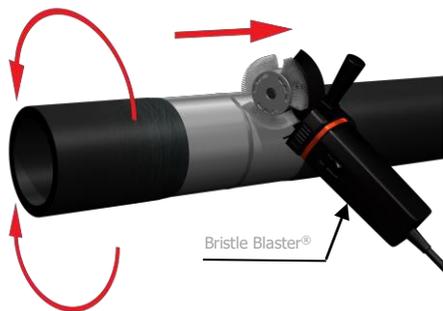


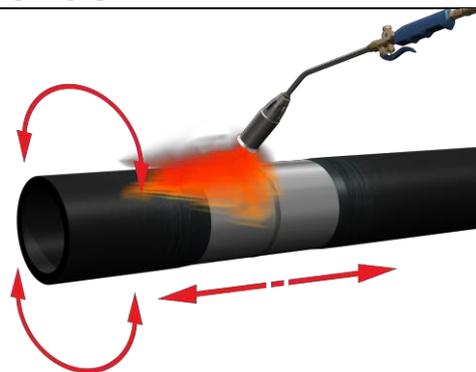
"ANTICORRay WSS60" APPLICATION TECHNOLOGY



Step 1

Surface cleaning

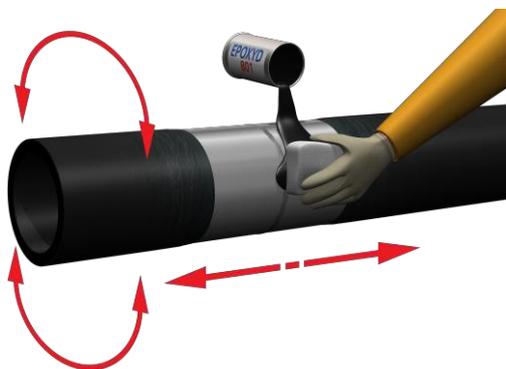
- 1) First, clean the surface to be insulated from impurities and degrease it with an oil-free solvent (e.g. petroleum ether, acetone).
- 2) Clean the steel surface to cleanliness grade Sa 2½ according to ISO 8501, using e.g. the Bristle Blaster® device.
- 3) Using sandpaper, roughen the ends of factory-made insulation at the width of about 10 cm.
- 4) Bevel the factory-made insulation edges at an angle of approx. 15°.



Step 2

Preheating

- 1) Heat the surface prepared for insulation with a burner to min. 70°C.
 - 2) Check the temperature with a thermometer during heating.
 - 3) Mix the two-component epoxy primer "ANTICORRay Epoxy Primer 801" in an appropriate proportion simultaneously with surface heating.
- Note: it is not necessary to apply epoxide to the factory-made surface.



Step 3

Application of primer

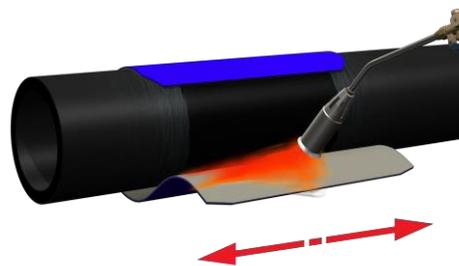
- 1) Apply the well-mixed primer to the steel surface using the sponge provided.

Notes:

The layer thickness should be min. 100µm.

The well applied primer should be uniformly black (no steel clearances or stains should occur).

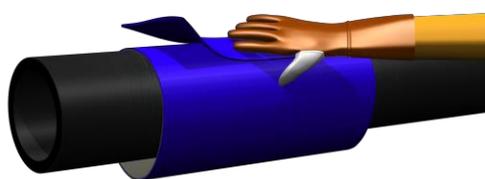
Protect your hands with the provided protective gloves.



Step 4

Application of a sleeve.

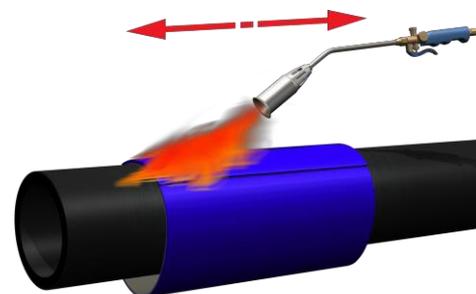
- 1) Remove silicone-coated paper.
- 2) With soft flame, heat glue at the end of the sleeve from the side of sharp corners.
- 3) Place the heated end directly on the welded joint at the eleven o'clock position pressing it against the pipe surface.
- 4) Wrap the sleeve loosely around the pipe, leaving clearance of about 2-4 cm under the sleeve. -
- 5) With soft flame, heat up the adhesive on the other end of the sleeve.
- 6) Place the heated end on the glued-in sleeve, while maintaining the recommended overlap.



Step 5

Gluing-in the closing strip

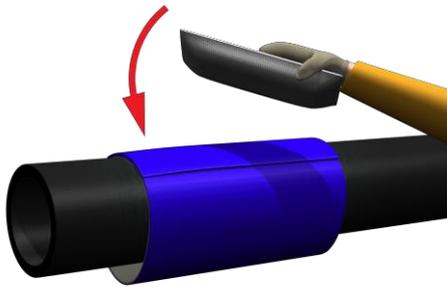
- 1) Heat the inner side of the closing strip with soft flame to soften the adhesive.
- 2) Glue the strip symmetrically along the sleeve edge.



