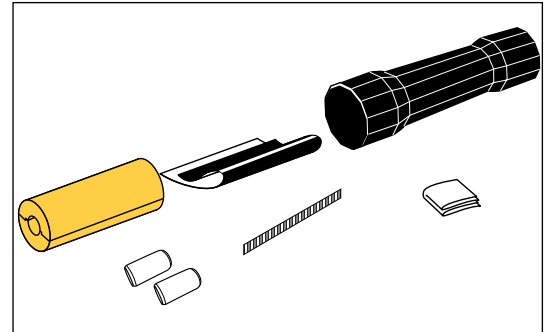


Installing straight joints for SafePipe BXJoints

Application

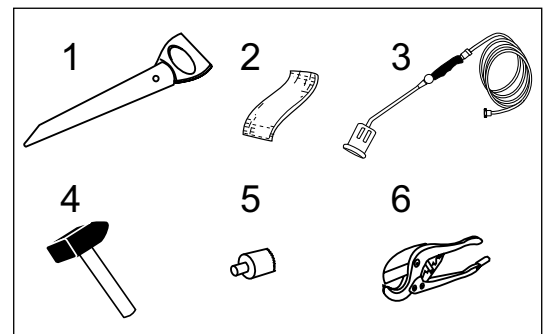
BXJoints are used to join pipes with outer casing dimensions \varnothing 90-630 mm.



Tools

It is recommended to use the following tools when installing BXJoints:

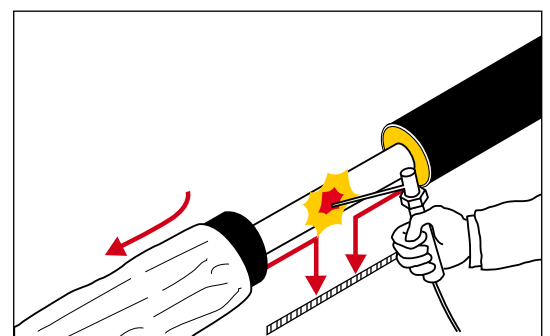
Type:	Application:
1. Saw	Adjusting insulation shells
2. Emery cloth	Surface activation
3. Gas burner, \varnothing 50 mm	Surface activation, Shrinking film and sleeve.
4. Hammer	Installing pipe coupling
5. Spoon bit \varnothing 29 mm	Pre-drilling around perforated plastic tubes
6. Plastic tube cutter	Shortening the tracer pipe



Preinstallation of casing joint

1. Place the shrink sleeve with packing on one of the pipes, before the service pipes are joined.

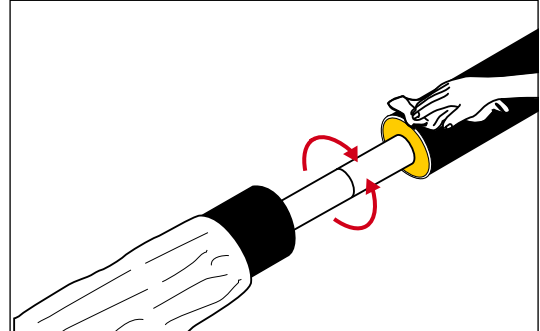
Notice! Align the pipes with the tracer pipe in 6 o'clock position to facilitate later installation of the tracer pipe.



