egeFit® Shrinking Sleeves

Assembly Instructions for Mechanical Protection of Joints

Application Area:

To be used for post-factory insulation of egeplast protective layer pipes such as SLM® DCT, egeSmart: Integrity DCS, Barrier Pipes SLA® or egeSmart: Leak Control 3L safety pipe systems.

Note:

The explanations below exlusively outline the processing of the shrinking sleeves. Please also pay attention to any potentially required further steps which serve to ensure the operability of the relevant pipe systems and are outlined in the product-specific Processing Guidelines.

Condition upon delivery



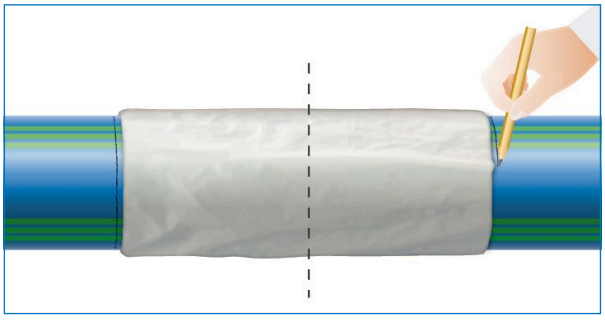
Upon delivery, the shrinking sleeves come wrapped in protective foil protecting them from moisture and contaminations.

1. Sliding on the shrinking sleeve



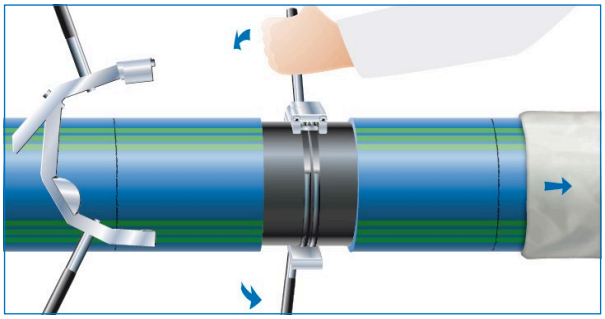
Prior to establishing the pipe connection, slide the still wrapped sleeve over the pipeline which is to be welded.

2. Positioning of the shrinking sleeve



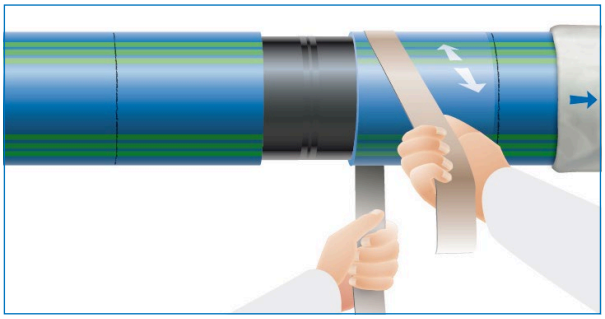
After welding, position the shrinking sleeve centrally above the weld seam and mark the shrinking area on both sides. Afterwards, slide the sleeve back to remove it from the shrinking area.

3. Removal of the outside bead



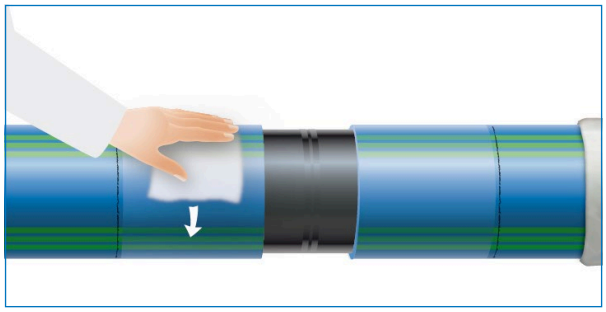
Removal of the outside bead with a suitable outer debeader.

4. Roughening the protective layer



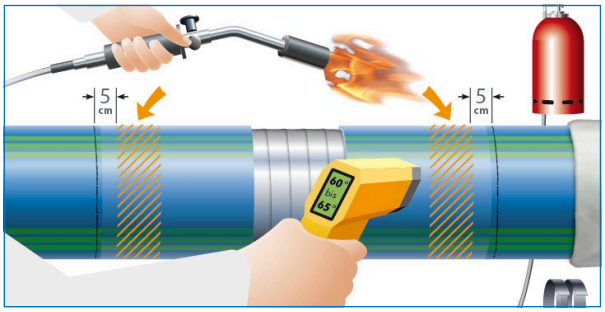
The protective layer must be roughened in the adhesion area around the location of the shrinking sleeve to be positioned later by means of emery cloth (P40) in order to ensure better adhesion.

