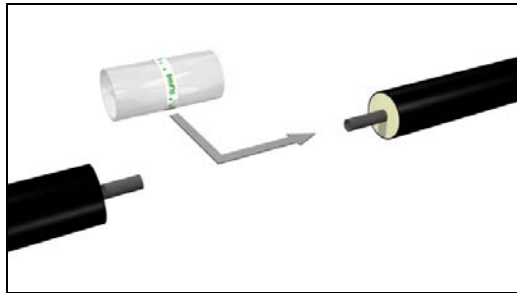
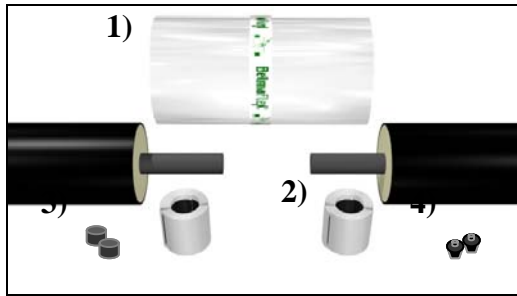
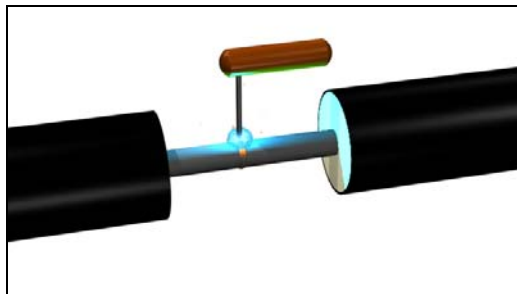


Shrink sleeve with mastic

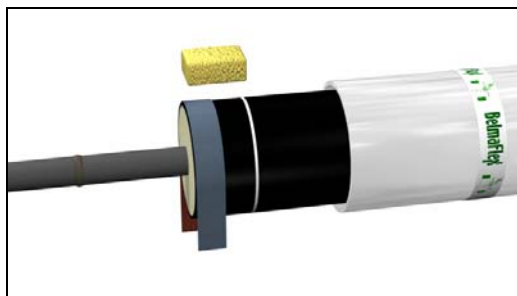
1 – 3



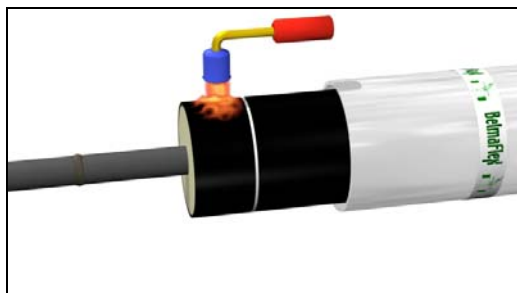
Place the shrink sleeve on one of the pipes.



Weld the steel pipes. Tightnesstest.



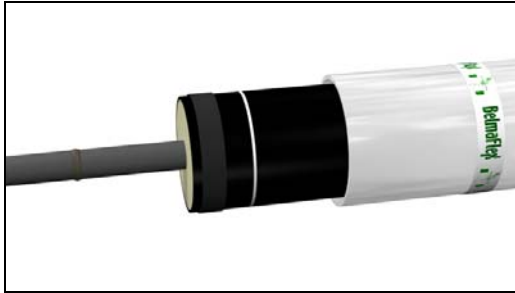
Cut away expanded insulation foam from around the pipe ends. Clean the jacket pipes at least 150 mm from both pipe ends (alcohol). The surfaces must be **CLEAN** and **DRY**.



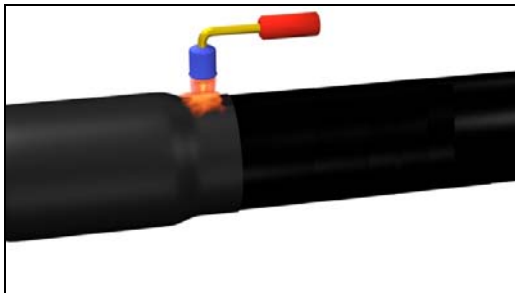
Activate the jacket pipes at least 150 mm from both sides of the pipe ends until the surface has a matt, silky look.

Shrink sleeve with mastic

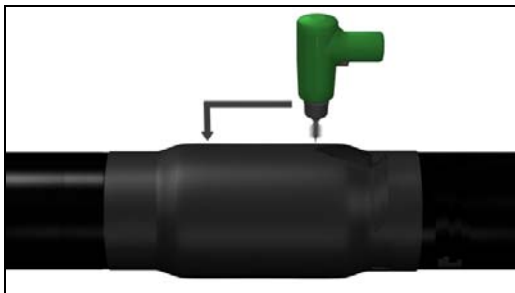
2 – 3



Install the mastic tapes around the jacket pipes approx. 20 mm from the jacket pipe edges. Press the tape ends together.

