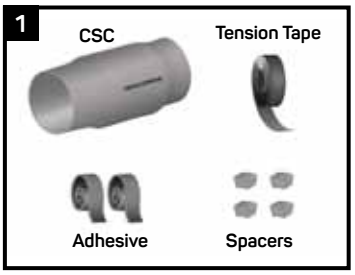
CSC SuperCase (Alternate Design, Sizes 63 - 180)

One-piece heat-shrinkable casing for foam-in-place pre-insulated pipes

Product Description

1



The CSC SuperCase is a crosslinked, heat shrinkable casing for joint protection of pre-insulated pipe. If the spacer kit is used, it contains: Adhesive & Spacers.

General Information

2

This Installation Guide is for CSC SuperCase Alternate Design

EN 489 Approved

Minimum Shrink Recovery ~ 20%

These installation instructions are intended as a guide for standard products. Consult your Canusa representative for specific projects or unique applications.

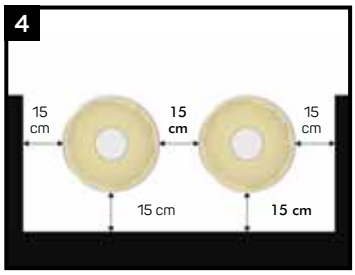
Equipment List

3

Propane tank, hose, torch & regulator; Sandpaper (40-60 grade) or wire brush; Knife, roller, rags & ethanol (min. 94%) or isopropyl alcohol cleanser; Temperature measuring device, triangular scraper; Marking pencil, grater, drill, CFS Rolling Tool; Standard safety equipment; gloves, goggles, hard hat, etc

Backfilling Trench

4



Ensure there is adequate work space area around the pipe in the backfilling trench.

Flame Intensity

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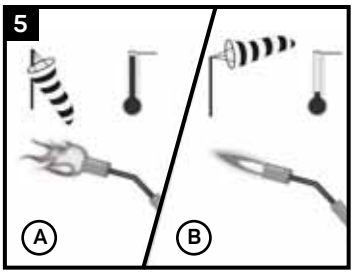


Adjust the flame according to outside conditions.

a. Use weak yellowish-orange flame for low wind, higher temps

b. Use moderate bluish-yellow flame for high wind, lower temps

Always aim the torch perpendicular to the shrink zone of the CSC and move in a circumferential direction quickly around the jacket pipe. **Do not overheat the jacket pipe as it will burn with excessive heating.**

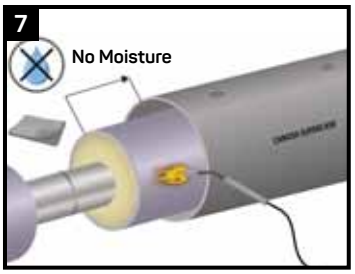
Casing Preparation

6

Check the CSC to ensure that it is not damaged. Before welding together the carrier pipes, slide the CSC as far away from the joint as possible.

General Drying and Cleaning

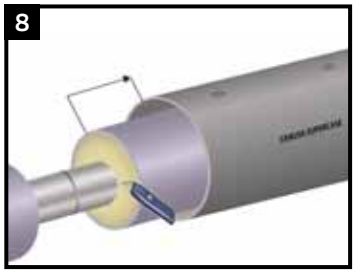
7



Use a propane torch with a **low** flame to dry the jacket pipe, carrier pipe and CSC. Use a dry, grease and lint-free rag to wipe clean the jacket pipe, carrier pipe and CSC.

Pipe Preparation

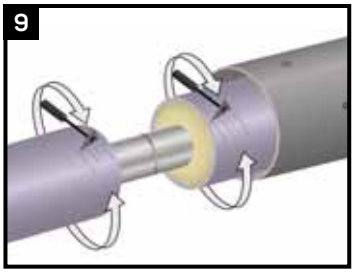
8



Remove any wet PUR foam from the end of the pre-insulated pipe.

