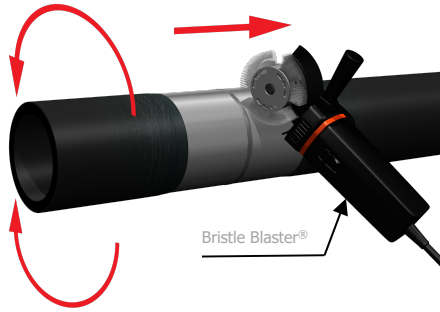


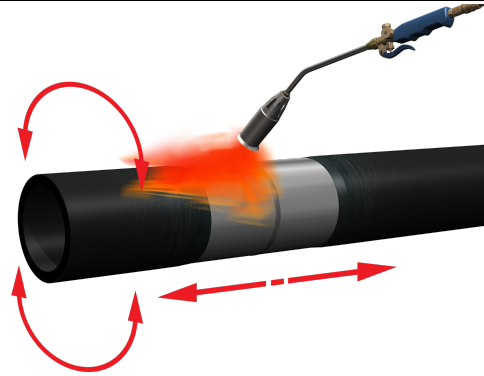
“ANTICORRay WSS60” APPLICATION TECHNOLOGY



Step 1

Surface cleaning

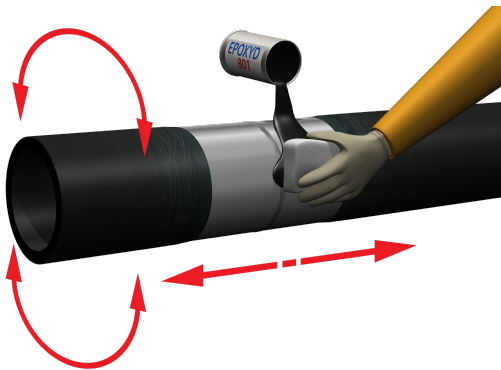
- 1) At first, clean the surface to be insulated from impurities and degrease with fat-free solvent (e.g. petroleum ether, acetone).
- 2) Clean steel surface up to cleanliness degree of Sa 2 ½ according to the ISO 8501 standard. Use, for instance, the Bristle Blaster® mechanical brush.
- 3) Using sandpaper, roughen the ends of factory insulation at the length of about 10 cm.
- 4) Bevel the ends of factory insulation at an angle of about 15°.



Step 2

Preheating

- 1) Using burner, evenly heat the surface prepared for insulating up to the temperature min. 70°C.
- 2) Control the temperature during heating by using thermometer.
- 3) Simultaneously with surface preheating, mix both components of epoxy primer “ANTICORRay Epoxy Primer 801” well in right proportion.



Step 3

Application of primer

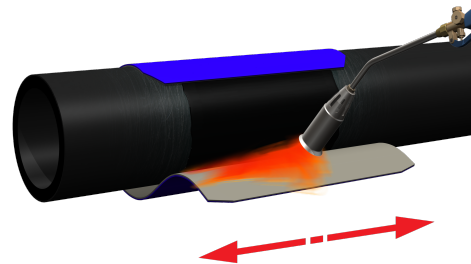
- 1) Apply the well mixed primer on steel surface and factory insulation (min. 10 cm from the edge of insulation) using sponge delivered with the system kit.

Notes:

The layer should be at least 100µm thick.

Well applied primer should be uniformly black (with no steel showed through and without sagging).

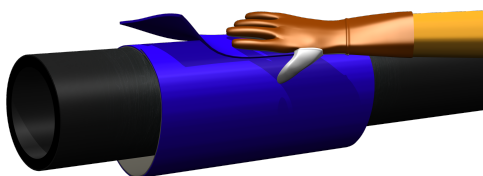
Protect hands by wearing gloves delivered with the system kit.



Step 4

Application of a sleeve

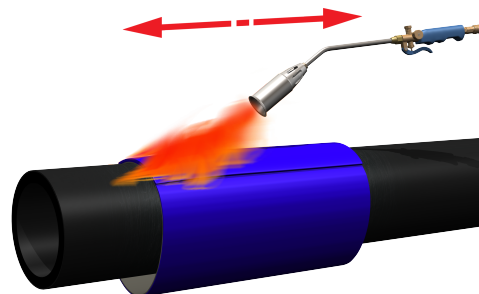
- 1) Remove silicone-coated paper.
- 2) Heat the glue/adhesive with soft flame at the end of sleeve from the side of sharp corners.
- 3) Place the heated end centrally on welded joint at the “eleven o’clock” position pressing it against the pipe surface.
- 4) Wrap the sleeve loosely around the pipe, leaving clearance of about 2-4 cm under the sleeve.
- 5) With soft flame, heat up the glue on the other end of sleeve.
- 6) Place the heated end on the glued-in sleeve, while maintaining the recommended overlap.



Step 5

Gluing-in of the closing strip

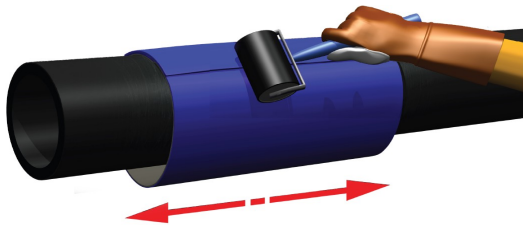
- 1) Heat up the inner side of closing strip with soft flame to make the glue/adhesive soft.
- 2) Apply the strip symmetrically along the sleeve edge.