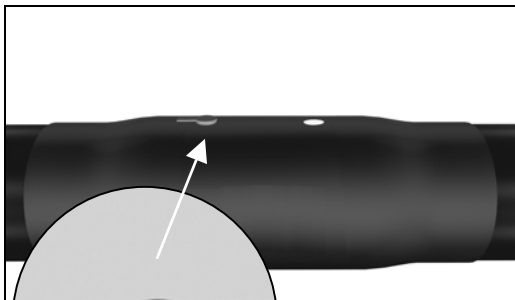


Remove the packing from the shrink sleeve. Check that the sleeve is CLEAN and DRY, inside and out. Centre the shrink sleeve on the joint. When the sleeve has been positioned, remove the paper from the mastic tapes. Check that the sleeve is correctly positioned. Shrink the outermost 100 mm at both ends.

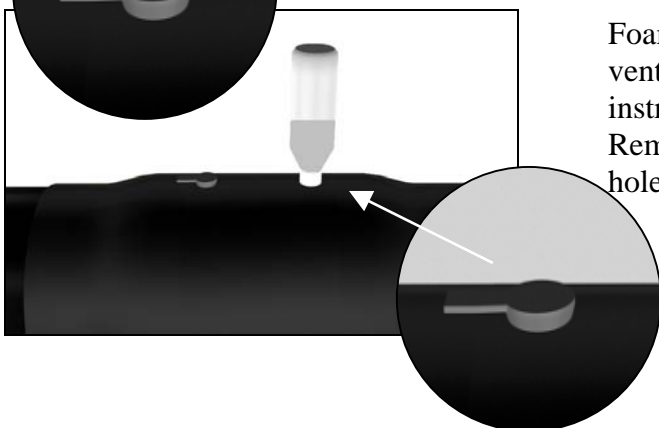


Drill a hole in the sleeve for the foam.

Make a tightness test of the joint at 0.2 bar.



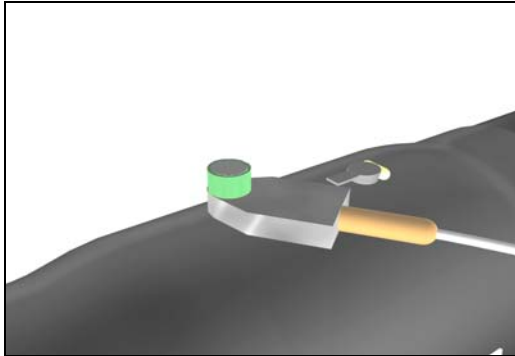
Install ventilation plug in one of the holes.



Foam the sleeve in the other. Install the other ventilation plug. Besides, we refer to the instructions for use of the foam supplier. Remember to clean the surface around the holes.

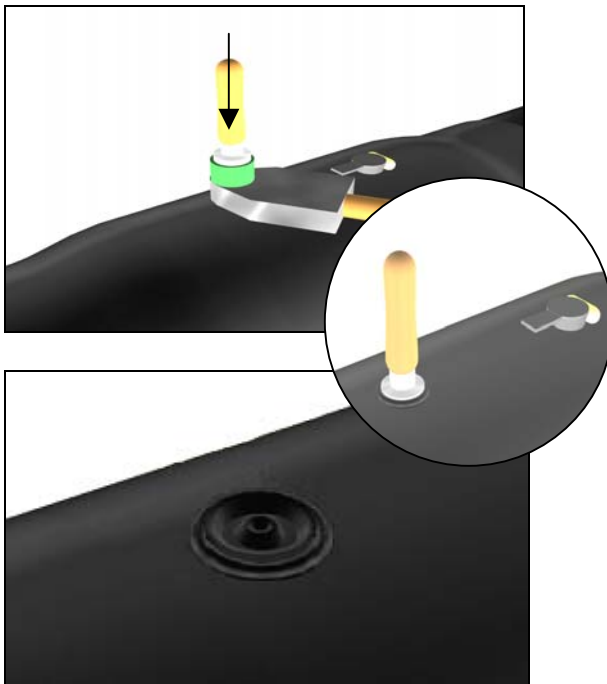
Shrink sleeve with mastic

3 – 3



Heat the welding tool to $260^{\circ}\text{C} \pm 10^{\circ}\text{C}$.
Heat the hole while the tool is pressed down.

Casing pipe dim.	Heating time
066-125	10 sec.
140-200	20 sec.
225-315	30 sec.
355-500	40 sec.
560-630	50 sec.



Place the welding plug in the plug keeper.

Press the welding plug downwards in the reflector, and heat the edge of the hole and the plug at the same time.

When both parts are well heated, take away the reflector and press immediately the welding plug down in the hole. Press down until the welding plug flushes with the upper edge. Do not press further down. Press constant and soft for at least 1 min.

There has to be 1 or 2 homogeneous welding beads around the welding plug. Do not take away the plug keeper till the surface is hand warm.

Repeat the process with the other plug.



Check the joint.

The joint is complete.