CSC Position Marking

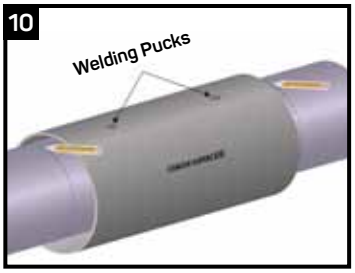
9



Using a triangular scraper, clean the edges of the jacket pipe to remove any burrs and dirt from the sealing area.

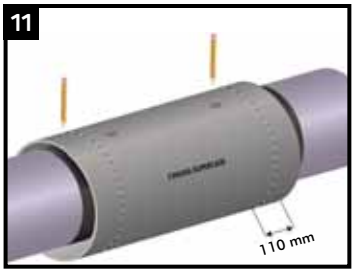
CSC Position Marking

10



CSC Shrink Zone Marking

11



Air Hole

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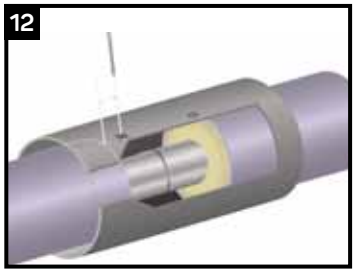
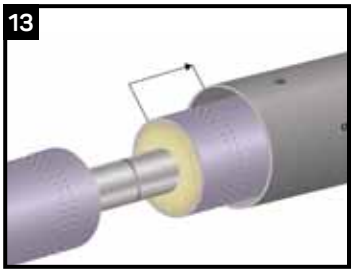


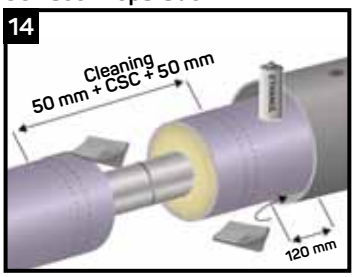
Drill a hole for air pressure relief through the centre of one of the foam hole welding pucks to allow air to escape during installation. **Ensure no damage is done to the jacket pipe.**

CSC Position



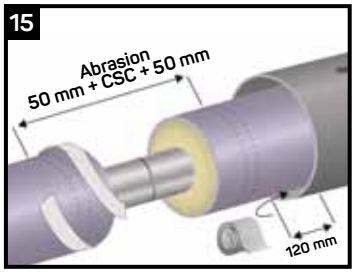
Slide the CSC away from the jacket pipe edge.

Surface Preparation



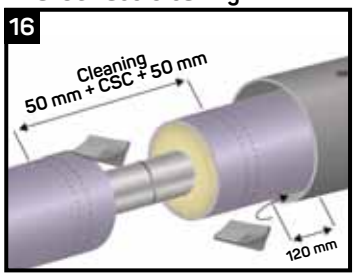
Clean the surface of the jacket pipe and the inside of the end zone of the casing with a rag to remove dirt. De-grease the surface of the jacket pipe and the inside of the CSC using a grease and lint-free rag soaked in ethanol (min. 94%) or isopropyl alcohol cleanser.

Surface Abrasion



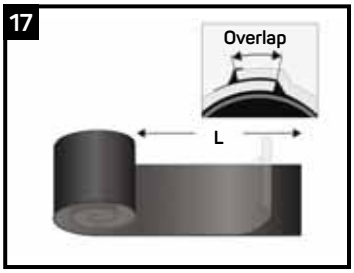
Roughen the surface of the jacket pipe on both sides of the cutback and the **inside of the CSC** using the sandpaper (40 to 60 grade).

Final Surface Cleaning



Using a dry, grease and lint-free rag, clean the roughened surface to remove any polyethylene or sand particles.

Adhesive Length (With Bulk Roll)



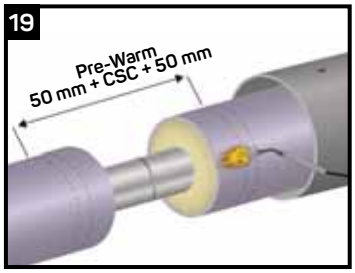
If not using the pre-cut adhesive from a kit, measure the circumference of the jacket pipe and cut two sealing strips long enough to allow for overlap.

The Length (L) should be the circumference + 35mm overlap.

