer decreases.
- 5) Let the Innercoat cool as with step 4 for vertical flange gaps. Remove the duct tape after Innercoat has cooled.
- 6) If desired, a Wax-Tape may be wrapped around the flange. (See step 5 for vertical flange gaps).

## Innercoat

### **Packaging:**

- 47 lb. block ( 1 per case)
- 7-½ lb. blocks (10 per case)
- 7-½ lb. blocks (quartered) (10 per case)

### **Specifications:**

- Color ..... Brown
- Specific gravity at 77°F.88 - .94
- Flash point, min..... 500°F
- Melting point..... 160°F - 175°F
- Dielectric strength..... 100 volts/mil

## Flange Fill Estimated Quantity Requirements\*

Pipe Size	Pounds	Pipe Size	Pounds
4".....	.3	18".....	1.2
6".....	.4	20".....	1.3
8".....	.5	22".....	1.4
10".....	.7	24".....	1.5
12".....	.8	26".....	1.7
14".....	.9	28".....	1.8
16".....	1.1	30".....	1.9

\* Estimated quantity usage is based on 3/8" wall pipe, 2-½" flange face and 1/4" flange gap.