Step 6

Heating the closing strip

- 1) Heat the outer surface of strip with strong flame until it becomes plastic.

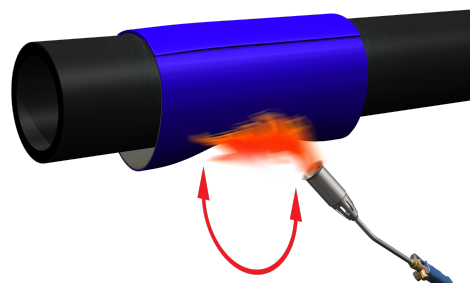


Step 7

Final gluing of sleeve

- 1) Press the heated closing strip very firmly against the sleeve with a silicone roller or with hand wearing a protective glove.

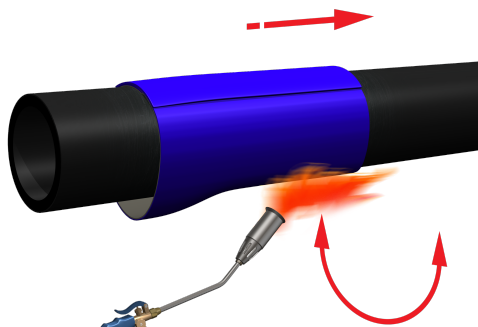
Note: The properly glued strip shows no wrinkles and closed „air pockets”.



Step 8

Shrinking of sleeve I

- 1) Heat up the sleeve with strong flame, starting from underneath, centrally at the height of welded joint. Move the flame alternately along the entire circumference.

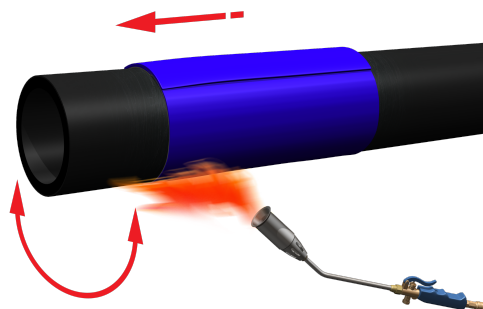


Step 9

Shrinking of sleeve II

- 1) Continue to heat the sleeve up going from welded joint in one direction, then in the other, moving the flame along the circumference.

Notes: Heating should be done uniformly and evenly to avoid trapping of air under the sleeve. The sleeve should adhere tightly to the pipe. The sleeve on pipelines with diameter above DN300 should be shrank using two burners placed symmetrically on both sides of a pipeline.

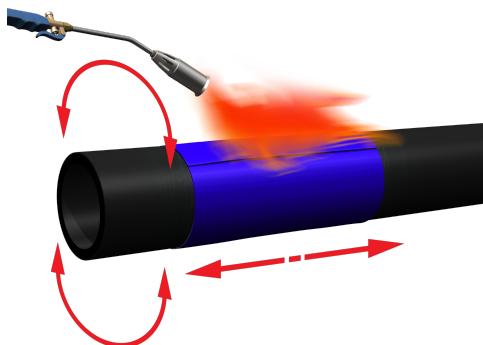


Step 10

Shrinking of sleeve III

- 1) Finally, heat up the whole surface of sleeve by slow, longitudinal passes of the burner along the entire circumference to obtain uniform melting of the glue and even shrinking of the coating.

Note: Shrinking operation is finished when glue begins to flow out from under the edges of sleeve.

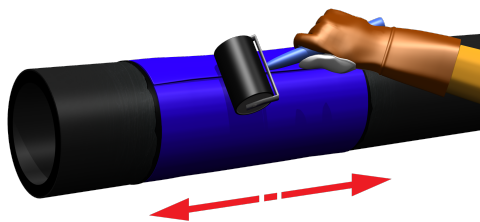


Step 11

Check if the sleeve was heated properly

- 1) Press the sleeve with a finger in several points, trying to move it slightly.

Note: If the sleeve is heated well, then after pressing and moving the finger a wrinkle appears which upon completion of the test disappears by itself.

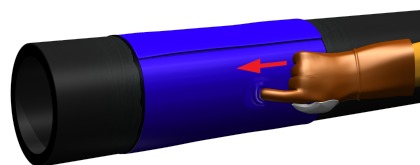


Step 12

Smoothing of sleeve

- 1) Smoothen the sleeve using a silicone roller, especially around the welded joint and near the closing strip, to remove possible air pockets.

Note: If air pockets were formed, remove them by moving the roller from the centre of the sleeve towards the edges. The sleeve can be re-heated if necessary.



Step 13

Finishing works

- 1) Using UV and water-resistant marker, write the following information on the sleeve surface:

- Company name, name and surname of the person who performed the installation.
- Date and time of installation completion.

Note: The above information written on the sleeve serves as the **certificate** of the installed coating.

Should any problems occur, please contact us – our technical support staff is ready to help. Thank you for choosing our offer.

