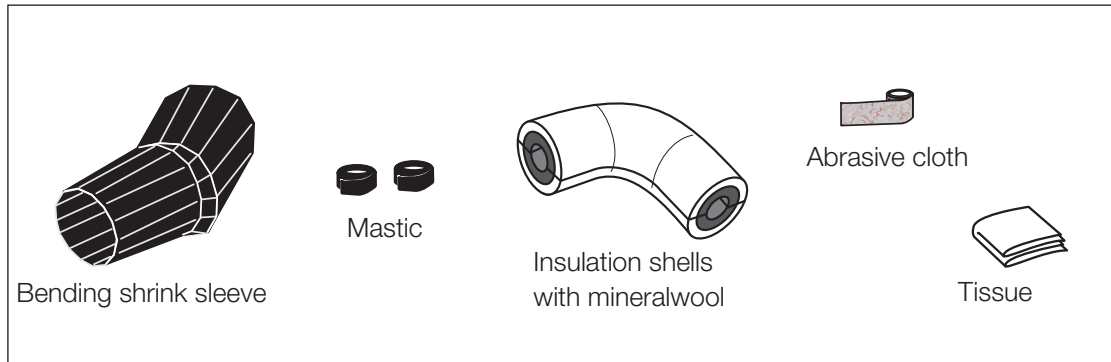


HBM

High temperature elbow joint, single sealed

Fitting Instructions 1/3

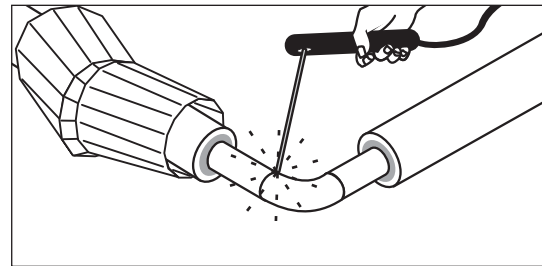


Important:

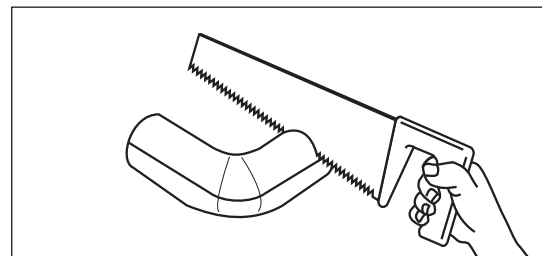
It is only necessary to pull the sleeve if shrinking across the centre has been carried out too quickly. Fig. 10.

Never apply heat to creases, if any, since the sleeve material will be discoloured and the surface will crack.

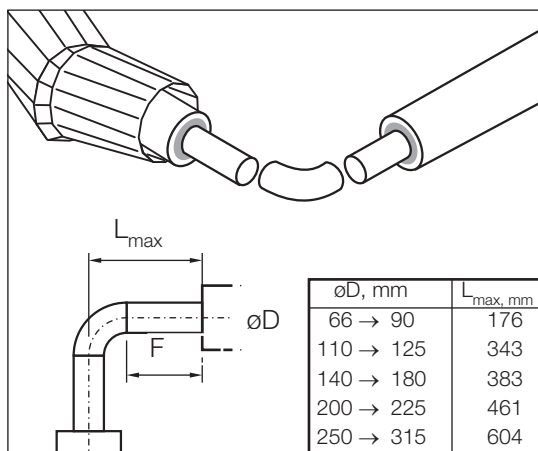
Never apply heat underneath the sleeve at the ends, since this may damage the sleeve permanently. Pockets of air under the sleeve can be removed by bending a piece of welding wire into U-shape and pushing it underneath the sleeve while it is still warm. Use burner head dia. 51 mm for sleeves up to dia. 200 mm. For larger sleeves use burner head dia. 63 mm.



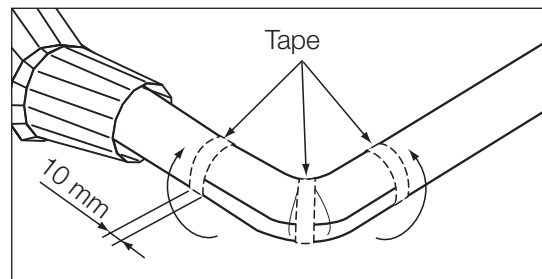
2. Weld the steel pipes. Pressure test.



3. Cut the insulation shells to make them fit over the steel pipes.



1. Place the two pipe ends at the correct angle. Pull the shrink sleeve onto the pipe (F = max. 150 mm).



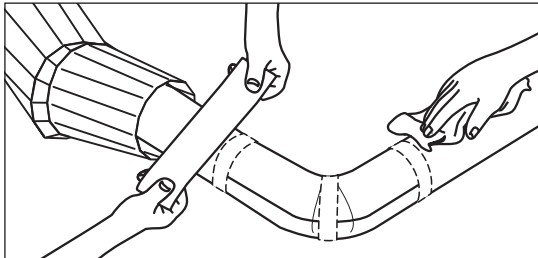
4. Fasten the insulation shells with tape. The tape overlap on the jacket is max. 10 mm.