Installing straight joints for SafePipe BXJoints

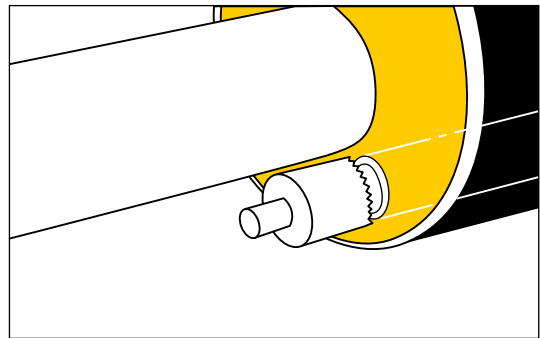
Cleaning

2. Clean all surfaces in the mounting area.



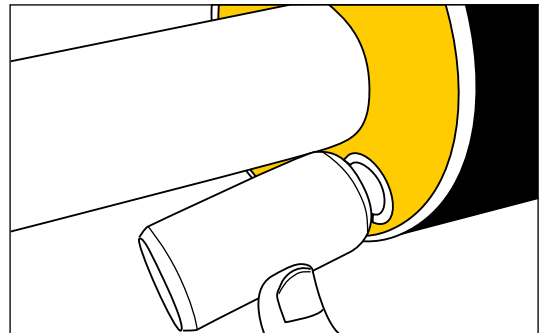
Pre-drilling

3. Before hammering the \varnothing 25 mm pipe coupling into the foam it is recommended to pre-drill around the perforated plastic tube embedded in the foam with a spoon bit.



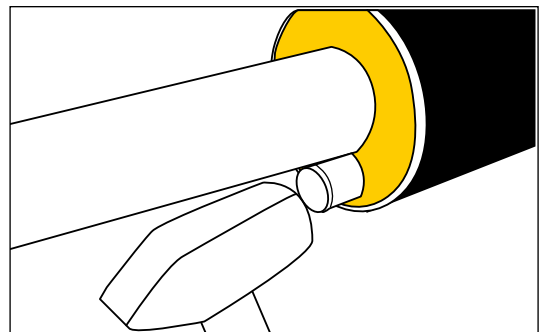
Installing the pipe coupling

4. Place the pipe coupling against the tube in the foam.



5. Hammer the coupling approx. 25-30 mm into the foam.
It is recommended to use a plastic-covered, recoilless hammer.

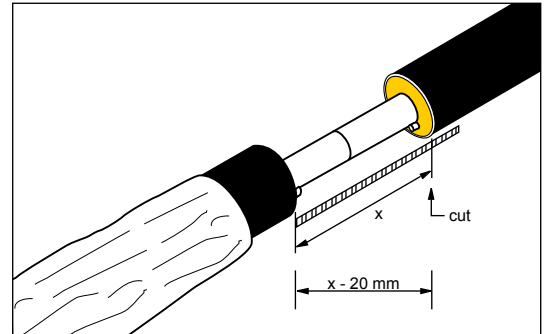
Repeat items 3-5 at the opposite pipe end.



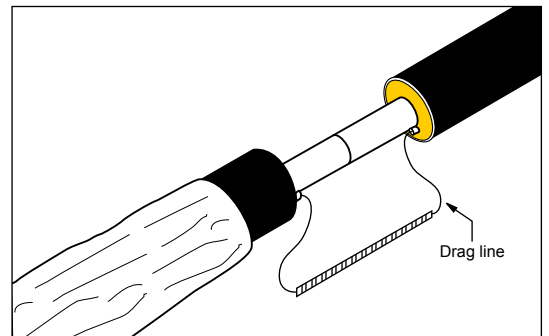
Installing straight joints for SafePipe BXJoints

Installing the tracer pipe

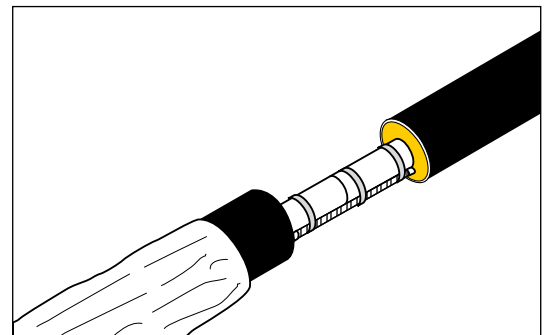
6. Measure the distance x and adjust the length of the tracer pipe to $x - 20$ mm.