Pre-Warming (Inside of Casing)

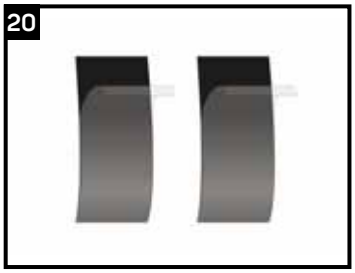
Pre-warm the inside of the casing on each end (150mm) by moving it half-way over the joint. Use low intensity flame to make sure that the casing does not start to recover.

Pre-Warming (Jacket Pipe)



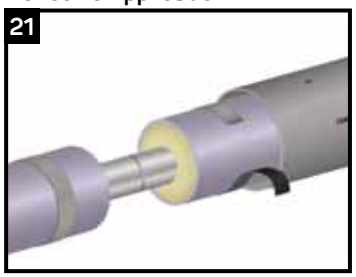
Pre-warm the pipe to 40°C-50°C. **Ensure the correct temperature with a temperature measuring device.** Do not exceed 60°C as this makes the removal of release liner difficult.

Release Liner

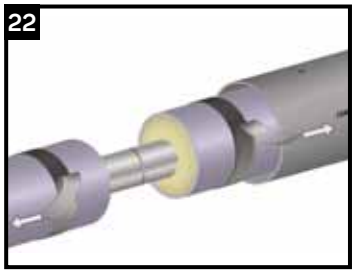


Remove the thinner release liner (opposite the mesh side) from both adhesive strips and...

Adhesive Application

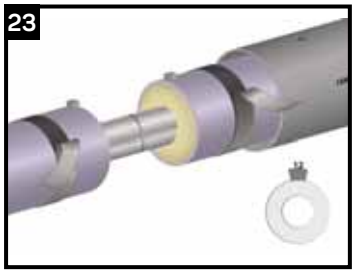


...apply the adhesive strips tightly around the jacket pipe with the mesh side facing up. The strips should be applied so that they are placed approximately 5mm inside of the marks. Make sure the adhesive is not stretched during wrapping. Partially peel-back the release liner on the under lap and wrap the strips around the jacket pipe so that they overlap.



Fold the release liner outwards to allow for easy removal after positioning the casing.

Spacing Placement



Remove the paper backing and place the spacer at the 12 o'clock position of the jacket pipe, right at the edge of the cutbacks. Note: The use of spacers is optional, but recommended.

CSC Placement

Carefully slide the CSC over the joint, so that the edges are centered over the edge of the adhesive strips.

CSC SuperCase (Alternate Design, Sizes 63 - 180)

CSC Installation

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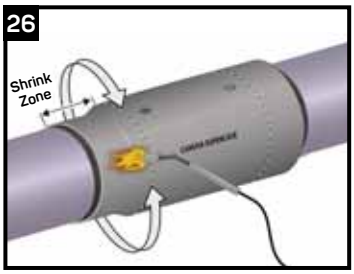
Completely remove the release liners from the adhesive strips.

26



Using broad strokes and the appropriate flame, begin shrinking one end of the CSC evenly all around. Keep the torch moving to avoid overheating any spots; ensure sufficient heat is applied at the bottom. **Ensure the flame remains in the shrink zone and the torch is never pointed at the CSC middle or jacket pipe.**

Quality Check (Finger Probe Test)

27

With a gloved finger, press down on the shrunk area to ensure the backing and adhesive are soft. If there are cool spots, the shrink zone should be reworked with additional heat.

28

Continue heating the edge until it is fully recovered around the entire circumference of the jacket pipe. **Shrinking has been completed when the shrink zone of the CSC has conformed to the entire pipe jacket.**

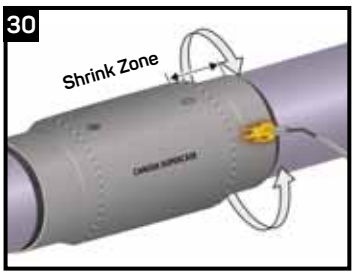
Quality Check (Finger Tip Test)

29

As a final check, ensure that the shrink zone of the CSC conforms intimately with the entire pipe surface. This can be checked by feeling the edges all around the circumference of the casing. If there is edge lifting, the edge should be reworked with additional heat.

