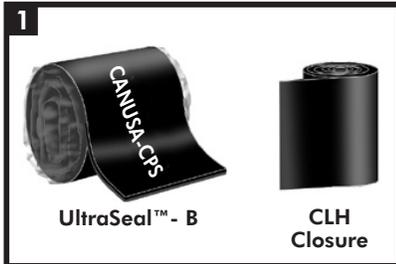


UltraSeal™ - B (Bulk Rolls)

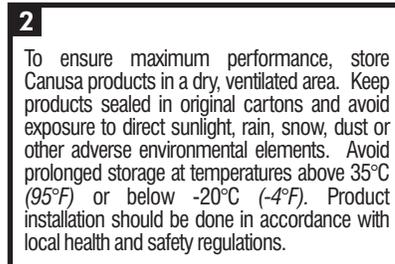
Two-piece bulk roll sleeve with separate closure for pre-insulated pipes

Product Description



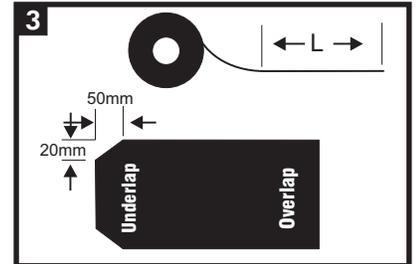
UltraSeal™ - B sleeves are shipped in bulk rolls. Closures are shipped either in bulk rolls or pre-cut. The adhesive is protected from contamination by an inner liner.

Storage & Safety Guidelines



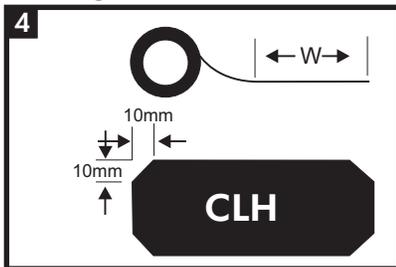
To ensure maximum performance, store Canusa products in a dry, ventilated area. Keep products sealed in original cartons and avoid exposure to direct sunlight, rain, snow, dust or other adverse environmental elements. Avoid prolonged storage at temperatures above 35°C (95°F) or below -20°C (-4°F). Product installation should be done in accordance with local health and safety regulations.

Cutting Sleeve



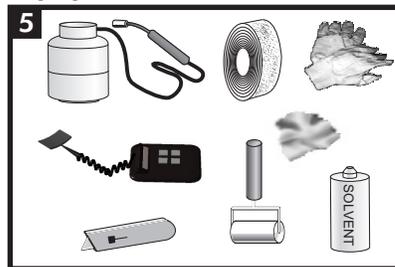
Cut the required length (L) of sleeve material from the bulk roll. **UltraSeal™ - B** (L = circumference of casing + 100 mm) **Corner cuts:** Underlap ~ 20 X 50 mm Ensure that the sleeve is ready for installation, that there is no dirt or moisture on the sleeve and that the sleeve is not damaged.

Cutting Closure



Cut the required length (W) of closure material from the bulk roll. **CLH** (W = sleeve width less 5 mm) **Corner cuts:** All corners (10 X 10 mm) Ensure that the closure seal is ready for installation, that there is no dirt or moisture on the closure seal and that the closure seal is not damaged.

Equipment List

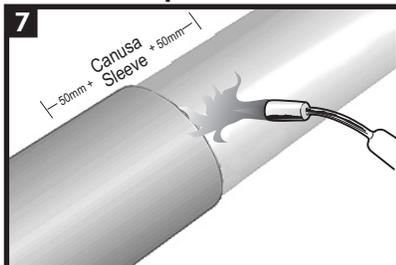


Propane tank, hose, torch & regulator
Appropriate tools for surface abrasion (40-60 grade sandpaper) Knife, roller, rags & approved solvent cleanser Digital thermometer with suitable probe
Standard safety equipment; gloves, goggles, hard hat, etc.

