



DEKOTEC®-HTS

1. Preparation

- During all application steps, you must wear appropriate personal protection equipment, such as safety shoes, helmet, protective goggles and welding gloves, as prescribed by local health and safety regulations. We strongly recommend that new staff becoming involved in using shrink sleeves receive training prior to working on them.
- Roughen adjacent work surfaces (e.g. with an emery cloth #40) and chamfer to an angle of $\leq 30^\circ$.
- For pipe diameters of sizes > 400 mm (16"), we recommend the use of 2 applicators.
- The surface must be dry and free from grease, oil, dust and other impurities prior to blast cleaning with a cleanliness level of at least Sa 2½ (ISO 85011). Surface roughness (ISO 85031) 50–100 µm. The blasted surface must be protected from the effects of dust and moisture.
- Never touch the cleaned surface with bare hands.
- When using master rolls, the sleeves must be cut to the required length (see table) and must have 45° chamfers.

2. Pre-warming the surface to be coated

- The surface to be coated must be evenly pre-warmed (steel and the adjacent factory coating) to $+50^\circ\text{C}$ ($+122^\circ\text{F}$) prior to the application of the **DEKOTEC® Primer**. If no **DEKOTEC® Primer** is used, the surface must be pre-warmed directly to $+90^\circ\text{C}$ ($+194^\circ\text{F}$) up to $+212^\circ\text{F}$. Pre-warming is carried out at a high flame intensity.
- Always use the correct primer for the shrink sleeve system.

3. Mixing DEKOTEC® Primer

- Mix together **DEKOTEC® Primer** components A and B and stir for at least 2 min.
- Always measure out component B first. Before using **DEKOTEC** hand pumps, a waiting time of approx. 5 sec between the individual pump strokes is highly recommended.
- When using the primer bag, place this on a firm subsurface, remove the plastic clip and carefully mix the components in the bag using a roller or a clip for at least 2 min.
- Always adhere to a pre-mixing material temperature of $+20^\circ\text{C}$ to $+40^\circ\text{C}$ ($+68^\circ\text{F}$ to $+104^\circ\text{F}$) for all variants.

4. DEKOTEC® Primer application

- Apply an even layer of **DEKOTEC®-Primer** (**DEKOTEC®-EP Primer** $\geq 30\ \mu\text{m}$ / **DEKOTEC®-EP Primer HT** $\geq 200\ \mu\text{m}$) to the whole area to be coated (steel surface and adjacent factory coating) with a solvent-resistant nylon roller. Alternatively, **DEKOTEC®-EP Primer** can be applied with a sponge.

5. Curing the DEKOTEC® Primer

- Curing the **DEKOTEC® Primer** with strong flame intensity up to a surface temperature of $+90^\circ\text{C}$ to $+110^\circ\text{C}$ ($+194^\circ\text{F}$ to $+230^\circ\text{F}$).
- Curing is complete when the **DEKOTEC® Primer** is dry to the touch.
- Maintain temperature of $+90^\circ\text{C}$ ($+194^\circ\text{F}$) until the sleeve is applied.

6. DEKOTEC®-HTS sleeve installation \leq DN 100

- Warming the entire sleeve on the adhesive side.
- Press on the sleeve in the steel area by hand so that it is free of air, overlap and push out any air pockets from the centre of the seam to the right and left.

Caution: Risk of burns.

7. DEKOTEC®-HTS sleeve installation $>$ DN 100 – step 1

- Warm the adhesive side of the sleeve on the side with the 45° chamfer to a length of approx. 200 mm (8").

8. DEKOTEC®-HTS sleeve installation $>$ DN 100 – step 2

- Press the **DEKOTEC®-HTS sleeve** onto the pre-warmed surface in a 2 o'clock position so that the centre marking is positioned on the sleeve above the weld seam.
- Remove any air pockets using the roller, as shown in the image.

9. DEKOTEC®-HTS sleeve installation $>$ DN 100 – step 3

- Warming the adhesive side of the **DEKOTEC®-HTS sleeve** at the loose end at a length of approx. 100 mm (4").
- Press the loose end firmly onto the surface of the already installed end so that the centre marking of the sleeve at both ends is superimposed. Overlapping of the sleeve ends at approx. 100 mm (4").
- If the closure patch of the **DEKOTEC®-CLP** has been pre-installed, warm it until the silvery surface is shiny.

10. DEKOTEC®-CLP Applying the closure patch

- Warm up the adhesive side (silver) of the **DEKOTEC®-CLP** closure patch until it is shiny.
- Apply the **DEKOTEC®-CLP** in the overlap area of the sleeve by firmly pressing down on the surface with the superimposed centre markings.
- Avoid bending the closure patch.

11. DEKOTEC®-CLP (pre-installed) Applying the closure patch.

- Reduce the burner to a lower intensity (yellow flame).
- Warm the closure patch progressively and pummel it by hand until it is smooth and tight all over.

12. DEKOTEC®-HTS Sleeve installation Shrinking

- Use a medium intensity burner to shrink the **DEKOTEC®-HTS sleeve**.
- Heat the sleeve from the centre to the edges around the circumference with even movements.
- For pipe diameters of > 400 mm (16") 2 burners should be used in the respective opposite position.

13. DEKOTEC®-HTS Sleeve installation post-warming

- Even warming of the entire **DEKOTEC®-HTS sleeve** with strong flame intensity.
- The "DEKOTEC" embossing will disappear when sufficient heat is applied.
- The adhesive must be visible on both sides of the sleeve around the entire circumference.

14. DEKOTEC®-HTS Sleeve installation Smoothing

- Use a roller to remove air pockets. First, roll around the circumference to overlap the sleeve.
- Starting in the overlap area, from the centre to the edges, the roller is moved back and forth in a zig zag motion to push the air pockets forwards.
- Before filling, allow the sleeve to cool to the ambient temperature.

Pipe size diameter			Sleeve length		Length DEKOTEC®-CLP
DN (nominal diameter) (mm)	DA (outer diameter) (mm)	DN (inch)	mm	mm	mm
80	88.9	3"	370	75	
100	114.3	4"	455	75	
150	168.3	6"	680	100	
200	219.1	8"	850	100	
300	323.9	12"	1195	150	
400	406.4	16"	1465	150	
500	508.0	20"	1800	150	
600	609.6	24"	2135	200	
700	711.2	28"	2470	200	
800	812.8	32"	2800	200	
900	914.4	36"	3135	200	
1000	1016.0	40"	3470	200	
1200	1219.2	48"	4135	200	
1400	1422.4	56"	4800	200	

The above values are theoretically determined on the basis of the specified tube outer diameter and a max. 4 mm thick factory coating. These must be checked before cutting. Other cutting lengths on request.

DEKOTEC GmbH
 Felderstrasse 24 | 51371 Leverkusen | Germany
 Phone: +49 214 2602-0 | info@dekotec.com
 www.dekotec.com

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