7. Pull the drag line through the tracer pipe.

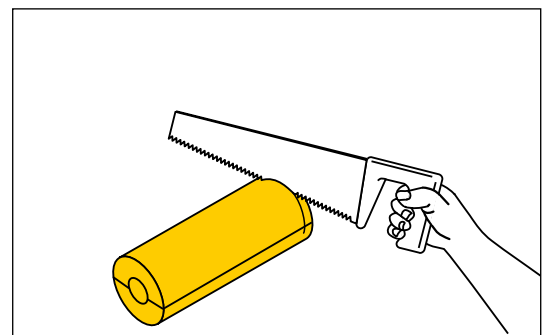


8. Insert the tracer pipe into the pipe couplings at each pipe end and secure it to the service pipe with tape.



Adjusting insula- tion shells

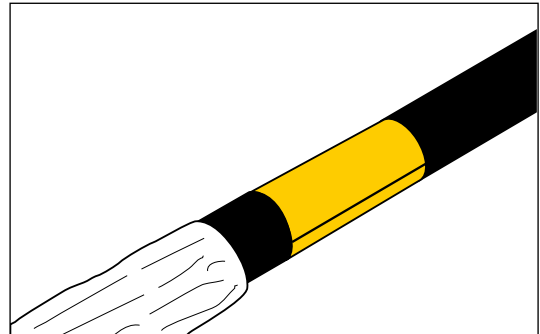
9. Shorten the insulation shells to make them fit tightly between the casing pipes.



Installing straight joints for SafePipe BXJoints

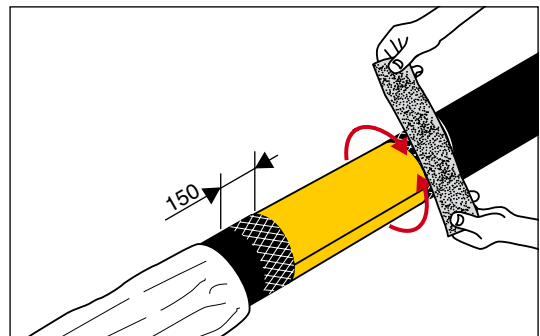
Adjusting insula- tion shells, *continued*

10. Fit the insulation shells tightly between the casing pipes, using adhesive tape if required. All surfaces must be CLEAN and DRY.

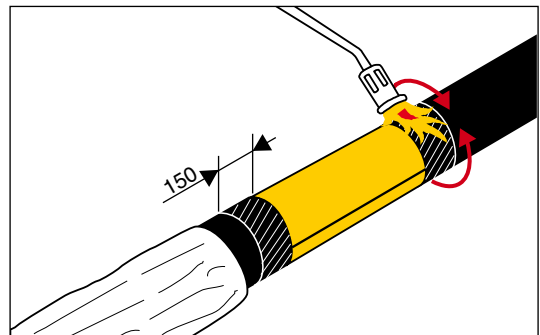


Activation

11. Activate the casing pipes with emery cloth grain size 60 at least 150 mm from both casing ends.

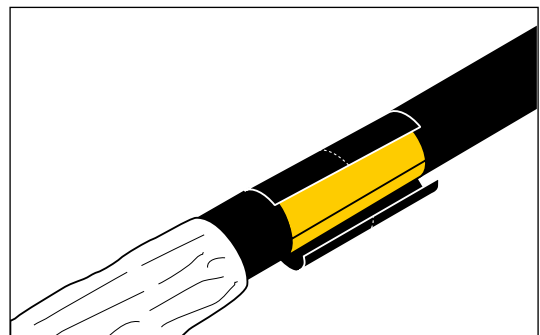


12. Activate the casing pipes with gas burner at least 150 mm from both casing ends, until the surface has a matt, silky look.