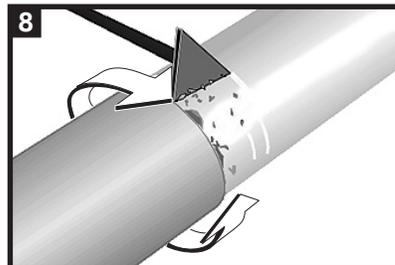
Flame Intensity & Torch Size

<p>Pipe O.D. ≤ 450mm (18")</p> <p>Use moderate to high flame intensity for shrinking.</p> <p>Minimum Torch Size: 150,000 BTU/hr.</p>	<p>Pipe O.D. > 450mm (18")</p> <p>Use moderate to high flame intensity for shrinking.</p> <p>Minimum Torch Size: 300,000 BTU/hr.</p>
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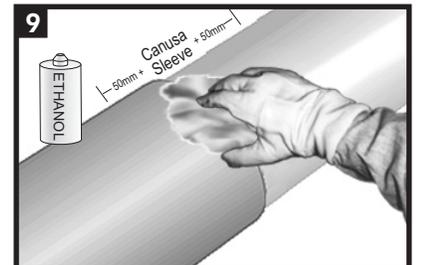
Surface Preparation



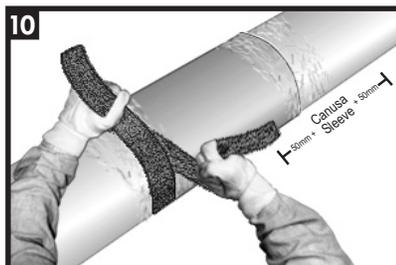
Dry the surface of the casing and jacket pipe (width of sleeve + 50 mm on each side) with the torch. Use high intensity flame for pre-heating. Clean the surface with a dry, grease and lint-free rag to remove any grease or dirt.



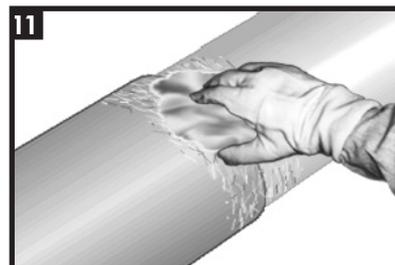
Clean the edges of the casing to remove any sharp corners and burrs, foam and dirt, using a triangular scraper.



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

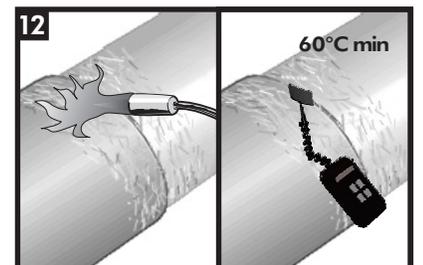


Roughen the surface (width of sleeve + 50 mm on each side) using 40-60 grade sandpaper or a wire brush.



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

Pre-Heat



Using the torch, preheat the surface to be covered with the shrink sleeve (casing+ pipe) to a minimum of 60°C. Check the temperature all around the surface with a temperature stick.

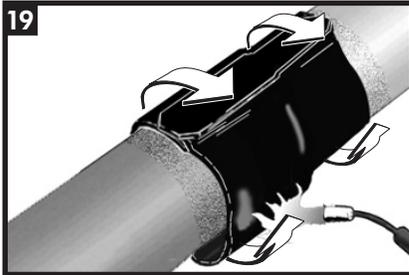
Sleeve Installation



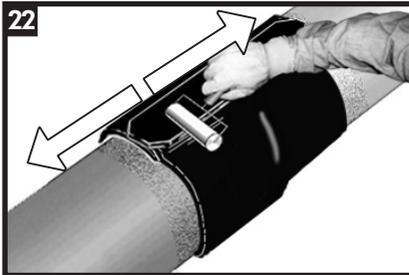
13 Partially remove the release liner from the sleeve (~15 cm from the edge) and gently heat the adhesive along the undertap with a torch.



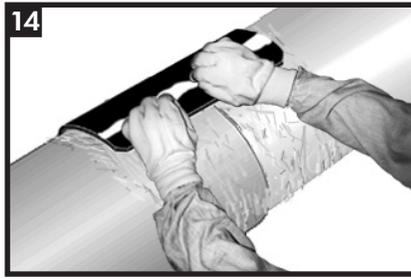
16 Center the closure over the overlap and press it down.



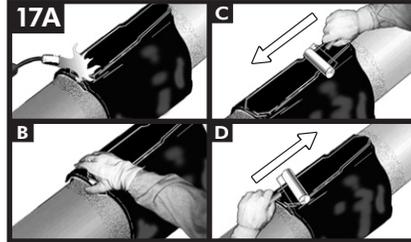
19 Continue heating from the centre toward one end of the sleeve until recovery is complete. In a similar manner, heat and shrink the remaining side.



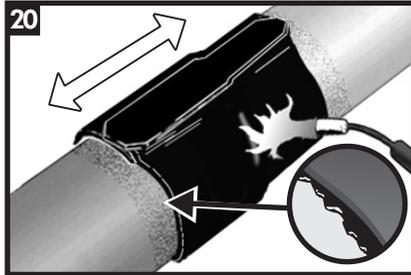
22 Continue the procedure by also firmly rolling the closure with long horizontal strokes from the weld outwards.



