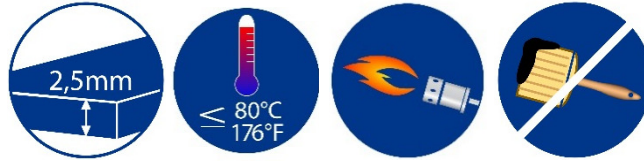


Premier™ 80 ST Heat Shrink Sleeve

with indicator and separate closure patch

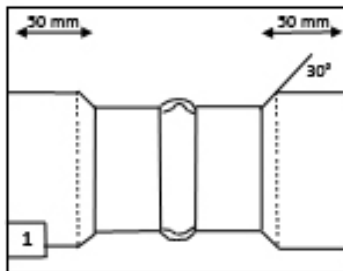


Application

The Premier™ 80 ST Heat Shrink Sleeve with indicator and separate closure patch is a warm applied shrinkable wrap-around sleeve. It is used for the protection of welded seams on buried or above ground pipelines and can be applied on site. After surface preparation of the area to be wrapped to ISO 8501-1 St2-St3, the use of a primer is not necessary.

Required Materials and Equipment

- Premier™ 80 ST Heat Shrink Sleeve
- Closure patch
- Wire brush
- Propane torch
- Working gloves
- Brush
- Rasp with semi-circular blade
- Roller



Ensure the heat shrink sleeve is wide enough to overlap the factory coating 50 mm minimum. Bevel the edges with a rasp with semi-circular blade to an angle of 30°.



Preheat the pipe to remove moisture, if necessary. Clean the pipe surface thoroughly (St 2 – St 3) with a hand wire brush. Remove rust, dirt and other residues.



Abrade the adjacent factory coating (including the beveled edges) by 100 mm on both sides of the joint.



The surface of the steel and adjacent coating shall be free of grease, oil and dust. If solvent cleaning is required this shall be carried out according to SSPC SP 1 using approved solvent.



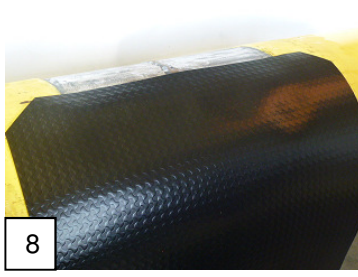
Dry the pipe and warm the area where the sleeve will overlap itself (exposed pipe plus adjacent factory coating) up to 90°C.



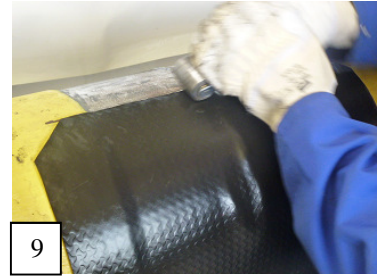
Measure the preheating temperature with an appropriate temperature sensor.



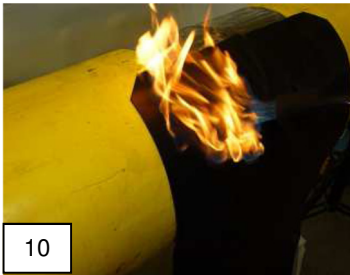
7
Remove approx. 300 mm of the release film from the whole width of the mitred end of the sleeve. Warm up the butyl rubber using the propane torch.



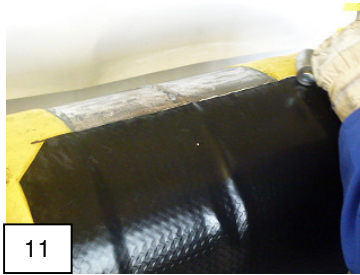
8
Place the sleeve on the preheated area of the pipe.



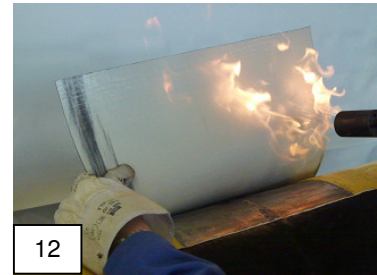
9
Roll on the underlap with a roller.



10
Heat up the applied end of the sleeve with blue-yellow flame, so that a 20 cm portion of the sleeve sticks to the pipe.



11
Roll on the edges of the end of the sleeve with a roller until butyl rubber flows out of the sides.



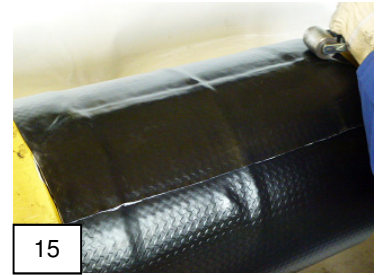
12
Wrap the sleeve around the pipe. Adjust the sleeve and warm up the rubber with the blue-yellow flame.



13
Stick the sleeve all the way around the pipe overlapping onto the underlap. Warm up the overlapping area.



14
Roll on the overlapping area.



15
Butyl rubber should flow out the side.



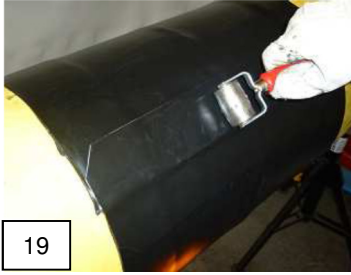
16
Warm one end of the adhesive side of the closure patch with a gas flame. Position the warmed side of the patch over the exposed edge of the sleeve.



17
Continue warming up the adhesive side and position it over the whole sleeve width in the overlapping area.



18
Continue warming up the adhesive side of the closure patch and position it over the whole sleeve width in the overlapping area.



Roller the closure patch in the overlapping area. Let the installed closure patch cool down before continuing with the application.



Beginning below, heat up the middle of the sleeve, moving the torch in a circumferential direction with blue-yellow flame. Use the same motion to shrink one side, then the other side. Ensure even shrinkage.



When sufficient temperature is reached, the texture of the sleeve will become smooth. The shrinking procedure is finished when the sleeve is tightly fitting everywhere and appears smooth.



Roller the transition to the factory coating, the edge of the sleeve, the overlap of the sleeve and the area of the welded seam.

Health and Safety

These application instructions do not constitute a risk assessment. We recommend that installation is carried out with due regard to health and safety and in accordance with relevant local statutes and regulations. Safety Data Sheets are available on request.



DENSO (AUSTRALIA) PTY LTD

77 - 95 National Boulevard

Campbellfield, VIC 3061

Tel: +61 3 9356 7600

Fax: +61 3 9356 7699

www.densoaustralia.com.au

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