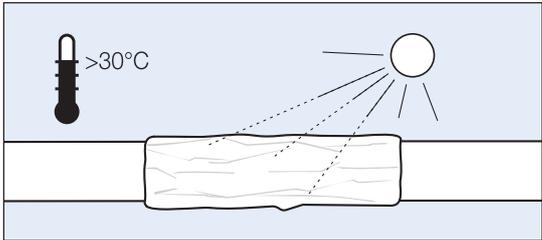
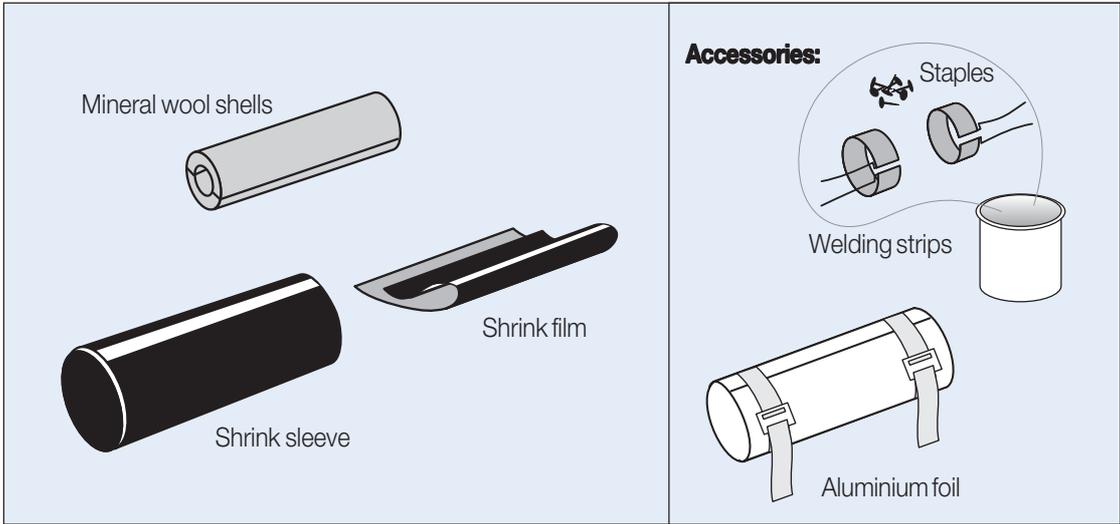


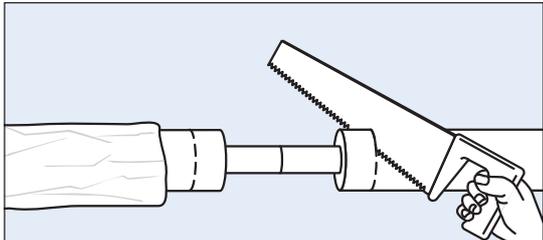
HEW

High temperature joint for foaming

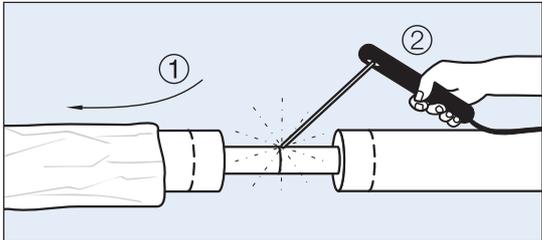
HT3 installation 5.4.2 - 1/4



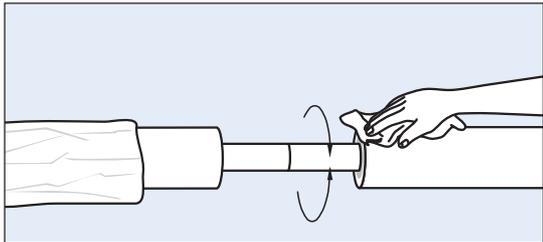
If the surrounding temperature is $>30^{\circ}$ or the shrinking sleeve is exposed to sunlight, the wrapping foil must remain on the pipeline until the shrinking sleeve has been shrunk. The shrink sleeve must be covered up with wrapping foil when it is not being processed.



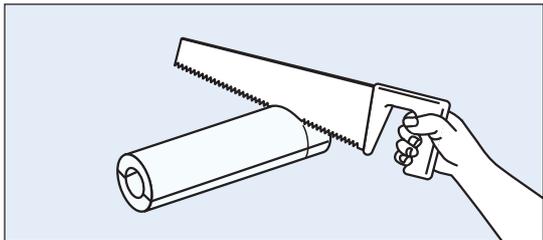
2. Cut the jacket pipes at the markings.



