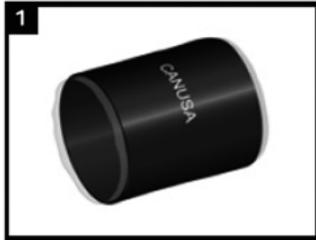


Installation Guide K-60 HS-CT

Tubular sleeve for protection of Tyton joints

Product Description



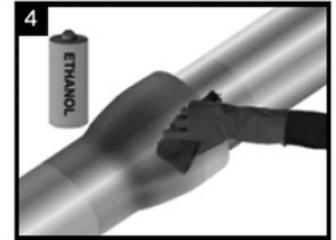
K-60 HS (CanusaTube™) are shipped with an inner release liner for protection from contamination.

Equipment List

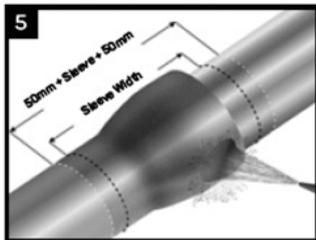


Propane tank, hose, torch & regulator; Appropriate tools for surface abrasion; Knife, roller, rags & approved solvent cleanser; Digital thermometer with suitable probe; Standard safety equipment; gloves, goggles, hard hat, etc.

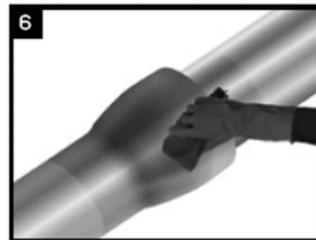
Surface Preparation



Ensure that the coating edges are beveled to 30°. Clean exposed steel and adjacent pipe coating with a solvent cleanser to remove the presence of oil, grease, and other contaminants.

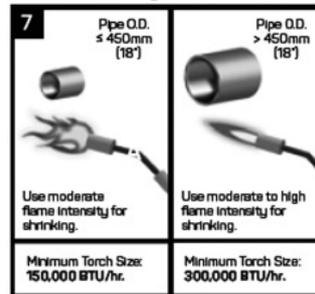


Ensure that the pipe is dry before cleaning. Prepare the steel joint area to a minimum of St2 /SP2. Lightly abrade the pipe coating adjacent to the weld area to a distance of 50mm (2") beyond each end of the sleeve width.

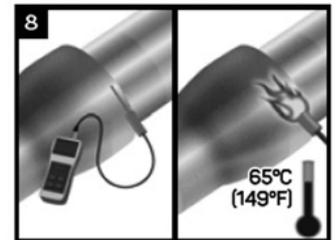


Wipe clean or air blast the steel and pipe coating to remove foreign contaminants.

Flame Intensity & Torch Size

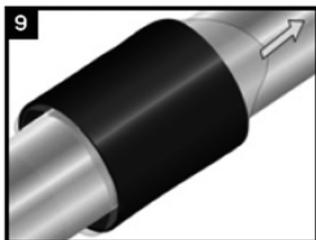


Pre-Heat

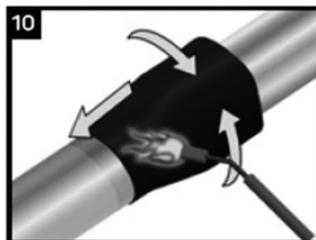


Pre-heat the joint area to a minimum of 65°C (149°F). Using a temperature measuring device, ensure that the correct temperature is reached on the steel and at least 50 mm (2") on each side of the sleeve.

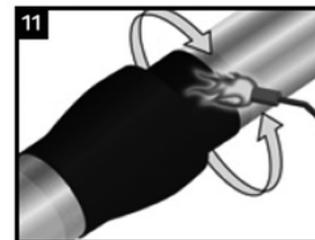
Sleeve Installation



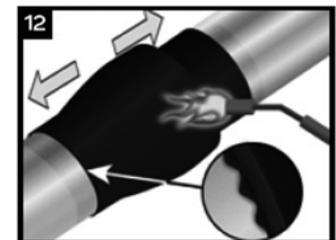
Slide the tube onto the steel joint area, positioning the weld seam at the 12 o'clock position. Centre the tube to ensure a minimum 50 mm (2") overlap onto the pipe coating. Remove the inner release liner.



Using the appropriate sized torch, begin shrinking the larger diameter portion of the joint circumferentially around the pipe. Use broad strokes. Continue heating from the centre toward one end of the sleeve until recovery is complete.



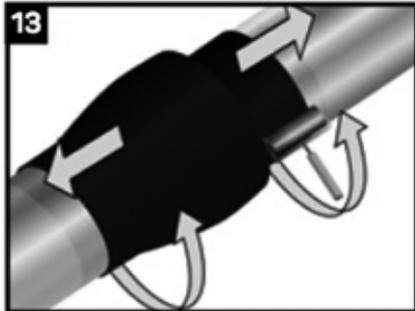
In a similar manner, heat and shrink the smaller diameter side from the centre towards the remaining end until recovery is complete. If necessary, use a gloved hand at the step down to assist recovery and minimize air entrapment.



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 a uniform bond.

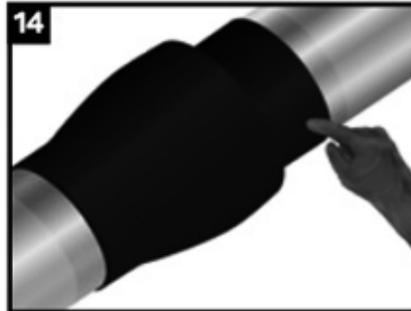
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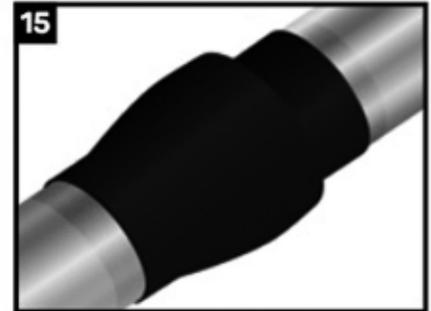
13 While the sleeve is still hot and soft, use a hand roller to firmly roll the sleeve surface and push any trapped air up and out of the sleeve, as shown above. If necessary, reheat to roll out air.

Quality Check (Finger Probe Test)



14 With a gloved hand, press down on the installed sleeve to ensure the backing and sleeve are soft. If there are any cool spots, the sleeve should be reworked with additional heat.

Inspection



15 Visually inspect the installed sleeve for the following:

- Sleeve is in full contact with the steel joint.
- Adhesive flows beyond both sleeve edges.
- No cracks or holes in sleeve backing.
- Weld-seam integrity is maintained.

Backfilling Guidelines

After shrinking is complete, allow the sleeve to cool for 2 hours prior to lowering and backfilling. To prevent damage to the sleeve, use selected backfill material, (no sharp stones or large particles). Otherwise, an extruded polyethylene mesh or other suitable shield should be used.