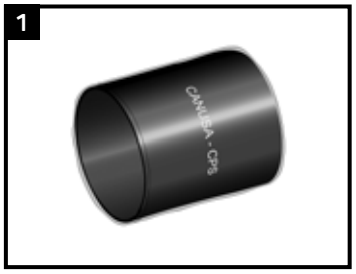
PTD™

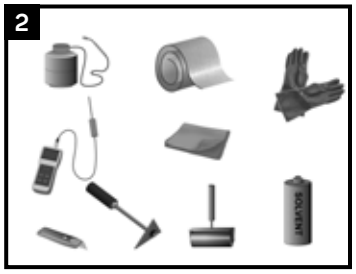
Heat Shrinkable Tubular Sleeve for Protection of Pre-Insulated Pipe Joints

Product Description



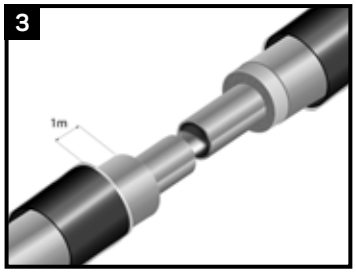
PTDs are individually packaged to protect the adhesive from contamination.

Equipment List



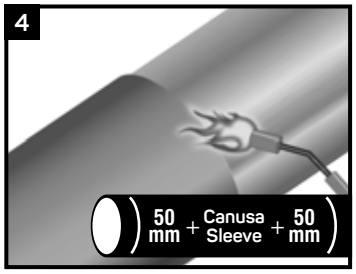
Propane tank, hose, torch & regulator Appropriate tools for surface abrasion (40-60 grade sandpaper) Knife, roller, triangular scraper, rags & approved solvent cleanser Digital thermometer with suitable probe Standard safety equipment; gloves, goggles, hard hat, etc.

Surface Preparation

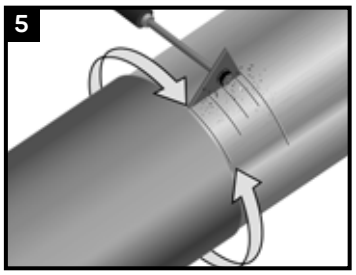


Before welding together the carrier pipe, slide the tubular sleeves at least 1 meter away from the cutback area on each side of the joint.

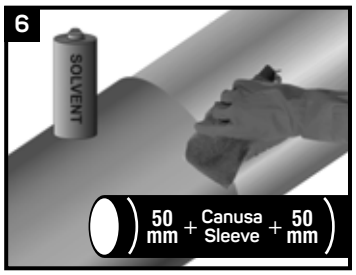
Surface Preparation



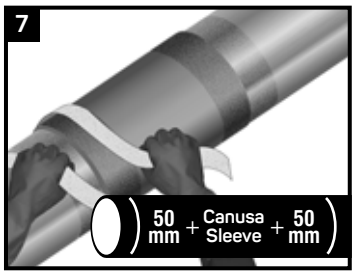
Dry the surface of the casing and jacket pipe (width of sleeve + 50 mm on each side) with moderate flame intensity. Clean the surface with a dry, grease and lint-free rag to remove any grease or dirt.



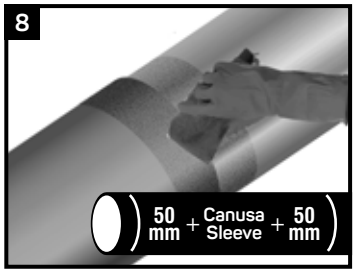
Clean the edges of the casing to remove any sharp corners and burrs, foam and dirt, using a triangular scraper.



De-grease the surface (width of sleeve + 50 mm on each side) using a grease and lint-free rag soaked in ethanol (min. 94%) or other suitable solvent.

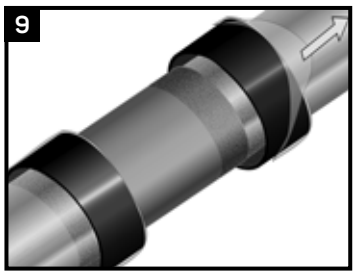


Roughen the surface (width of sleeve + 50 mm on each side) using 40-60 grade sandpaper.



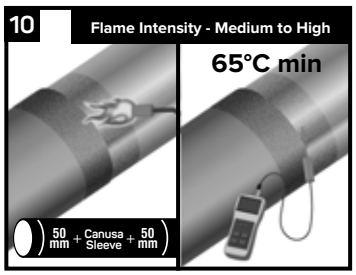
Clean the roughened surface to remove any polyethylene or sand particles, using a dry grease and lint-free rag.

