



# DEKOTEC®-HTS

### 1. Preparation

- All application steps have to be performed with proper personal protection equipment, such as safety shoes, helmet, safety goggles and heat protection gloves, in accordance with local health and safety regulations. A personal application training is strongly recommend for people who are new to the application of heat shrink sleeves!
- Adjacent factory coating must be roughened (e.g. emery cloth #40) and beveled with an angle  $\leq 30^\circ$ .
- For pipe diameters > 400mm (16") two applicators are recommended.
- Required surface cleanliness:** Surface has to be dry, free of grease, oil, dust and other dirt before blast cleaning to a minimum of SA 2½ according to ISO 8501-1. Blast cleaned surfaces have to be protected against the influences of dust and moisture.

### 2. Cleaning

- Use clean gloves and a lint-free cloth to ensure a clean surface for an optimal application.  
**Never touch the blast cleaned surface with bare hands!**

### 3. Preheating of joint area

+50°C (+122°F) with Primer    +90°C (+194°F) without Primer

- Pre-heat the joint area uniformly (steel and adjacent mill coating) to +50°C (+122°F) before the application of DEKOTEC®-EP Primer. If no DEKOTEC®-EP Primer is used, directly heat the surface to +90°C (+194°F). Preheating is performed with a high intensity flame.

### 4. DEKOTEC®-EP Primer application

**Optional**

- Mix DEKOTEC®-EP Primer components A and B in the ratio 2:1 (by volume) and stir for 1 minute.
- Apply a thin and even layer of DEKOTEC®-EP Primer on the surface of the total joint area (steel and adjacent mill coating) with the rough (black) side of a sponge.

### 5. DEKOTEC®-EP Primer Curing

**Optional**

+90 to +110°C    +194 to +230°F

- Cure DEKOTEC®-EP Primer with a high intensity flame until a surface temperature of +90°C to +110°C (+194°F to +230°F) is reached.
- Curing is completed when DEKOTEC®-EP Primer is "touch dry".

### 6. DEKOTEC®-HTS Sleeve Installation Step 1

- Heat the adhesive side of the sleeve with the 45° edges on a length of app. 200 mm (8").
- When using masterrolls, cut the sleeve to the appropriate length (see table) and cut the edges in a 45° angle.

### 7. DEKOTEC®-HTS Sleeve Installation Step 2

- Press DEKOTEC®-HTS to the pre-heated surface in a 2 o'clock position so that the centre marking on the sleeve is positioned over the pipe weld.
- Use a roller to remove the enclosed air, as indicated in the picture.

### 8. DEKOTEC®-HTS Sleeve Installation Step 3

100 mm (4")

- Heat the adhesive side of the loose end of the DEKOTEC®-HTS shrink sleeve gently on a length of 100 mm (4").
- Firmly press the loose end of the sleeve to the surface of the already installed end, so that the centre marking of sleeve is overlaid. The overlap should be app. 100 mm (4").

### 9. DEKOTEC®-CLP Closure Patch application

- Heat the adhesive (silver) side of DEKOTEC®-CLP closure patch until the surface becomes shiny.
- Apply the CLP in the overlapping area of the heat shrink sleeve, so that the centre markings are overlaid, and press it firmly to the surface.  
**Avoid to stretch the CLP.**

### 10. DEKOTEC®-HTS Sleeve Installation Shrinking

DN >400  
2 torches!

- Use a torch flame with medium intensity to shrink the DEKOTEC®-HTS sleeve.
- Heat the DEKOTEC®-HTS sleeve starting from the centre to its edges circumferentially around the pipe, using constant and round movements.
- For pipe diameters > 400 mm (16") use two torches on opposite sides.

### 11. DEKOTEC®-HTS Sleeve Installation Postheating

- Heat the complete DEKOTEC®-HTS heat shrink sleeve homogeneously with a high intensity flame.
- The imprinting "DEKOTEC" vanishes when the sleeve was heated sufficiently.
- The adhesive has to be visible on both sides of the sleeve around the circumference.

### 12. DEKOTEC®-HTS Sleeve Installation Smoothing

- Use a roll to remove entrapped air. First roll circumferentially to the overlap area of the shrink sleeve.
- In the overlap area start rolling from the middle to the outer side. Use a zig-zag movement of the roll to drive the air bubbles.

### 13. DEKOTEC®-HTS Installation Cool down time

2h

- After application wait for at least 2 hours to let the shrink sleeve cool down to ambient temperatures before burying the pipe.

| PIPE DIAMETER |      | Length of Shrink Sleeve | Consumption DEKOTEC®-EP Primer |              | Length DEKOTEC®-CLP |
|---------------|------|-------------------------|--------------------------------|--------------|---------------------|
| DN (mm)       | inch |                         | Comp. A (ml)                   | Comp. B (ml) |                     |
| 75            | 3"   | 425                     | 32                             | 16           | 75                  |
| 100           | 4"   | 510                     | 35                             | 17,5         | 100                 |
| 150           | 6"   | 685                     | 43                             | 21,5         | 100                 |
| 200           | 8"   | 850                     | 50                             | 25           | 100                 |
| 300           | 12"  | 1195                    | 65                             | 32,5         | 150                 |
| 400           | 16"  | 1465                    | 76                             | 38           | 150                 |
| 500           | 20"  | 1800                    | 90                             | 45           | 150                 |
| 600           | 24"  | 2135                    | 105                            | 52,5         | 200                 |
| 700           | 28"  | 2470                    | 120                            | 60           | 200                 |
| 800           | 32"  | 2800                    | 134                            | 67           | 200                 |
| 900           | 36"  | 3135                    | 150                            | 75           | 200                 |
| 1000          | 40"  | 3470                    | 163                            | 81,5         | 200                 |
| 1200          | 48"  | 4135                    | 192                            | 96           | 200                 |
| 1400          | 56"  | 4805                    | 220                            | 110          | 200                 |