14 Centre the sleeve over the area to be sealed (casing pipe/PE pipe) and press the underlap into place. Remove the remaining release liner from the sleeve.

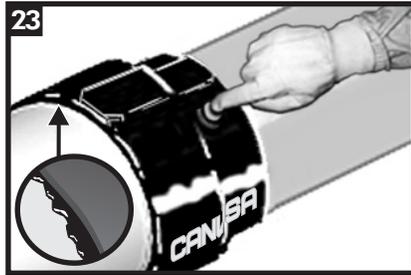


17A Gently heat the closure and pat it down with a gloved hand. Repeating this procedure, move from one side to the other. Smooth any wrinkles by gently working them outward from the centre of the closure with a roller.

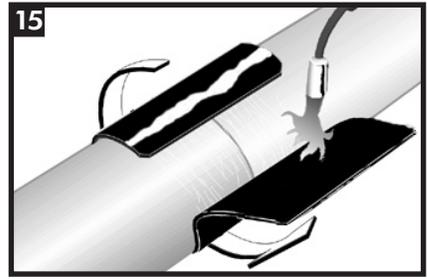


20 Shrinking has been completed when the adhesive begins to ooze at the sleeve edges all around the circumference and backing becomes smooth (indentations disappear). Finish shrinking the sleeve with long horizontal strokes over the entire surface to ensure a uniform bond.

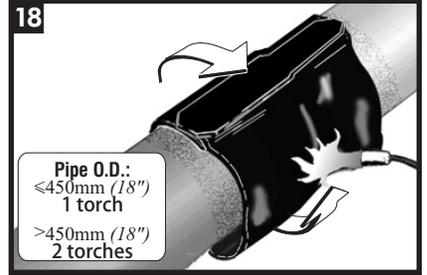
Quality Check



23 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.**

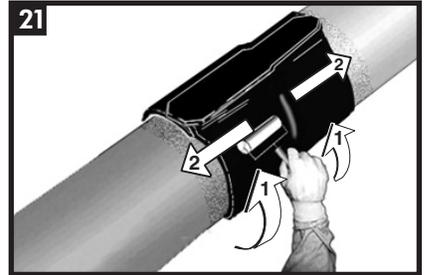


15 Wrap the sleeve loosely around the pipe, ensuring the appropriate overlap. Gently heat the backing of the underlap and the adhesive side of the overlap.

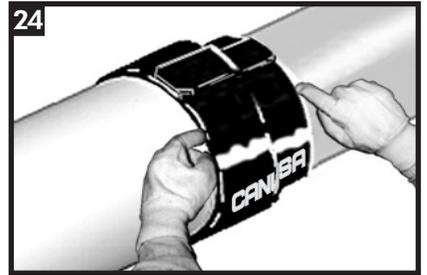


18 Pipe O.D.:
 ≤450mm (18")
 1 torch
 >450mm (18")
 2 torches

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.



21 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.



24 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. The edges of the sleeve should be sunk into the adhesive ooze and should not lift. 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

25 After shrinking the sleeves, they should be left for as much time as possible prior to backfill (min. 30 minutes to 1 hour, depending on ambient temperature). This ensures that the adhesive Ahas cooled enough to reach the required peel and shear strength and that permanent sealing is attained.



A SHAWCOR COMPANY

Canada

CANUSA-CPS
 a division of SHAWCOR LTD.
 25 Bethridge Road
 Toronto, Ontario
 M9W 1M7,
 Canada
 Tel: +1 (416) 743-7111
 Fax: +1 (416) 743-5927

U.S.A./Latin America

CANUSA-CPS
 a division of SHAWCOR INC.
 2408 Timberloch Place
 Building C-8
 The Woodlands, Texas
 77380, U.S.A.
 Tel: +1 (281) 367-8866
 Fax: +1 (281) 367-4304

Europe/Middle East

CANUSA-CPS
 a division of CANUSA SYSTEMS LTD.
 Unit 3, Sterling Park
 Gatwick Road
 Crawley, West Sussex
 England RH10 9QT
 Tel: +44 (1293) 541254
 Fax: +44 (1293) 541777

Asia/Pacific

CANUSA-CPS
 a division of SHAWCOR LTD.
 #05-31, Blk 52, Frontier
 Ubi Avenue 3
 Singapore
 408867
 Tel: +65-6749-8918
 Fax: +65-6749-8919

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