

LOGSTOR Installation Instructions

SXB-EWJoint



Installation instructions

SXB-EWJoint

Application

SXB-EWJoint is used for 0-90° directional changes in casing dimensions 90 - 250 mm.

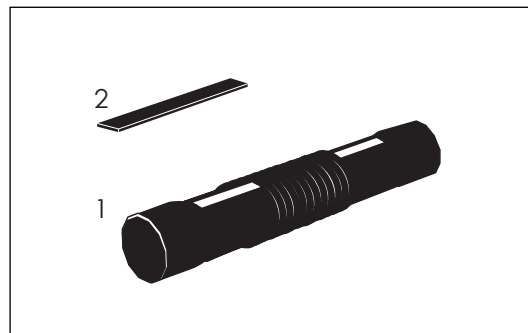
The SXB-EWJoint consists of:

1. SXB bend sleeve
2. Terminal protection

As for connection of alarm wires, see Handling & Installation manual "LOGSTOR Detect".

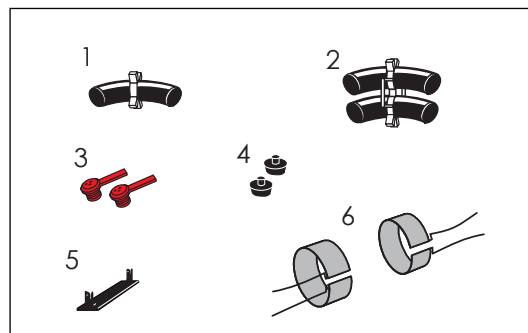
Foam pack:

- size, see foam pack folder
- more information see Handling and Installation manual "Insulating joints"



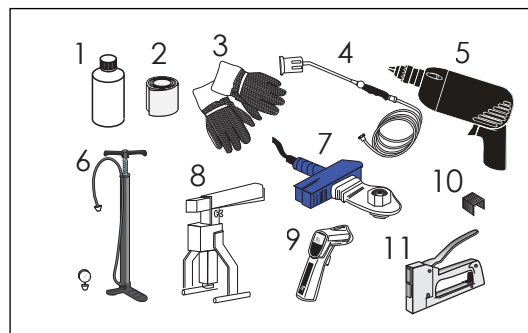
Accessories

1. SXB-WP steel elbow with spacers for single pipe
2. SXB-WP steel elbow with spacers for TwinPipe
3. Venting plugs
4. Weld plugs
5. Wire holders
6. EW welding strips



Tools

1. Alcohol, min 93%
2. Emery cloth, grain size 36-40
3. Gloves
4. Gas burner, ø50 mm
5. Drilling machine with drill bit ø17.5 mm and conical drill bit ø 35 mm
6. Leakage test equipment
7. Plug welding tool
8. Retaining tool for weld plug
9. Temperature measurement device
10. Staples 4 mm
11. Staple gun



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Preparations

Place the bend sleeve with packing on one of the pipes.

Cut the steel elbow at the wanted angle and weld it on to the two pipe ends.

Important:

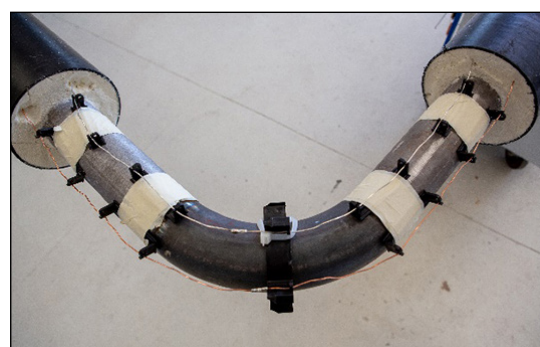
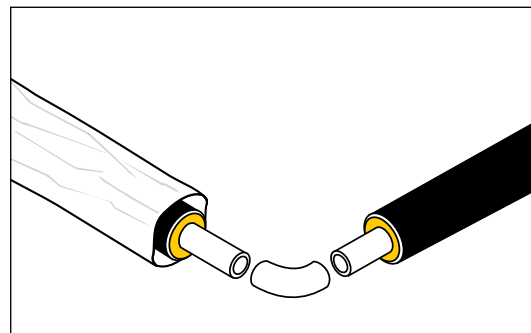
- Only use steel elbow specified by LOGSTOR.
- TwinPipe: The two steel elbows must be parallel to each other.

Place the spacer in the middle of the bend to ensure correct centring of the service pipe in the foam. The bevelled edge must face the bend sleeve.

Fasten the wire holders and the alarm wires in 12 and 2 o'clock position on the outside of the bend as described in the LOGSTOR Detect section under "Connecting alarm wires"

Make sure the wires are not in contact with the service pipe.

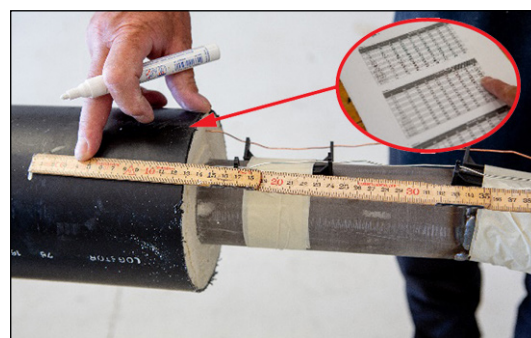
Take care not to damage or displace the alarm wires, when positioning the sleeve.



