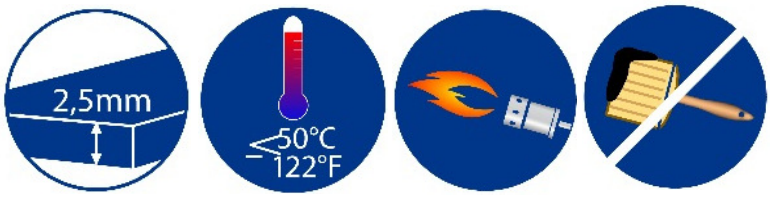
Premier 50 ST Heat Shrink Sleeve™

with indicator and separate closure patch

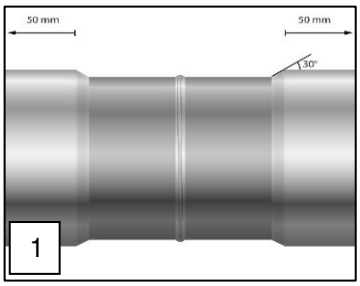


Application

The Premier 50 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 SA 2 ½. The use of a primer is not necessary.

Required Materials and Equipment

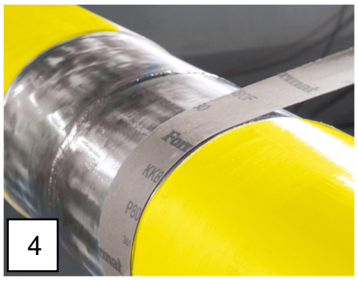
- Premier 50 ST Heat Shrink Sleeve
- Closure Patch
- Wire brush
- Propane torch
- Working gloves
- Brush
- Rash with semi-circular blade
- Roller



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°.

Pipe surface must be free from grease, oil, solvent, coupling agents and similar. Clean the pipe surface with hand wire brush or by abrasive blasting to remove rust, dirt, and other residues.

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



Roughen the pipe surface to a roughness of 50-100 µm by sandblasting acc. to standard purity degree Sa 2 ½ or with emery cloth (K60). Hard adhesive and the epoxy resin layer on factory delivered steel pipes must not be removed.

Brush the surface of the steel and adjacent coating to ensure it is free of dust.

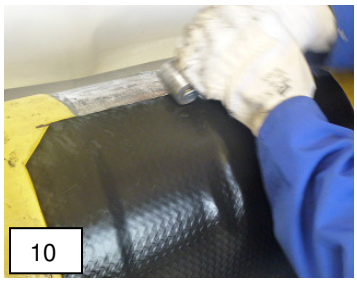
Preheat the the pipe up to 50°C.

Issue date: 14/04/22

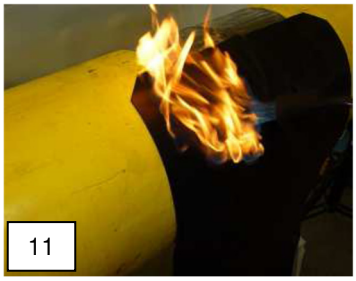
Measure the preheating temperature with an appropriate temperature sensor.

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

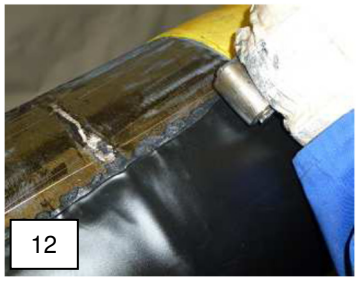
Place the sleeve on the preheated area of the pipe. Overlap minimum 50 mm on factory coating (see pict. 1).



Roll on the underlap with a roller.



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



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

Remove the release film completely from the remainder of the sleeve.

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

Stick the sleeve all the way around the pipe with overlap.

Roll on the overlapping area once again.

A bead of extruded butyl rubber is visible at the edge of the sleeve.

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.

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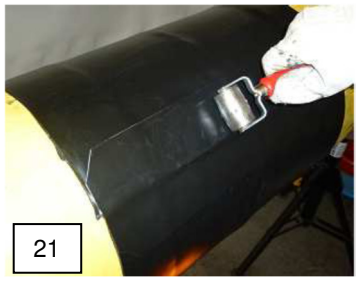
Progressively warm along the length of the closure patch and press on it with roller in order to avoid air pockets.

Continue warming up the adhesive side of the closure patch. Press until butyl adhesive is visible out of the side.



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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