5. Drying and cleaning of the shrinking area



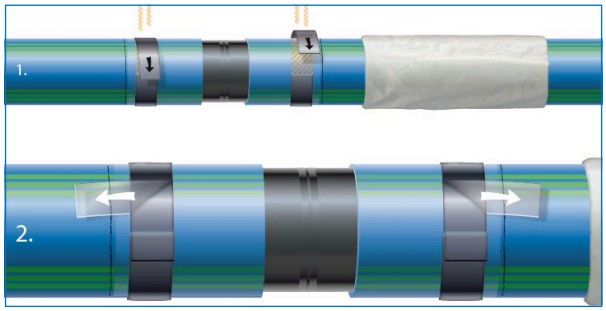
Dry and clean the shrinkage area with a lint-free cloth.

6. Heating of the pipe surface



Heat the pipe surfaces on both sides of the joint (surface temperature 60-65°C), 5 cm away from the markings made in step 2. Apply the enclosed hot-melt adhesive right afterwards.

7. Application of the hot-melt adhesive



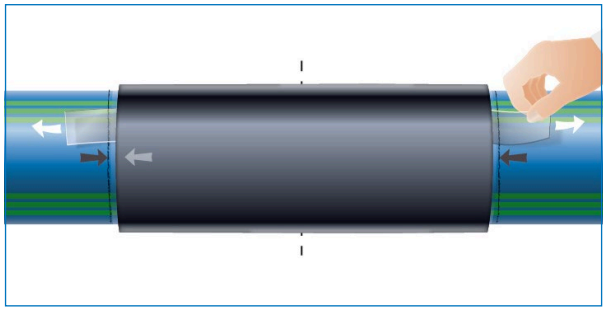
1. To do so, apply a prefabricated strip of hot-melt adhesive. Do not shorten, let the ends overlap.
2. Remove the protective film from the adhesive and bend it outwards.

8. Removal of the protective foil



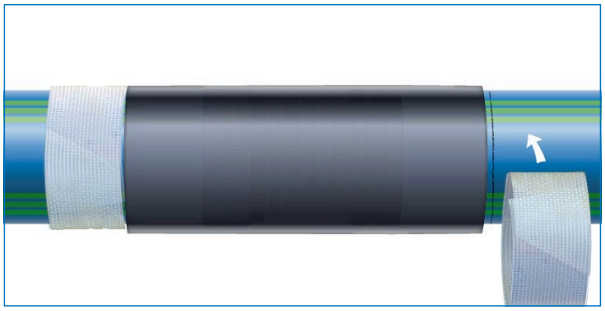
Remove the protective foil from the sleeve before further processing and extract it from the sleeve by pulling it into a single direction.

9. Alignment of the shrinking sleeve



Align and position the shrinking sleeve centrally above the weld seam and the previously applied hot melt. The protective film of the hot melt adhesive can now be removed and pulled outwards.

10. Protection of the outer layer



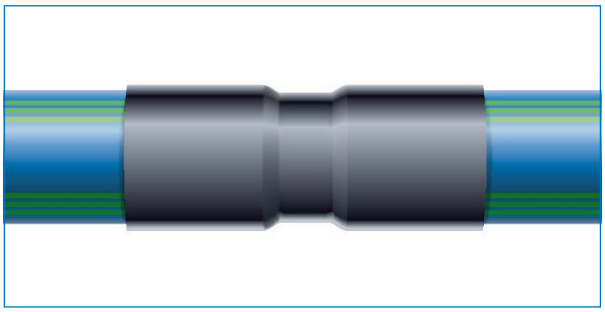
Prior to the shrinking process, the protective layer is to be protected by means of suitable heat protection mats at the edges of the shrinking sleeve.

11. Shrinking process



Shrink the shrinking sleeve on by means of a soft, yellow gas flame. Temperature of the sleeve must be at least 140°C. Processing always from the middle working outwards, constantly keeping the propane torch rotating around the pipe. Ensure a sufficiently large working space beforehand. For dimensions above OD 355 mm, we recommend using 2 torches or additional staff respectively to enable you to work from both sides.

12. Joint upon completion



The assembly is complete once the shrinking sleeve fits smoothly. Make sure that the shink-on sleeve does not wrinkle and that the ends sit smoothly on the pipe wall.
Note: Following the shrinking process, let the joint cool down to ambient temperature to enable the material to obtain adequate strength.

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