Installing shrink film

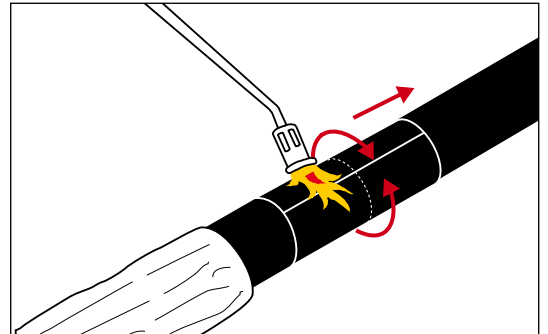
13. Place the shrink film so that the marking line forms a ring around the pipe. Attach one edge of the shrink film in the "10 o'clock" position.
14. Pull the film around the pipe by removing the adhesive paper so that the film adheres to the surface beneath it.



Installing straight joints for SafePipe BXJoints

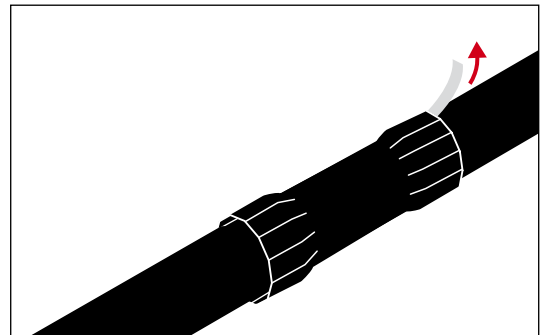
Installing shrink film, continued

15. Heat the whole film from the centre towards the sides, ensuring that the mastic becomes visible at all edges and that the shrink film is tightly fitted.



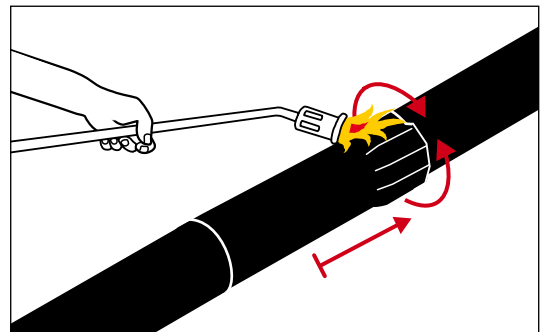
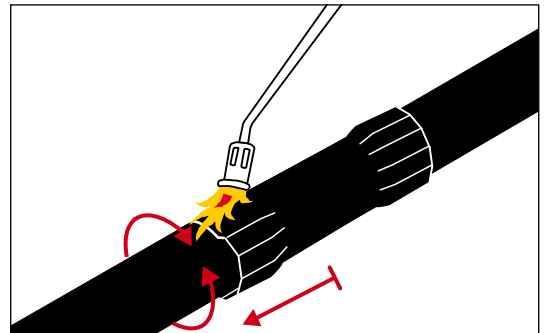
Positioning shrink sleeve

16. Remove the packing from the shrink sleeve. Check that the sleeve is CLEAN and DRY, inside and out. Remove the protective foil from the mastic.
17. Centre the shrink sleeve on the joint and mark it. Remove the mastic covering and make sure that all the foil has been removed.



Shrinkage

18. First, shrink from the middle towards one end, then from the middle towards the other end. Avoid heating directly on the casing.

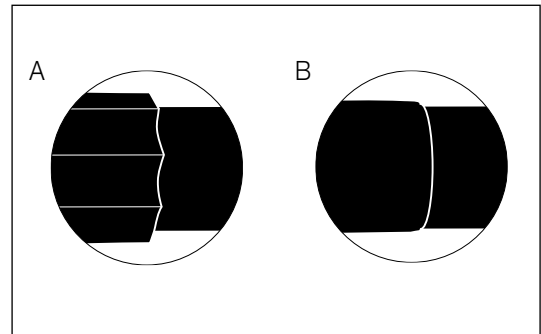


Installing straight joints for SafePipe BXJoints

Shrinkage, *continued*

19. Shrink until all expansion marks have vanished and the end of the sleeve forms an almost straight encircling edge.

- A. Before
- B. After



Completed joint

20. The joint is complete.

