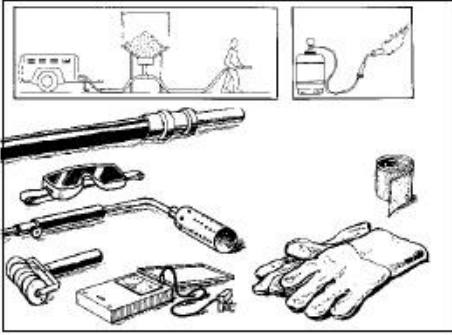


热缩套安装说明书

Installation Instructions for Tubular Heat-shrinkable Sleeve



安装准备 Materials and equipment

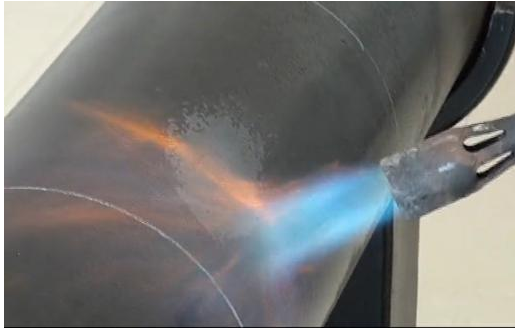
1. 合适尺寸的热缩套、环氧底漆、搅拌棒、防护手套。
 2. 加热枪或其等同物。
 3. 煤气罐。
 4. 测温仪。
 5. 压辊。
 6. 安全装备如手套、防护眼镜、安全帽等。
1. Appropriate size sleeve, epoxy primer, mixing sticks, protective gloves.
 2. Torch or equivalent.
 3. Propane tank with regulator, hose and gauge.
 4. Contact pyrometer.
 5. Siliconized hand roller
 6. Standard safety equipment such as gloves, goggles, hard hat, etc.



1. 用喷砂机或其他机械方法去除补口处钢管表面的铁锈，使其达到SIS 055900 -SA 2 1/2级（至少不低于St3级）
Grid blast or sand blast the steel surface to remove loose and foreign materials. The surface should be cleaned to SIS 055900 -SA 2 1/2 (at least SIS 055900 - ST3).



2. 用抹布或鼓风机去除补口处钢管及两侧FBE层/PE层的灰尘与杂物。
Wipe exposed steel and adjacent pipe coating to remove dust and remaining blasting material. Use a clean dry cloth or air blow.



3. 用加热枪均匀加热补口处钢管，将钢管预热，用测温仪测定补口处钢管表面温度，直到温度达到50°C~70°C。
Preheat the steel and the adjacent pipe coating evenly with a torch, to 50°C minimum, 70°C maximum. Check the preheating temperature with a contact pyrometer.



4. 将双组份环氧底漆按比例混合，并搅拌均匀。将混合好的底漆均匀涂敷于补口处钢管表面（温度为70°C左右）。底漆涂层厚度应达到100-500微米。
Mix the two-part epoxy primer in the right proportion and apply to the preheated surface. Use application pad to spread it evenly over the joint area and on to the adjacent pipe coating to achieve a film thickness of 100 to 150 microns.

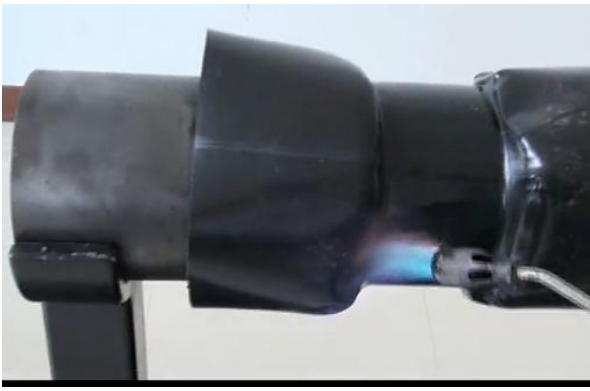


5. 安装热收缩套

移除热收缩套内衬垫，将热收缩套安装在管道补口处中心位置使其完全密封。热缩套需在管道焊接前套上。

Install the heat shrinkable sleeves

Completely remove the inner release liner from the sleeve and centre the sleeve over the area to be sealed. Tubular heat shrinkable sleeves should be installed before welding the pipeline.



6. 加热与收缩

从中部沿周向用加热枪加热热缩套，先使其中间收缩，再从中间向一端加热收缩。再用同样的方法对热缩套的另一端加热收缩。注意加热要均匀，逐步向前移动。

Heating and Shrinking

Begin heating at the center of the sleeve and heat circumferentially around the pipe using a constant paintbrush motion. Continue heating toward one end of the sleeve, followed by the other. Ensure that the total sleeve has been heated evenly and has completely shrunk tightly around the pipe.



7. 趁热缩套还是热的柔软的，用压辊在热缩套的表面滚动以消除气泡。若有缺陷，需再次加热热缩套。

While the sleeve is still hot and soft, use a hand roller to firmly roll the sleeve surface to push any trapped air up and out of the sleeve, as shown above. If necessary, reheat to roll out air.



8. 安装好的热缩套，两端应有胶溢出。为确保整个热缩套出胶均匀，可用中火在水平方向上快速均匀回火。

Shrinking has been completed when the adhesive begins to ooze at the sleeve edges all around the circumference. Finish shrinking the sleeve with long horizontal strokes over the entire surface to ensure uniform bond.