Step 6

Heating the closing strip

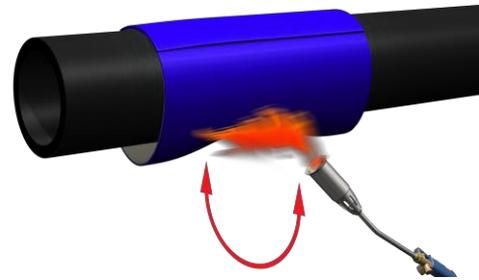
- 1) Heat the outer surface of the strip with strong flame until it becomes plastic.



Step 7

Final sealing of the sleeve

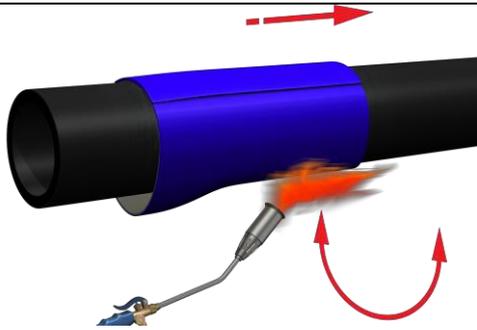
1) Press the heated closing strip very strongly against the sleeve with the use of "Anticor Smash Belly" pressing tool or do it by hand protected by glove.
 Note: The properly glued strip shows no wrinkles or closed „air pockets”.



Step 8

Sleeve shrinking I

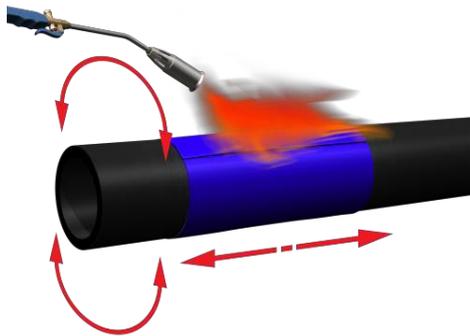
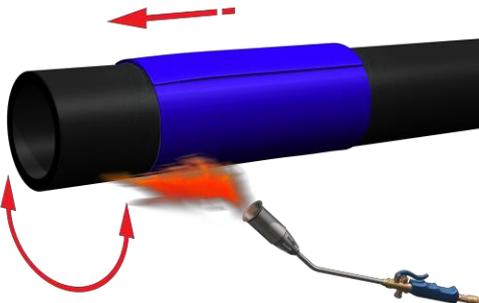
1) Heat up the sleeve with strong flame, starting from the bottom, directly at a height of the welded joint. Move the flame alternately around the entire circumference.



Step 9

Sleeve shrinking II

1) Continue to heat the sleeve going from the welded joint in one direction, then in the other, moving the flame around the circumference.
 Notes: Heating should be done evenly so that the air is not locked under the sleeve. The sleeve should fit tightly against the pipe. The sleeve on pipelines with diameter above DN300 should be shrunk symmetrically using two burners placed on both sides of the pipeline.



Step 10

Sleeve shrinking III

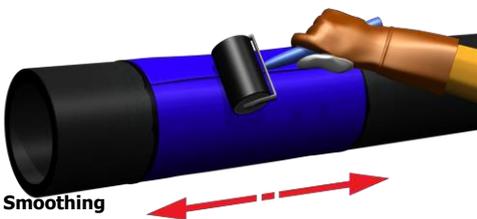
1) Finally, heat the whole sleeve surface by slow, longitudinal motion of the burner around the entire circumference in order to obtain uniform melting of adhesive and even shrinking of coating.
 Note: Shrinking operation is finished when adhesive begins to flow out from under the sleeve edges.



Step 11

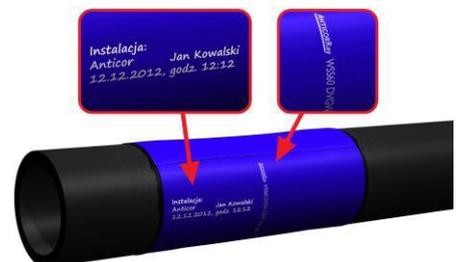
Checking the proper sleeve heating

1) Press the sleeve surface with a finger against several points, moving it slightly.
 Note: If the sleeve is properly heated, after pressing and moving the finger a wrinkle appears and then disappears after the test is finished.



Step 12 Smoothing the sleeve

1) Smooth the sleeve using a silicone roller, especially around the welded joint and near the closing strip to remove possible air pockets.
 Note: If air pockets are present, remove them by moving the roller from the centre of the sleeve towards the edges. The sleeve can be re-heated if necessary.



Step 13

Final operations

1) Using a white marker pen (UV and waterproof), specify the following information on the applied sleeve:
 • Company name and a name of a person performing the installation.
 • Date and time of installation completion.
 Note: The above information on the sleeve **serves as the identification** of the installed coating.

In case of any problems, contact us, our technical service will provide assistance. Thank you for choosing our offer.



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