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



3. Clean all surfaces in the mounting area.



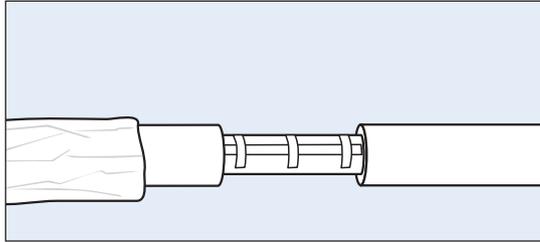
4. Shorten the mineral wool shells to make them fit tightly between the jacket pipes.

HEW

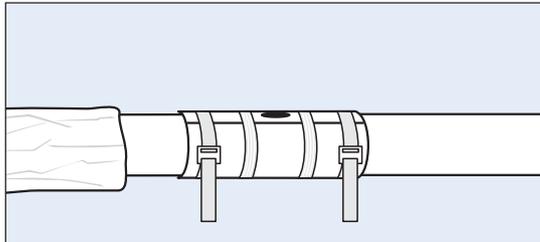
High temperature joint for foaming

HT3 installation

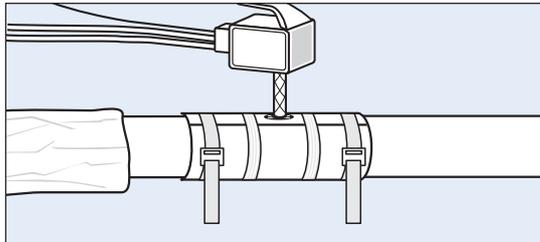
5.4.2 - 2/4



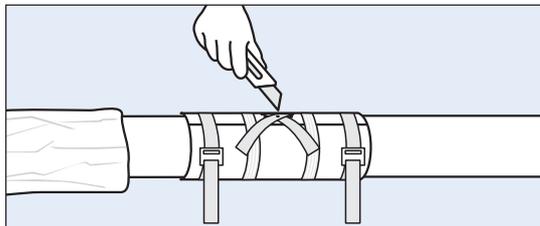
5. Fit the mineral wool shells tightly between the jacket pipes, using canvas tape if required.



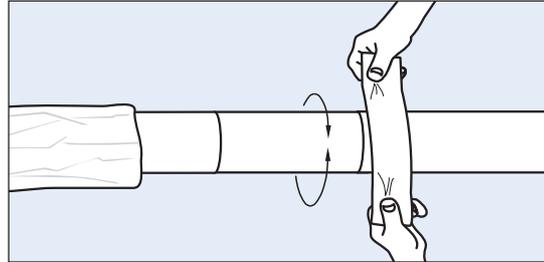
6. Centre the aluminium foil over the joint. Tighten the straps. Wind filament tape round the foil on both sides of the hole.



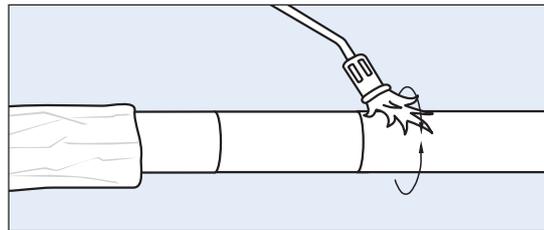
7. Foam the aluminium foil.



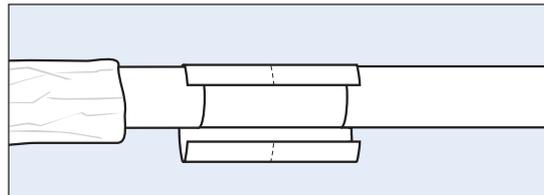
8. Close the opening with canvas tape. Prick a ventilation hole.



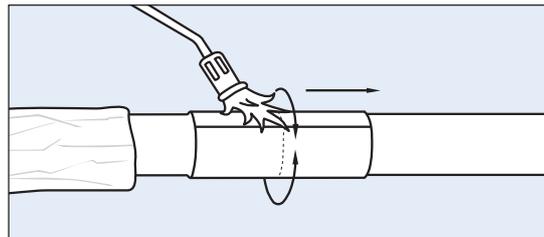
9. Wait minimum 30 minutes for degassing. Remove the aluminium foil. Activate the jacket pipes with abrasive cloth grain size 80 at least 150 mm from both jacket ends.



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



11. Place the shrink film so that the marking line encircles the pipe. Attach one edge of the shrink film at „10 o'clock“ position. Pull the film around the pipe by removing the adhesive paper so that the film adheres to the surface beneath.