Inspection



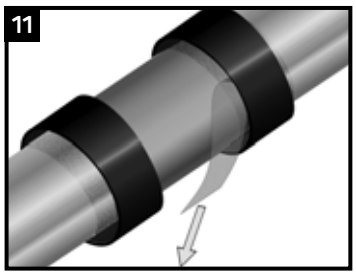
Remove the plastic bag from the tubular sleeve. Ensure that there is no dirt or moisture inside the tube and that the tube is not cut. If the sleeve is not useable, a one-piece Superseal pre-welded sleeve or Superseal bulk wrap sleeve should be used.

Pre-Heat

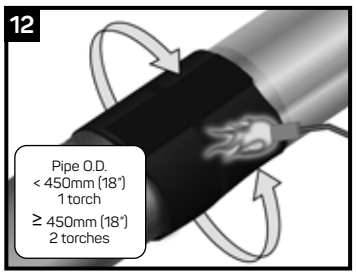


Using medium to high intensity flame, pre-heat and activate the surface to be covered with heat shrink sleeve and **min 50 mm** on each side of the sleeve to a minimum temperature of 65°C. The flame shall be kept perpendicular to the surface of the pipe and casing during pre-heating. Check the temperature around entire circumference of the pipe with a touch probe.

Sleeve Installation



Remove the inner release liner from the sleeve and centre the sleeve over the area to be sealed (casing/PE pipe).



Using the appropriate torch, begin at the centre of the sleeve and heat circumferentially around the pipe. Use broad strokes. If utilizing two torches, operators should work on opposite sides of pipe.

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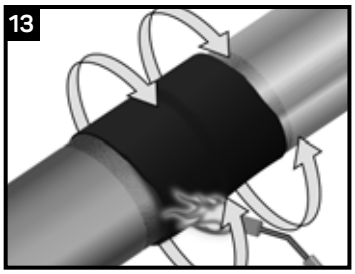

Continue heating from the centre toward one end of the sleeve until recovery is complete. In a similar manner, heat and shrink the remaining side.

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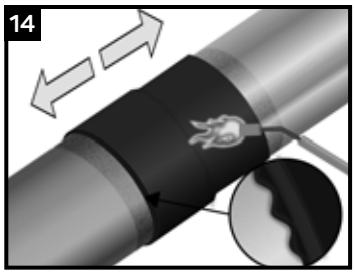

Shrinking has been completed when the adhesive begins to ooze at the sleeve edges all around the circumference. **Make sure the edges of the sleeve are not lifting anywhere around the circumference of the pipe.** Finish shrinking the sleeve with long horizontal strokes over the entire surface to ensure a uniform bond.

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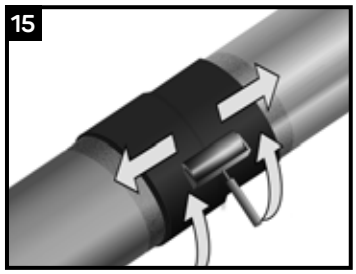

While the sleeve is still hot and soft, use a hand roller to gently roll the sleeve surface and push any trapped air up and out of the sleeve, as shown above. If necessary, reheat to roll out air. At the same time, the closure area shall also be rolled to ensure its full conformance to the underlying sleeve and substrates.

Quality Check

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During shrinking, press down on the sleeve to ensure adhesive flow over the entire surface. Special attention should be given along the circumference between 4 and 8 o'clock and along the overlap area. In order to avoid a channel formation at the step down, the sleeve should be pressed down. The shrinking has been completed when an adhesive ooze begins at the sleeve edges all around the circumference.

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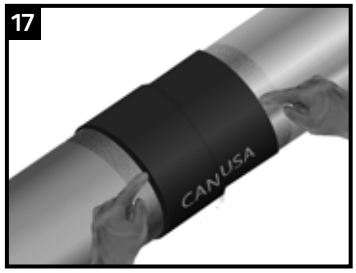

As a final check, ensure that the sleeve follows the entire contour of the surface and that there are no cold spots or burning of the sleeve. **Make sure the edges of the sleeve are not lifting anywhere around the circumference of the pipe.** This can be checked by feeling the edges all around the circumference of the sleeve. If there is edge lifting, the edge should be reworked with additional heat.

Recommendations

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After shrinking the sleeves, they should be left for as much time as possible prior to backfill (min. 1 hour, depending on ambient temperature). This ensures that the adhesive has cooled enough to reach the required peel and shear strength and that permanent sealing has been attained.

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.

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Quality Management system registered to ISO 9001

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