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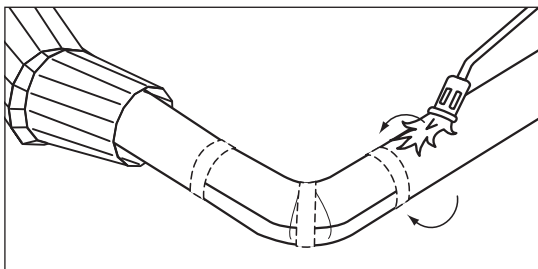
High temperature elbow joint, single sealed

Fitting Instructions

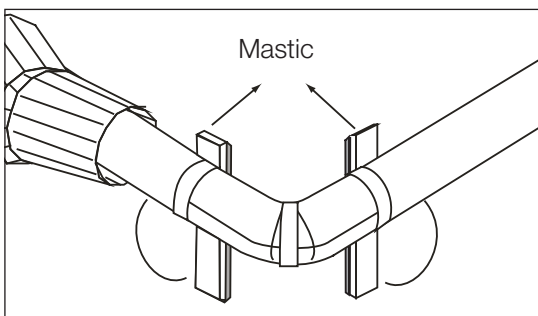
2/3



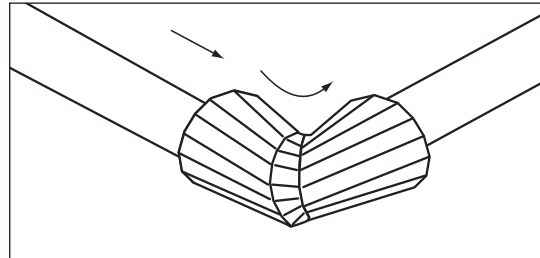
5. Clean the jacket with tissue. Activate the jacket pipes with ABRASIVE CLOTH at least 80 mm from both jacket ends. Use ABRASIVE CLOTH to remove sharp edges or burrs on the jacket pipes.



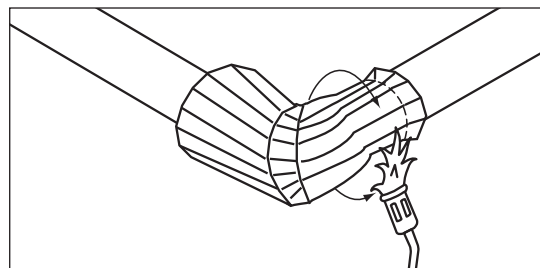
6. Activate the jacket pipes at least 150 mm from both jacket ends until the surface has a matt, silky look.



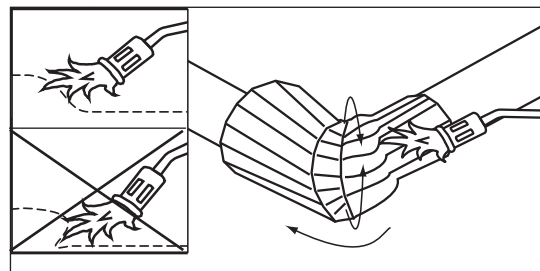
7. Pull the paper off the adhesive side of the mastic strip. Place the adhesive side face down on the jacket pipe furthest from the insulation shells.



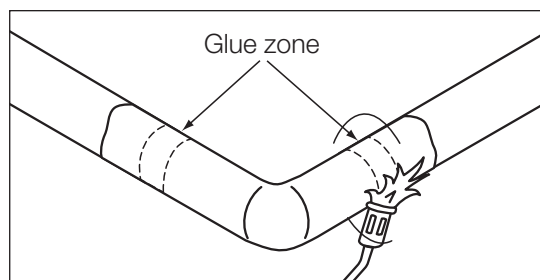
8. Remove the packing from the shrink sleeve. Check that it is CLEAN and DRY, inside and out. Centre the shrink sleeve on the elbow.



9. Start shrinking at the top of the shrink sleeve 5-8 cm from the end. During shrinking it is possible to adjust the position of the shrink sleeve.



10. Shrink from one end towards the other. Continue moving the flame until all expansion marks have vanished.



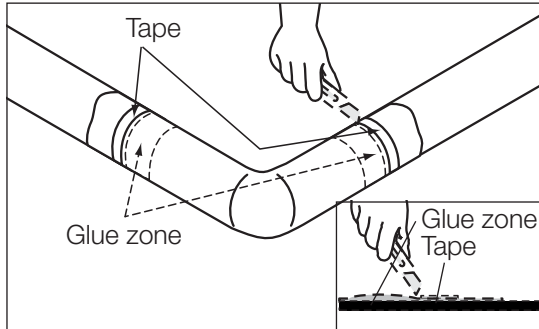
11. Supply extra heat to the glue zone to ensure correct adhesion.

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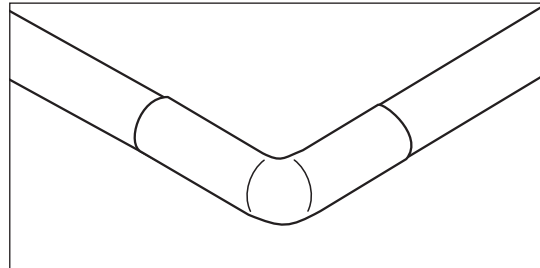
High temperature elbow joint, single sealed

Fitting Instructions

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12. Wind the tape around the sleeve, where the glue zone is weakly marked. Use a very sharp knife to cut along the edge of the tape while the item is still hand-warm.



13. The joint is now complete.