Marking I

Lookup the marking length L in the table.

At both ends measure from the weld and mark the length L clearly on the casing.



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Marking lengths, L for single pipe and TwinPipe

Series 1

d	D2	Bend angle						
		0°	15°	30°	45°	60°	75°	90°
26.9	90	440	428	416	405	393	381	369
33.7	90	440	428	416	405	393	381	369
42.4	110	440	428	416	404	392	379	367
48.3	110	440	426	411	397	383	368	354
60.3	125	450	432	414	396	378	360	342
76.1	140	483	460	437	414	391	368	345
88.9	160	483	468	453	438	423	408	393
114.3	200	505	485	465	445	425	406	386
139.7	225	525	500	475	450	426	401	376
168.3	250	525	495	465	435	405	375	345
26.9/26.9	125	450	432	413	395	377	358	340
33.7/33.7	140	483	464	446	428	409	391	359
42.4/42.4	160	483	464	446	428	409	391	354
48.3/48.3	160	483	464	445	426	407	388	353
60.3/60.3	200	505	484	463	442	421	400	379
76.1/76.1	225	525	502	479	456	433	410	388

Series 2

d	D2	Bend angle						
		0°	15°	30°	45°	60°	75°	90°
26.9	110	440	428	416	405	393	381	369
33.7	110	440	428	416	405	393	381	369
42.4	125	450	438	426	414	402	389	377
48.3	125	450	436	421	407	393	378	364
60.3	140	483	465	447	429	411	393	375
76.1	160	483	460	437	414	391	368	345
88.9	180	505	478	451	424	396	369	342
114.3	225	525	495	465	435	406	376	346
139.7	250	525	500	475	450	426	401	376
26.9/26.9	140	483	464	446	428	409	391	373
33.7/33.7	160	483	464	446	428	409	391	359
42.4/42.4	180	505	487	468	450	432	413	376
48.3/48.3	180	505	486	467	448	429	410	375
60.3/60.3	225	525	504	483	462	441	420	399
76.1/76.1	250	525	502	479	456	433	410	388

Series 3

d	D2	Bend angle						
		0°	15°	30°	45°	60°	75°	90°
26.9	125	450	438	426	415	403	391	379
33.7	125	450	438	426	415	403	391	379
42.4	140	483	470	458	446	434	422	410
48.3	140	483	468	454	439	425	411	396
60.3	160	483	465	447	429	411	393	375
76.1	180	505	482	459	436	413	390	368
88.9	200	505	478	451	424	396	369	342
114.3	250	525	495	465	435	406	376	346
26.9/26.9	160	483	464	446	428	409	391	373
33.7/33.7	180	505	487	468	450	432	413	382
42.4/42.4	200	505	487	468	450	432	413	376
48.3/48.3	200	505	486	467	448	429	410	375
60.3/60.3	250	525	504	483	462	441	420	399

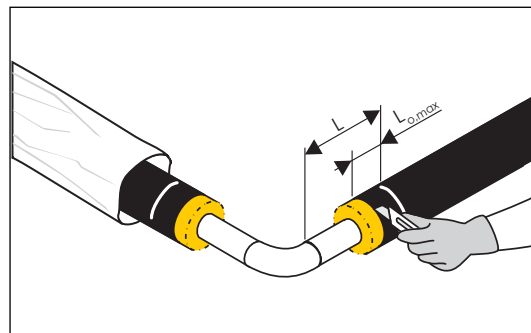
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Cut back

Lookup the maximum overlap length $L_{o,max}$ for the sleeve in below table.

At both ends measure from the L-mark to the insulation end. If the length exceeds the looked up value, cut back the insulation to $L_{o,max}$.

Please note that the overlap should be minimum 120 mm to have enough space for the welding.



Casing D, mm	110	125	140	160	180	200	225	250
Max overlap, $L_{o,max}$, mm	130	140	183	183	195	195	195	195

Cleaning I

Clean the casing surfaces thoroughly with min. 93% alcohol.



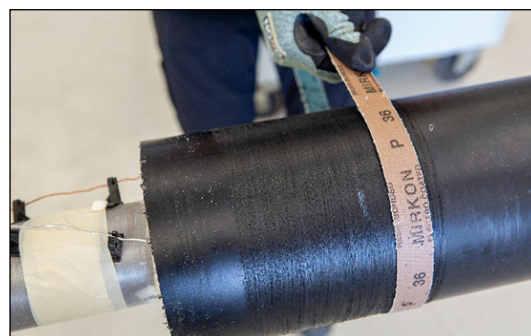
Activation

Remove any moisture with a gas flame by preheating the casing to 20-30°C before grinding.

Grind the casing thoroughly with emery cloth, grain size 36-40.

Grind extra 30 mm, so grinding marks will be visible after installation. This enables visual inspection of the activation later by the supervisor.

