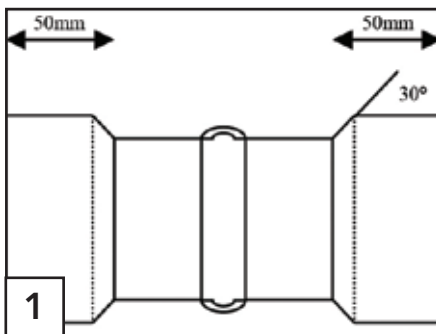


**INSTRUCTIONS FOR USE****HSS 50 ST™****APPLICATION**

The Premier HSS 50 ST™ Heat Shrink Sleeve with indicator with separate closure patch is a warm applied shrinkable wrap-around sleeve. It is used for the protection of welded seams on buried or above ground pipelines and can be applied on-site. After surface preparation of the area to be wrapped to ISO 8501-1 St2-St3, the use of a primer is not necessary.

**REQUIRED MATERIALS AND EQUIPMENT**

- Premier HSS 50 ST™ Heat Shrink Sleeve
- Closure patch
- Wire brush
- Propane torch
- Working gloves
- Brush
- Rasp with semicircular blade
- Roller



1 Ensure the Heat Shrink Sleeve is wide enough to overlap the factory coating by 50 mm minimum. Bevel the edges of the factory coating with a rasp with semi-circular blade to an angle of 30°.



2 Preheat the pipe to remove moisture, if necessary. Clean the pipe surface thoroughly to very thoroughly (St 2 - St 3) with a hand wire brush. Remove rust, dirt and other residues.



3 Abrade the adjacent factory coating (including the beveled edges) 100 mm on both sides of the joint.



4 The surface of the steel and adjacent coating shall be free from grease, oil, and dust. If solvent cleaning is required this shall be carried out according to Steel Structure Painting Council SSPC SP 1 using approved solvent.



5 Dry the pipe and warm the area where the sleeve will overlap itself (exposed pipe plus adjacent factory coating) to 50°C.



6 Measure the preheating temperature with an appropriate temperature sensor.

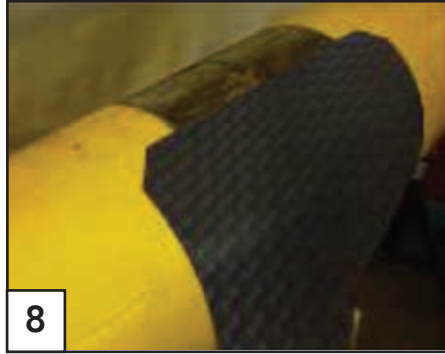
# INSTRUCTIONS FOR USE



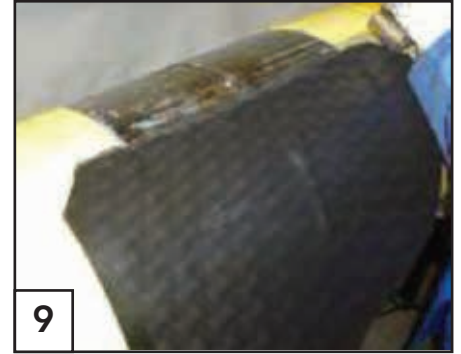
## HSS 50 ST™



Remove approx 300 mm of the release film from the whole width of the mitred end of the sleeve. Warm up the butyl rubber using the Propane torch.



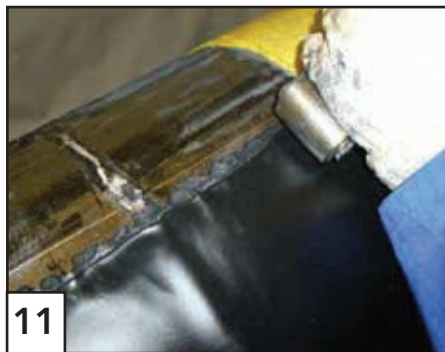
Place the sleeve on the preheated area of the pipe.



