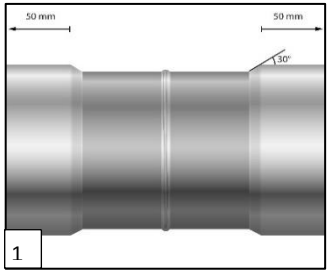
Application manual
Kebulen-Heat shrinkable sleeve C50

With indicator and loose closure



1

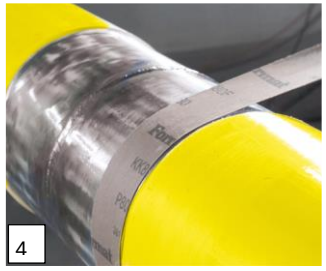
Bevel edges to a 30° angle using a rasp with a semicircular blade.

2

The pipe surface has to be free of grease, oil, solvents, coupling agents, etc. Clean pipe surface e.g., with hand wire brush or sand blasting from rust, dirt and other residues.

3

Roughen each 100 mm of the adjacent factory coating, e.g., with abrasive cloth, and chamfer the edges of the factory coating.


4

Roughening of the pipe surface for roughness 50-100 µm by sandblasting according to standard cleanliness grade Sa 2 ½ or by means of abrasive cloth (K60-80). Do not remove hard adhesive and the epoxy resin layer on steel pipes supplied from the factory, whereby the EP resin and hard adhesive must be roughened.

5

Remove dust residues preferably by blowing off or sweep off with a broom.

6

Preheat the pipe surface and the adjacent factory coating to 50 °C.

7

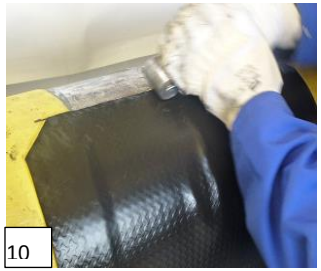
Measure the surface temperature with an appropriate temperature probe.

8

Remove the release film from the beveled end over the entire width and in a length of approx. 300 mm. Heat the adhesive of the sleeve if necessary..

9

Place the sleeve on the pipe with min. 50 mm overlap (see Figure 1).


10

Roll the sleeve with a seam roller.

11

Completely remove the separating foil from the sleeve.

12

Wrap the shrinkable sleeve thight around the pipe. Align and heat adhesive with blue-yellow flame.

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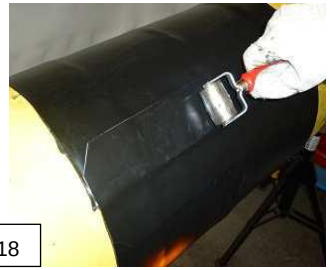
Close the shrinkable sleeve with an min overlapping of 80 mm.

Roll up the overlapping area.

Heat the adhesive side of the closure from one side with the gas flame. Place the heated side centrally on the overlap of the shrinkable sleeve.

Heat adhesive side further and place over the entire cuff width in the area of the overlap. Work from the inside out with the seam roller to prevent air pockets.

Heat the outside of the closure and press it on.



Roll the closure flap in the overlap area from the inside to the outside.

Starting at the bottom, heat the shrinkable sleeve in the center in the circumferential direction with a blue-yellow flame and shrink it. Starting from the center, shrink in the circumferential direction to one side as far as the edge. After completion, start shrinking again from the center in the other direction to the edge.

The shrinking process is finished when the cuff with indicator is tight all over and appears smooth and the thermal indicator can no longer be felt.

Press on the transition to the factory coating, the edge of the sleeve, the overlap of the sleeve and the weld seam area with a seam roller*.

* For shrinkable sleeves with a total thickness of more than 2.5 mm, roll vigorously with the seam roller in the overlap area of the cuffs to avoid channel formation.

Attention: Our coating systems are not suitable for sealing leaks in media-carrying pipelines, but exclusively for prevention and protection against corrosion!

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