Check that the entire circumference has been ground.



Cleaning II

Clean the surfaces thoroughly with min. 93% alcohol.



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Marking II

For correct positioning of the sleeve ends, draw a line all the way around the casing at the L-marking.

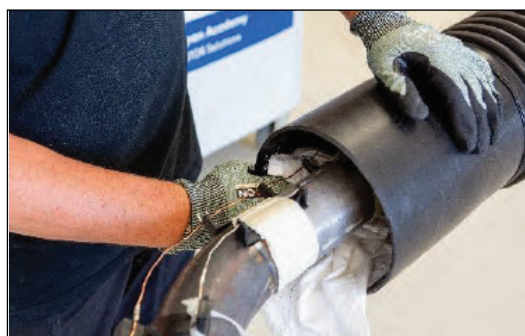


Cleaning III

Remove the packing from the sleeve. Do not use cutting tools.

Clean the inner surfaces of the sleeve at both ends with min. 93% alcohol.

Check that all surfaces are clean and dry.



Welding strips

Mark the position of the welding strips 30 mm from the L-marking.

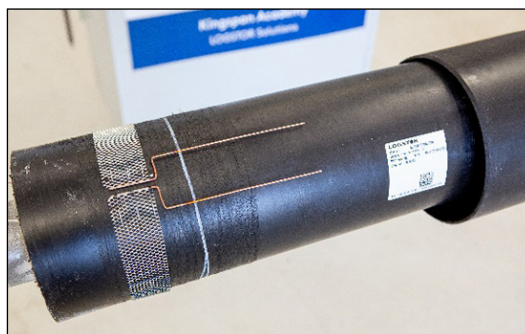


Fix one end of the welding strip with staples as illustrated in the picture.

Stretch the welding strip to the extent where the ends are close to but DO NOT touch each other (3 mm).

Fix the other end against the three polyamide clips as indicated in the picture.

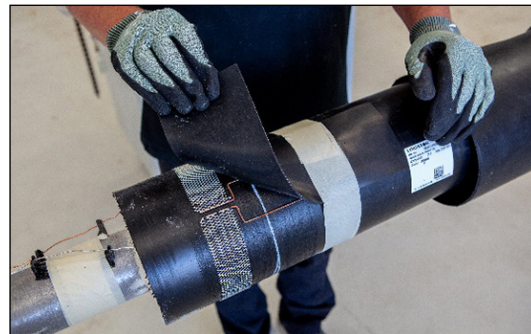
Fix the welding strips with staples, spaced app. 250 mm apart around the casing.



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Terminal protection

At the pipe on which the sleeve is pre-installed place the terminal protection over the terminals and fasten with tape outside the ground area.



Heating the corrugation

Heat the corrugation with a gas burner. Avoid heating on the smooth ends.



Continue until the corrugation is flexible enough to be easily compressed manually.



Positioning and shrinking

Pull the corrugation back to neutral and pull and push the sleeve around the elbow.

Press the corrugation on the opposite side of the spacer, if it gets stuck.

Be careful not to damage or displace the welding strips or the alarm wires.

Remove the terminal protection.



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Positioning and shrinking, continued

Position the sleeve end at the marking.
Shrink the end of the sleeve, so the end is aligned with the marking all the way around the casing.

Shrink the end until the sleeve has full contact with the welding strips and casing.

Repeat at the other end.

Do not use wedges to fix the sleeve.

Make sure that both ends are aligned with the markings all the way around the casings. If not, reheat the corrugated part and pull into position.



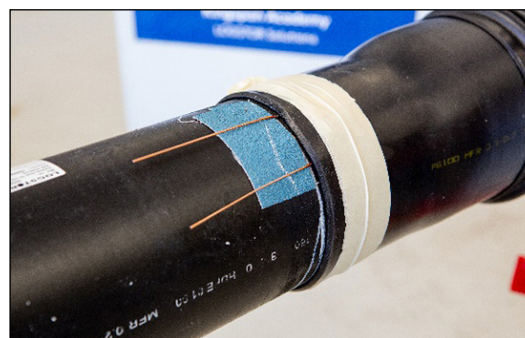
Welding

Wrap tape around the joint in the weld zones to ensure a long service life for the pressure tubes.

Remove the tape before leakage testing.

Place a piece of emery cloth under the terminals to protect them from melting into the casing pipe.

Weld the joint ends as described in the Weld Joint Manual "EWJoint".



Leakage test

Drill two Ø17.5 mm holes at the top of the sleeve - one at each sleeve end.

The distance from the hole centre to the mirror welding should be app. 40 mm to ensure enough space for later plug welding. Check there is enough space before drilling.



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Leakage test, continued

When the shrink sleeve has cooled to hand warm, leakage test with 0.2 bar.

Test the sleeve ends visually with soapy water.



When the joint has been tested and is leakproof, cut the terminals at the sleeve edge.



Foaming

Foam the joint in accordance with the installation instructions for foaming.



Plug welding

Install the weld plug as described in the Weld Joint Manual "EWJoint".



Joint complete

The joint is complete.



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