Roller the underlap with a roller.



Heat the applied end of the sleeve with a blue-yellow flame, so that a 20 cm portion of the sleeve sticks to the pipe.



Roll on the edges of the end of the sleeve with a roller until butyl rubber flows out of the sides.



Remove the release film completely from the remainder of the sleeve.



Wrap the sleeve around the pipe tightly. Position it carefully and warm up the butyl rubber with a blue-yellow flame.



Stick the sleeve all the way around the pipe overlapping onto the underlap. Warm the overlapping area.



Roller the overlapping area.

# INSTRUCTIONS FOR USE



## HSS 50 ST™



16 A bead of extruded butyl rubber is visible at the edge of the sleeve.



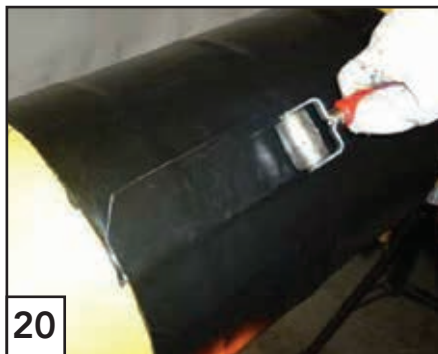
17 Warm one end of the adhesive side of the closure patch with a gas flame. Position the warmed side of the closure patch over the exposed edge of the sleeve.



18 Progressively warm along the length of the closure patch and press it on until butyl adhesive is visible out of the side.



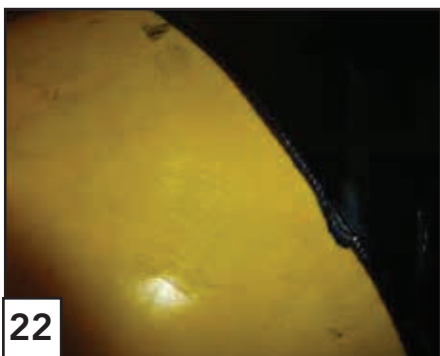
19 Continue warming the adhesive side of the closure patch and position it over the whole sleeve width in the overlapping area.



20 Roller the closure patch in the overlapping area. Let the installed closure patch cool down before continuing with application.



21 Beginning below, heat the middle of the sleeve, moving the torch in a circumferential direction with blue-yellow flame. Use the same motion to shrink one side, then the other side. Ensure even shrinkage.



22 When sufficient temperature is reached, the texture on the sleeve will become smooth. The shrinking procedure is finished when the sleeve is tightly fitting everywhere and appears smooth.



23 Roller the transition to the factory coating, the edge of the sleeve, the overlap of the sleeve and the area of the welded seam.



# HEAT SHRINK SLEEVE SYSTEM

## INSTRUCTIONS FOR USE



# HSS 50 ST™

### HEALTH & SAFETY

These application instructions do not constitute a risk assessment. We recommend that installation is carried out with due regard to Health and Safety and in accordance with relevant local statutes and regulations. Safety Data Sheets are available on request.

### STORAGE

- Store correct way up in original packaging.
- Store away from heat and open flames.
- Do not store in direct sunlight.
- Store in a ventilated area.
- Temperatures should be 5°C and 35°C.
- Do not stack pallets.

### DISPOSAL

Please minimise or avoid waste wherever possible. Please do not discard waste material, including packaging, in the surrounding environment. Follow all relevant legislation for disposal.

**IMPORTANT:** Premier Coatings Ltd pursue a policy to develop and continually improve all of our products and therefore information given in this data sheet is intended as a general guide and does not constitute a warranty or specification. However, our sales personnel are committed to assisting the user in establishing the suitability of the product for its intended purpose and additional specific information is available on request. These Instructions may not cover all circumstances and must be read in conjunction with the project specifications. For further advice contact Premier Coatings Ltd.



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