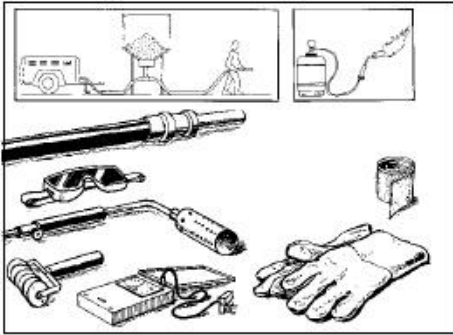


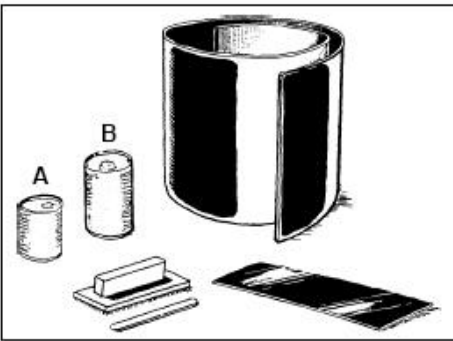
热缩带安装说明书

Installation Instructions for Wrap-around, Heat-shrinkable Sleeve



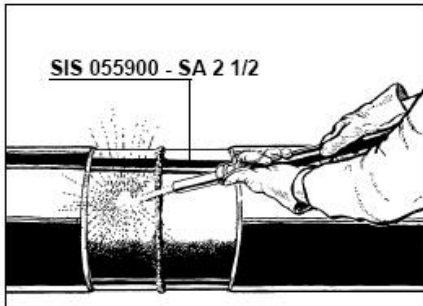
安装准备 Materials and equipment

1. 合适尺寸的热缩套、固定片、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 and closure, 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.

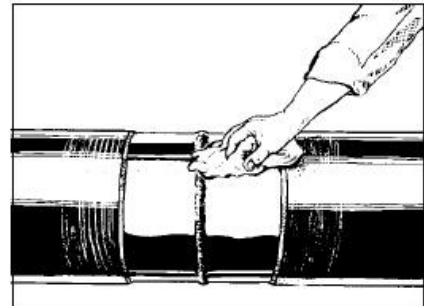


注意事项 Notes

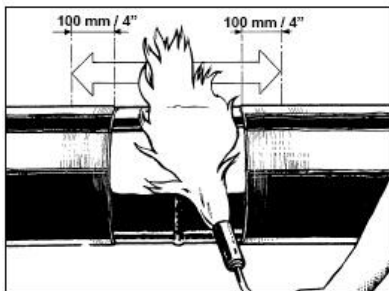
- *请根据当地法规与常用的安全预防措施进行安装。
- *本安装说明适用于2PE或3PE的、使用双组份环氧底漆的开口热缩套。
- *需要选购其他的管道焊口防腐材料，请参考我司的选购指南，或联系我司业务员。
- *Installation must be done according to local regulations and usual safety precautions.
- *This installation instruction is intended for the wrap-around heat-shrinkable sleeve to be installed on pipes coated with two-component epoxy primer, 2 or 3 layer PE.
- *For the selection of joint protection materials for other pipe coatings, see product selection guide or contact our sales.



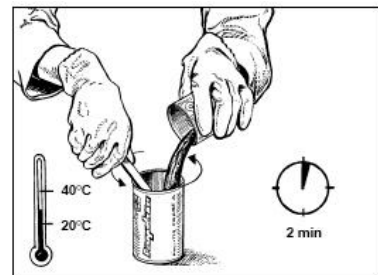
1. 用喷砂机或其他机械方法去除补口处钢管表面的铁锈，使其达到 SIS 055900 -SA 2 1/2级（至少不低于St3级）
Grid blast or sand blast the steel surface to remove loose and foreign materials. The surface should be cleaned to SIS 055900 -SA 2 1/2 (at least SIS 055900 - ST3).



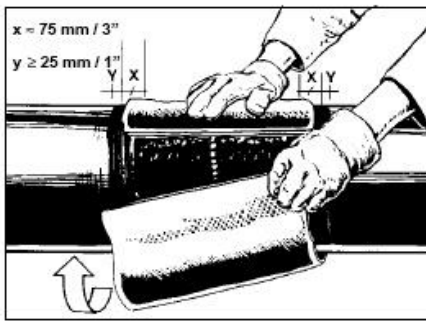
2. 用抹布或鼓风机去除补口处钢管及两侧FBE层/PE层的灰尘与杂物。
Wipe exposed steel and adjacent pipe coating to remove dust and remaining blasting material. Use a clean dry cloth or air blow.



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.

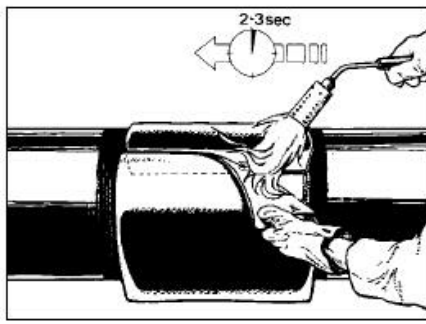


4. 将无溶剂环氧底漆A、B双组份按比例混合，并搅拌均匀。将混合好的底漆均匀涂敷于补口处钢管表面，即可安装热收缩套。
Mix the pre-dosed two component epoxy, and stir them totally. Evenly dispense the mixed epoxy primer to the preheated steel and the adjacent pipe coating.



