INSTRUCTION OF APPLICATION OF SPLIT HEAT SHRINKABLE SLEEVES WITH INCREASED SHRINKABILITY 45% ANTICORRay MSS50H, ANTICORRay HSS C50

1. SCOPE OF THE INSTRUCTION

This instruction outlines the sequential steps that should be followed to ensure that the anti-corrosion material used for insulation fulfills its function, i.e., provides a seal and proper protection against corrosion.

2. STORAGE & SAFETY GUIDELINES

To maintain quality, heat-shrink materials should be stored in dry, well-ventilated areas. Products must be kept in closed, original packaging away from sunlight, rain, snow, dust, and other harmful factors.
Recommended storage temperature: up to 25^{0}C.
The sleeve should be applied in accordance with occupational health and safety regulations.

3. TOOLS & EQUIPMENT

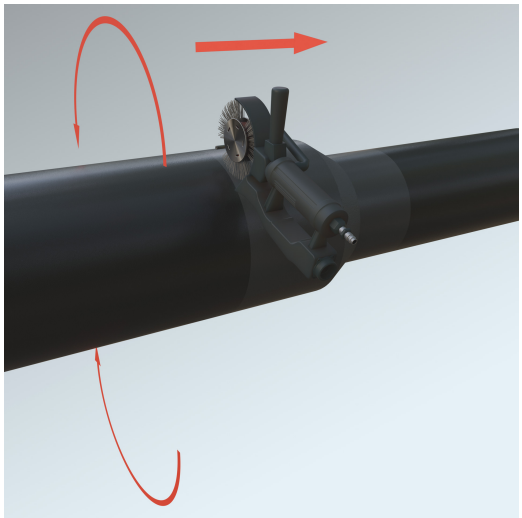
- Propane-butane gas cylinder,
- Torch with hose and reducing-regulating valve,
- Installation knife,
- Protective gloves,
- solvent (acetone, extraction gasoline),
- Cleaning cloth,
- Wire brush,
- Rasp for chamfering insulation edges,
- Suitable material for surface abrasive treatment.

4. TECHNOLOGY

SURFACE PREPARATION

a) Prepare the steel surface to a cleanliness grade of Sa 2 ½ (PN-ISO 8521).
b) Roughen the adjacent surface of the factory insulation to a width that will allow a part of the roughened surface to remain visible after the shrink sleeve is applied.
c) If the edges of the existing factory insulation are not chamfered at an angle of approx. 30^0, they should be prepared using a rasp.
d) After preparing the steel surface and the factory coating, remove any remaining residue.
e) The prepared surface should be also cleaned with solvent (acetone or petroleum spirit) to degrease the surface.

Proper surface preparation is critical for the quality of the insulation.



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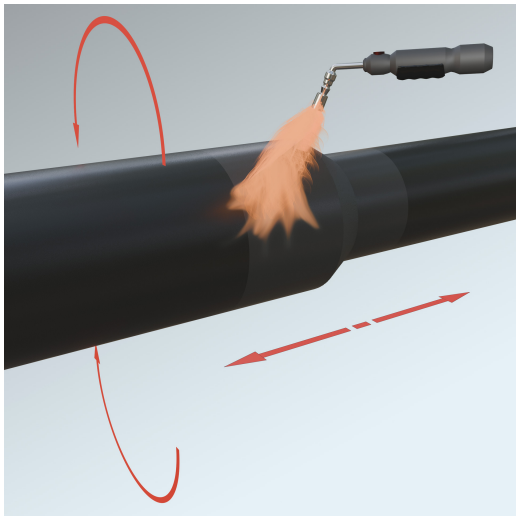
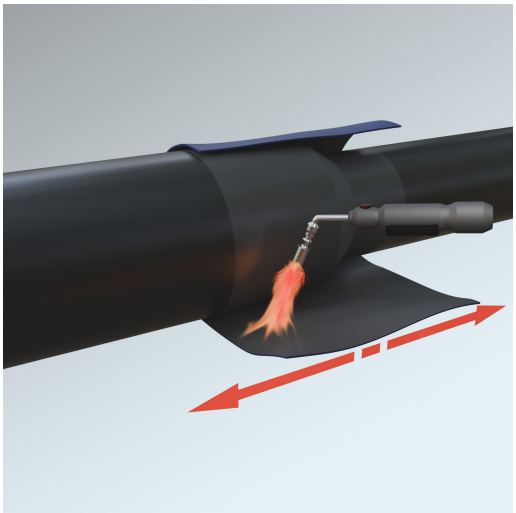
SURFACE HEATING



a) Heat the steel surface and adjacent insulation to a temperature of 60^0C.
b) Check the temperature across the entire surface of the insulated element and adjacent sections of the existing insulation, 50 mm from its edges.
c) In lower temperatures, the steel surface and factory insulation should be heated to a higher temperature to avoid cooling down before the sleeve application.

HEAT SHRINK SLEEVE APPLICATION ON CASING PIPE



a) Place the sleeve centrally on the protective pipe, at least 150 mm from the edge of the protective pipe circumferentially, and overlap the sleeve by 100 - 150 mm.
b) Heat the overlapping surfaces with a soft flame from the torch and press them together (pre-bond).
c) Place the edge part of sleeve centrally to the edges of the overlap, previously heating its adhesive with a gentle, soft flame from the torch.
d) Stick the overlap using a soft flame and pat it down with a gloved hand.
e) Begin shrinking the sleeve using a soft flame, starting from the protective pipe, moving towards the carrier pipe with an even circumferential movement.
f) Dimpled backing provides a “permanent change” indicator for application of heat.

