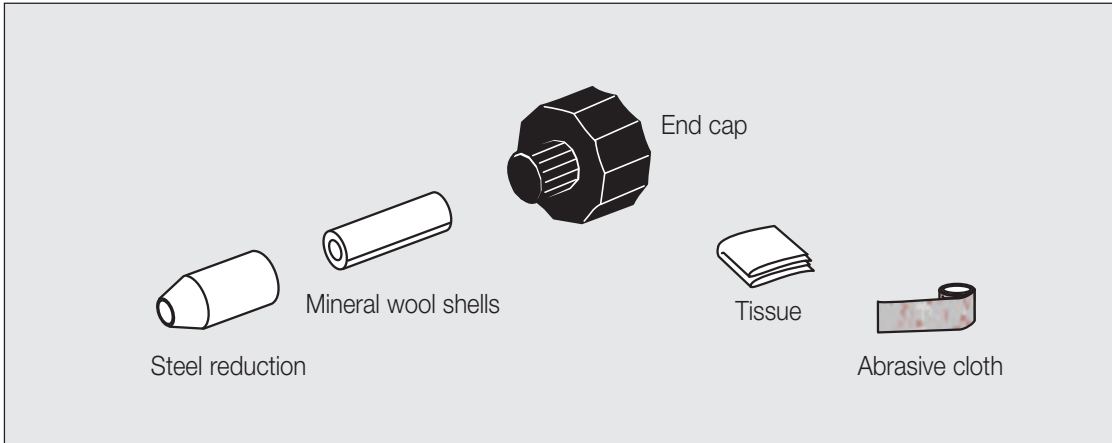


HDHEC

High temperature end cap

Fitting Instructions 1/3



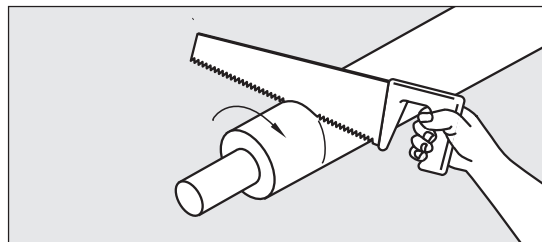
Important:

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

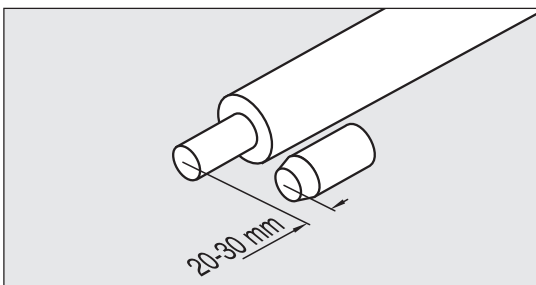
Never apply heat underneath the end cap, as this may damage the end cap permanently.

Pockets of air under the end cap can be removed by bending a piece of welding wire into U-shape and pushing it underneath the end cap while it is still warm.

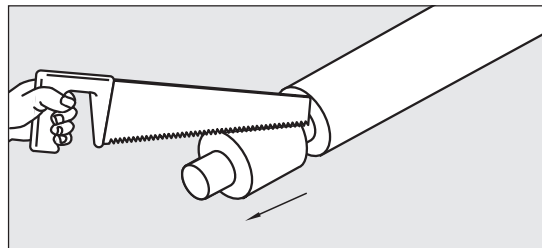
Use burner head dia. 51 mm for all dimensions.



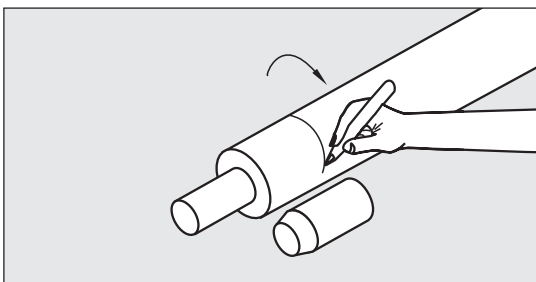
3. Cut the jacket and insulation using the marks as a guide.



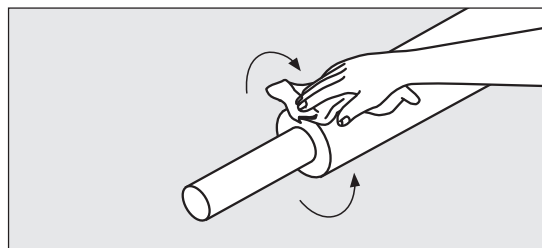
1. Place the steel reduction 20-30 mm from the steel pipe end.



4. Cut lengthwise through the jacket and remove jacket and insulation material.



2. Mark the length of the steel reduction on the jacket.



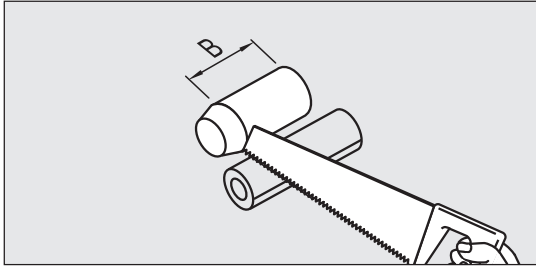
5. Clean all surfaces in the mounting area.