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

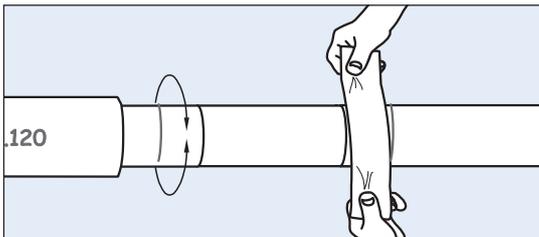
HEW

High temperature joint for foaming

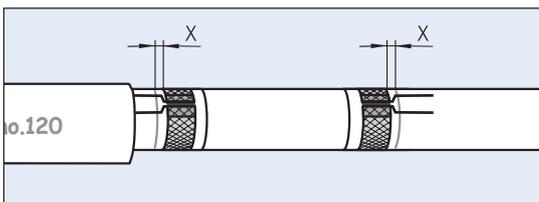
HT3 installation 5.4.2 - 3/4



13. Remove the packing from the shrink sleeve. Do not use cutting tools. Leave the packing on the pipeline. Check that the sleeve is CLEAN and DRY, inside and out. Centre the sleeve over the jointing area. Mark the placing of the sleeve on the jacket pipes. Write the sleeve number on the sleeve. Fill in the documentation form.



14. Pull the sleeve away on the cleaned pipe end. Thoroughly activate the jacket pipes with abrasive cloth, grain size 36-40, exactly touching the marking.

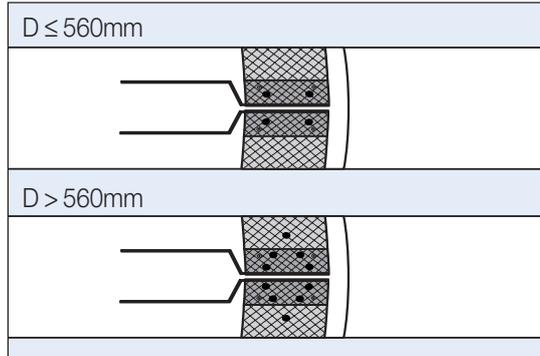


15. Mount the welding elements with the distance X to the marks.

$D \leq 560 \text{ mm} \Rightarrow X = 20 \text{ mm.}$

$D > 560 \text{ mm} \Rightarrow X = 30 \text{ mm.}$

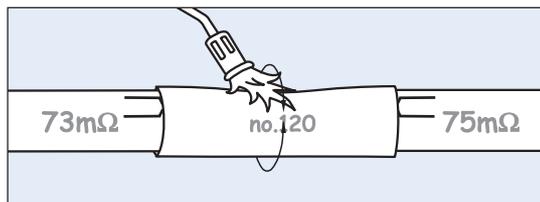
Stretch the elements uniformly so that the element ends exactly do NOT touch.



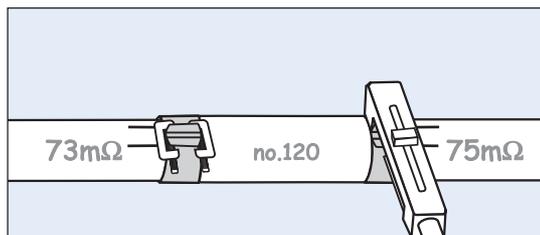
16. Mount the welding elements with nails as shown above and with a nail each 250 mm around the jacket pipes.



17. Place the sleeve between the marks. Write the joint number and resistance values for the welding element on the sleeve/jacket pipes and in the documentation form.



18. Shrink the sleeve from the middle towards the ends. Shrink the sleeve until it is in full contact with welding elements, insulation and jacket pipe.



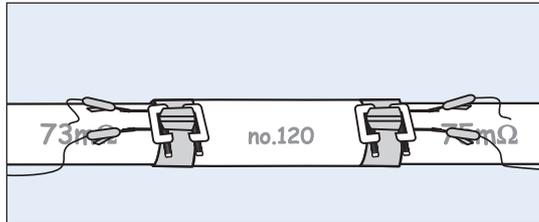
19. Mount clamps 5-10 mm over the sleeve ends. Press the clamps until the jacket pipe starts to deform (max. 0.1 mm). Keep the clamps tightly positioned by using a clamping tool.

HEW

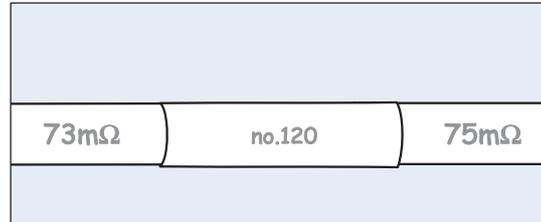
High temperature joint for foaming

HT3 installation

5.4.2 - 4/4



20. Adjust the cutoff voltage on the welding machine for each welding element according to the actual welding parameters. Mount the welding clips at the tip of the terminal wires. Start welding. After completed welding wait until the sleeve is hand-warm, at least 30 minutes. Wait until the clamps are handwarm underneath, before they are removed.



21. Check the joint.

Criteria for approval of EW joint:

- No visible welding elements
- No severe local melt out
- No deformation

After approval of the joint, cut off the terminal wires at the joint edge.

The joint is complete.