HEAT SHRINK SLEEVE APPLICATION ON JOINTS (WITH RECOMMENDED PRIMER ANTICORRay 720)

a) For better protection on FJC it is recommended to apply on heated surface Primer ANTICORRay 720. After application of Primer wait until dust dry and then start application of the sleeve.
b) Place the sleeve centrally on the weld, tight on the circumference and overlap the sleeve by 100 - 150 mm, leaving no lose space on the bottom side.
c) Heat the overlapping surfaces with a soft flame from the torch and press them together (pre-bond).
d) Place the edge part of sleeve centrally to the edges of the overlap, previously heating its adhesive with a gentle, soft flame from the torch.
e) Apply the ANTICORRay MSS Closure Patch (150 mm x 600 mm) using a soft flame and pat it down with a gloved hand.
f) Begin shrinking the sleeve using a soft flame, starting from the middle of the sleeve, moving towards the edges with an even circumferential movement.
g) Dimpled backing provides a “permanent change” indicator for application of heat.

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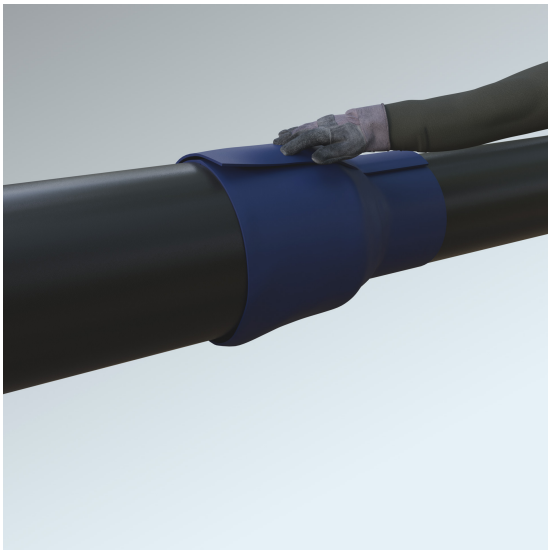
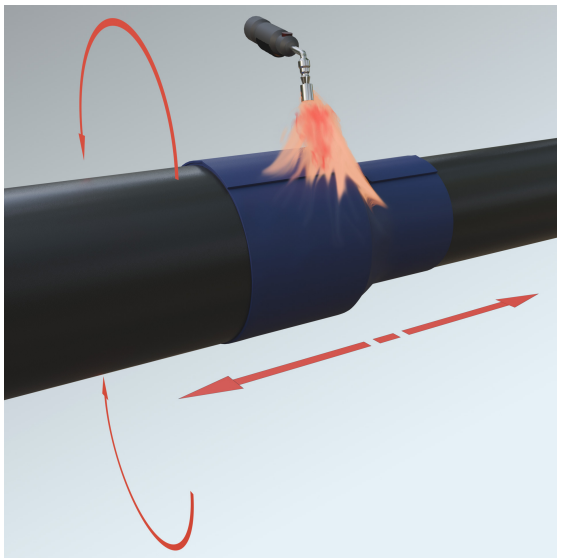


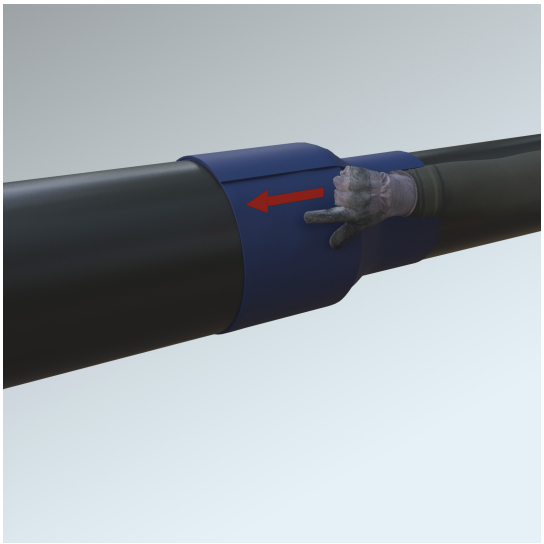


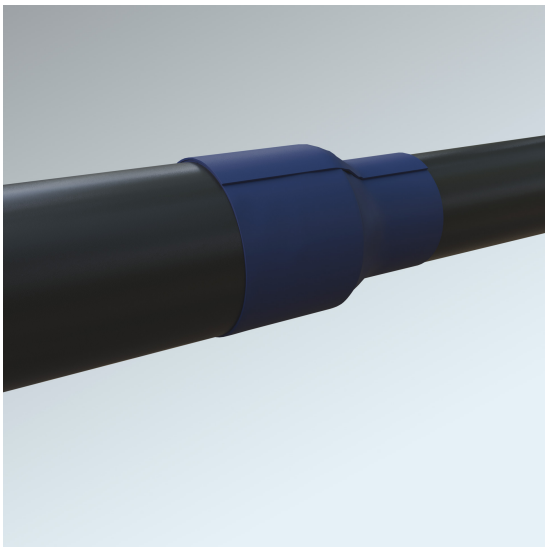
5. INSPECTION

Visually check the installed heat shrink sleeve to ensure that:

a) it adheres tightly to the pipe surface,
b) there is no mechanical damage.

After 2 hours, the tightness of the coating can be checked with a holiday detector.
Test voltage 15 kV (EN 12068).





Note: to protect the sleeve from damage, it is recommended to use suitable backfill material free from sharp elements, such as sharp stones, construction rubble, etc.

We recommend using ANTICOR CC (Casing Closure) technology for sealing and closing the ends of protective pipes.

For any questions, please contact us.

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