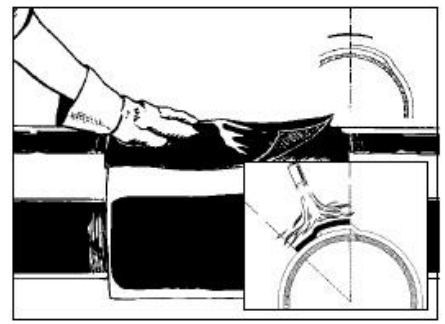
5. 安装热收缩带，使其与两端FBE层/PE层搭接长度相等。加热补口片一个端头的胶层，胶层熔化宽度约为100mm~150mm，并固定于补口处。

Loosely wrap the sleeve centrally around the welded joint. One edge of the sleeve should be pressed on the pipe first after heating its inside. The width of heated edge is 100~150mm.



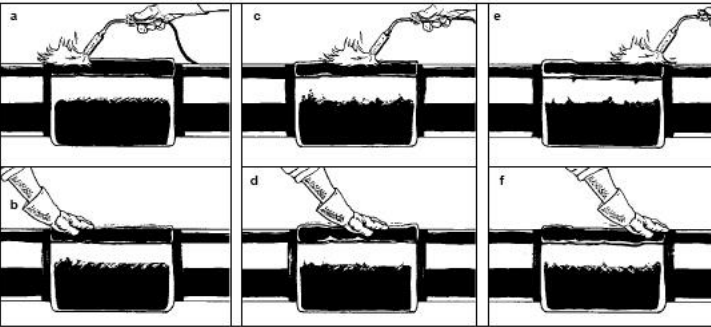
6. 将热收缩带沿钢管表面包卷，再加热补口片另一端的胶层，胶层熔化宽度约为100~150mm，固定于补口处。要求两个端头处的搭接重叠部分为80~150mm(根据钢管直径确定搭接长度)

Gently heat the inside of the overlapping sleeve edge and press down onto the opposite sleeve. According to the diameter of pipe, the overlap of the sleeve onto itself should be 80~150mm.



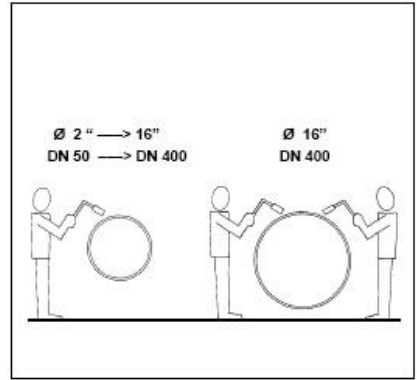
7. 将固定片的胶层加热熔化，并迅速的粘贴在搭接处。

Heat the inside of the closure patch. Immediately position it evenly over the edge of the heat shrinkable sleeve. Press it down firmly.



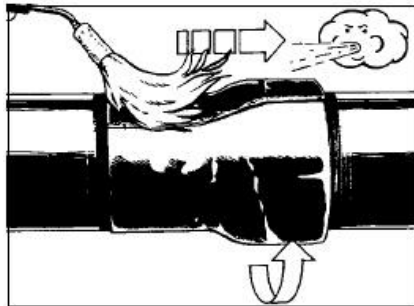
8. 继续加热固定片，使固定片充分的粘接在搭接处，并用手压平。

Continue heating the closure patch from one side and slowly move to the other side, whilst pressing down with a gloved hand to ensure good bonding.



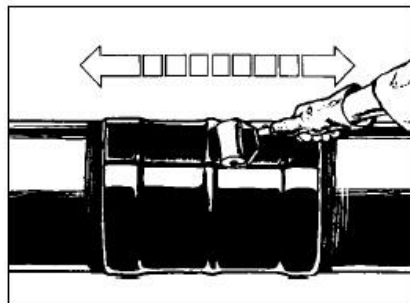
9. 若热缩套用于口径大于等于400mm的管道上，建议两个工人同时施工加热。

For sleeves for pipes 400 mm diameter and larger, two installers are recommended.



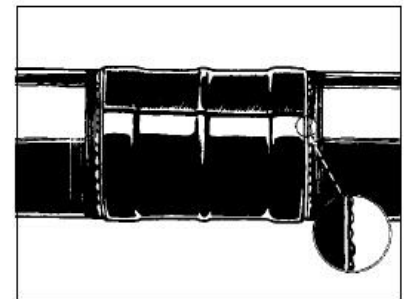
10. 从中部沿周向用加热枪加热热缩套，先使其中间收缩，再从中间向一端加热收缩。再用同样的方法对热缩套的另一端加热收缩。注意加热要均匀，逐步向前移动。

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.



11. 在收缩过程中，如果出现气泡或褶皱，应用压辊碾平，以消除气泡。

Possible air entrapments can be reduced to the maximum by post rolling of the sleeve.



12. 收缩完毕，应仔细检查热收缩套和固定片。若有缺陷，应及时加热并用压辊碾平。

After the sleeve is fully recovered, check sleeve and closure patch again. If necessary, areas may be reheated to roll out air.