CSC Installation - other side

30



Repeat Steps 26 to 29 on the other shrink zone.

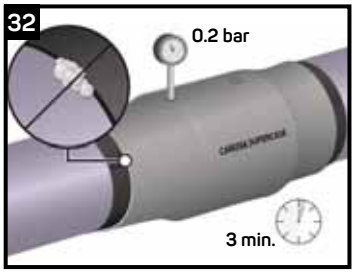
Cool to < 40°C

31

Allow the CSC to cool for 30 minutes. After 30 minutes measure the surface temperature of the CSC shrink zones. If the surface temperature of the shrink zones are still above 40°C, use shading and/or damp towels to quicken CSC shrink zone cooling time.

Quality Check (Air Pressure Test)

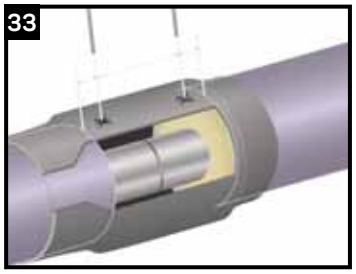
32



Ensure the CSC shrink zones have cooled to below 40°C. Perform the pressure test using the previously drilled pressure hole. The CSC should be checked with an air pressure test for 3 minutes at 0.2 bar. In case of a leak, the CSC shrink zones should be reworked with additional heat at the leaking area. The pressure test should then be repeated.

Foaming Holes

33



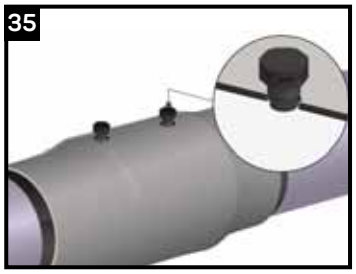
Drill one foaming hole over the pressure testing hole. Drill the other foaming hole, if required through the centre of the other foam hole welding puck.

Foaming

34

The temperature of the CSC shrink zones should not be more than 40°C when foaming. If necessary, follow the cooling instructions as described in step 32 to ensure the CSC shrink zones are below 40°C.

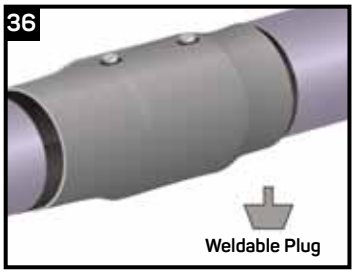
35



Foam the joint according to the manufacturer's guideline. Use standard ventilation plugs while foaming.

Foam Hole Sealing

36



After the foam has hardened, remove the ventilation plugs and drill any holes necessary for sealing. When using Canusa approved weldable plugs and welding machine, it is required to match the conical geometry with all pieces of equipment (i.e. weldable plug, drill bit, welding machine heating cups). Cylindrical tools for plug welding are not recommended. Note: Using an approved welding tool, (at 250 the recommended times for plug welding are:

1. Pre-warm the sealing hole for 45 sec.
2. At the same time as step 1), pre-warm the welding plug for 30sec.
3. Insert plug into sealing hole and hold for 30sec.

Total Installation Time = 105 sec.

CSC Completed Installation

37

Visually inspect the completed casing. **Ensure that the ends of the CSC are completely shrunk down.** To double seal the foaming hole use a Canusa Foam Seal - CFS.

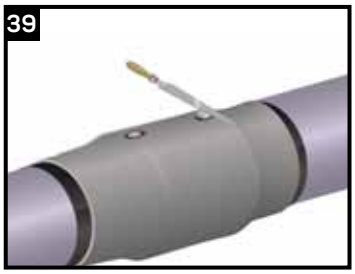
Control Step

38

Continue with step 39 when the foaming hole is to be double sealed with a weldable plug and Canusa Foam Seal - CFS.