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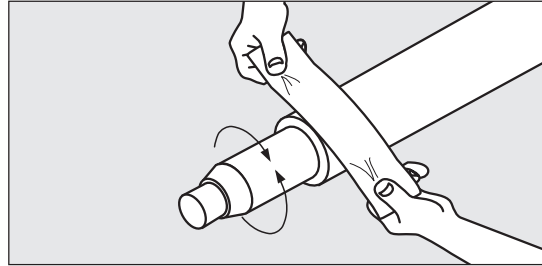
High temperature end cap

Fitting Instructions

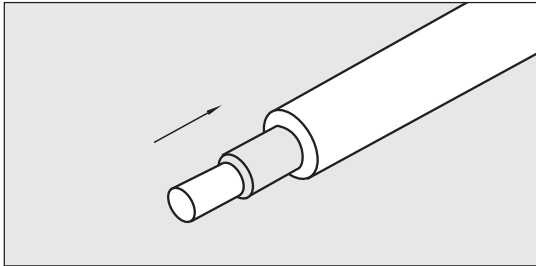
2/3



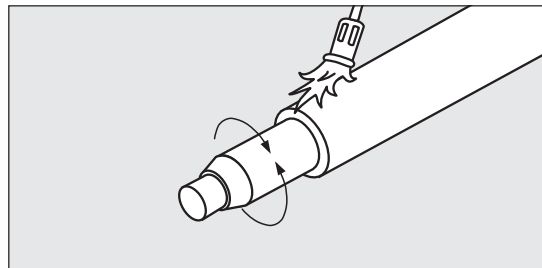
6. Adjust the mineral wool shells to the length (B) of the steel reduction.



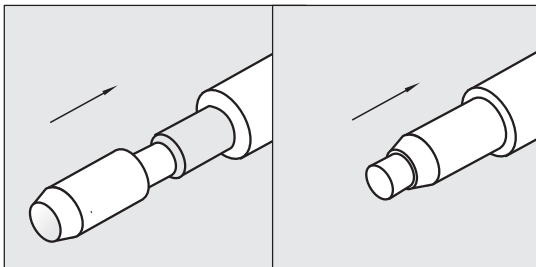
10. Activate the steel reduction and the jacket pipe with abrasive cloth grain size 80 at least 60 mm from the end of the jacket pipe.



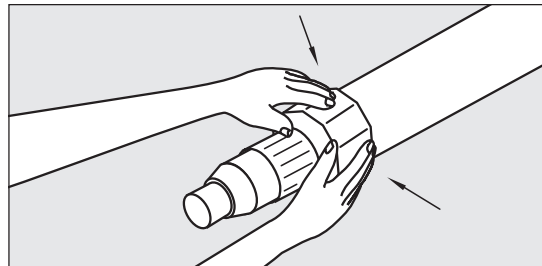
7. Place the mineral wool shells on the carrier pipe as close to the PUR insulation as possible.



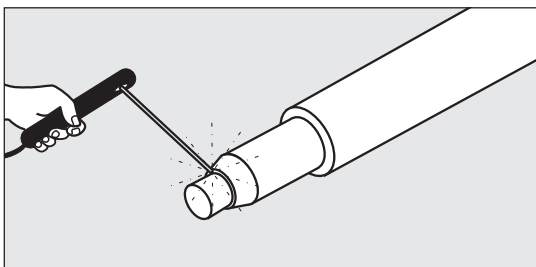
11. Activate the steel reduction and the jacket with gas burner at least 60 mm from the end of the jacket pipe until the jacket surface has a matt, silky look.



8. Pull the steel reduction onto the carrier pipe and the mineral wool shells. The steel reduction is placed correctly when it is in contact with the PUR insulation.



12. Remove the foil inside the end cap. Check that it is CLEAN and DRY, inside and out. Pull the end cap onto the steel reduction and jacket.



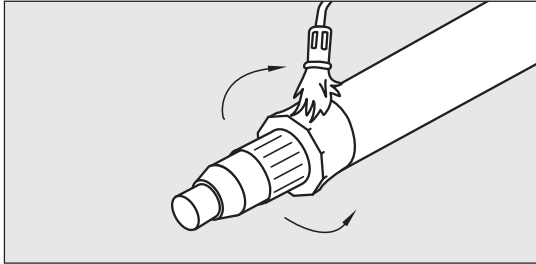
9. Weld the steel reduction to the carrier pipe. The welding has to be tightly.

HDHEC

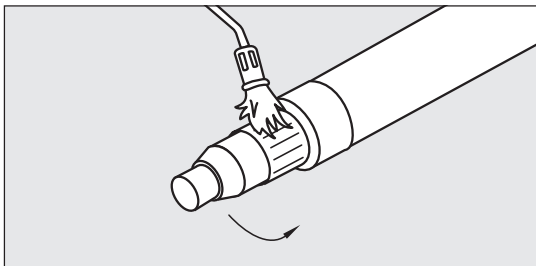
High temperature end cap

Fitting Instructions

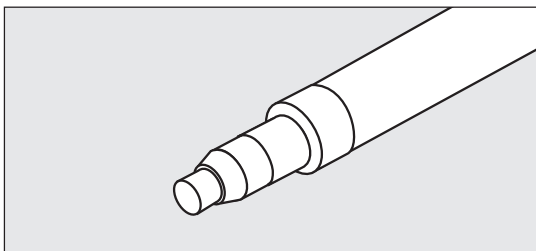
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13. Start shrinking the end cap onto the jacket pipe only. DO NOT YET shrink the edge of the end cap nor the end surface onto the jacket pipe. The flame must be held at a right angle to the pipe surface.



14. After a pause of approx. 3 min. shrink the end cap onto the steel reduction and at the same time the edge of the end cap and the end surface onto the jacket pipe. The flame must be held at a right angle to the pipe surface.



15. The end cap is complete when the sealing becomes visible on the steel reduction and the end cap is smooth.