Surface Preparation

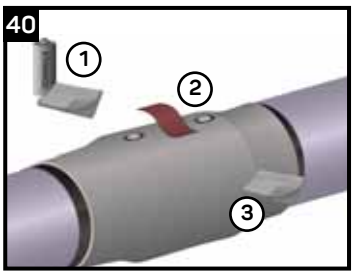
39



Using a grater, sand down the plugs bringing them flush to the surface of the CSC.

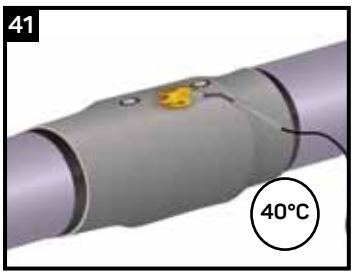
CFS Installation

40



1. De-grease the surface around the plug using a grease and lint-free rag soaked in ethanol.
2. Roughen the surface with sandpaper (40 to 60 grade).
3. Use a grease and lint-free rag to remove any polyethylene or sand particles caused by roughening the surface.

41



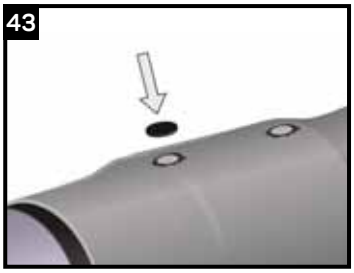
Pre-warm the casing surface around the foaming hole to 40°C. **Do not overheat the surface as the foam will gas.** Check the temperature using a temperature measuring device.

42

Heat the adhesive side of the CFS with a medium intensity flame until the adhesive becomes glossy (Adhesive will melt).

Weldable Plug CFS Rolling

43



Place the CFS onto the pre-cleaned and pre-warmed section of casing directly over the centre of the foaming hole.

44

Using a weak medium flame, heat the backside of the CFS until the adhesive oozes from the edge and the thermochromic ink print disappears. **Do not overheat the surface as the foam will gas.**

45

Using a roller, gloved hand or the side of the larger end of the CFS Rolling Tool; smooth out the CFS surface. Ensure adhesive has oozed from all sides of the CFS.

CFS Completed Installation

46

The CFS has been fully installed when adhesive can be seen around the entire circumference and is in full contact with the casing.

Backfilling Guidelines

After shrinking is complete, the CSC should be left for as much time as possible prior to backfilling (1 hour). This ensures that the adhesive has cooled enough and that sealing is achieved. To prevent damage to the CSC, use selected backfill material (no sharp stones or large particles).

Storage & Safety Guidelines

To ensure maximum performance, store Canusa products in a dry, ventilated area. Keep products sealed in original cartons and avoid exposure to direct sunlight, rain, snow, dust or other adverse environmental elements. Avoid prolonged storage at temperatures above 35°C (95°F) or below -20°C (-4°F). Product installation should be done in accordance with local health and safety regulations.

These installation instructions are intended as a guide for standard products. Consult your Canusa representative for specific projects or unique applications.

Canusa-CPS
A division of Shawcor Ltd.

Head Office
25 Bethridge Road
Toronto, ON, Canada M9W 1M7
Tel: +1 416 743 7111
Fax: +1 416 743 5927

Canada
Dome Tower St. 2200,
333-7th Avenue SW
Calgary, AB, Canada T2P 2Z1
Tel: +1 403 218 8207
Fax: +1 403 264 3649

Americas
5875 N. Sam Houston Pkwy W.,
Suite 200
Houston, TX, USA 77086
Tel: +1 281 886 2350
Fax: +1 281 886 2353

Middle East
Plot # 37-WR43, Sector no.: ICAD III
Musaffah South, PO Box 2621
Abu Dhabi, The United Arab Emirates
Tel: +971 2 204 9800

Europe, Africa & Russia
Dellaertweg 9-E, Gebouw
"Le Carrefour"
2316 WZ Leiden,
The Netherlands (NL)
Tel: +31 71 80 802 70
Fax: +31 71 80 802 71

Asia-Pacific
101 Thomson Road,
#11-03 United Square
307591 Singapore
Tel: +65 6749 8918
Fax: +65 6749 8919

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