

INSTALLATION INSTRUCTIONS

CS-60 Series
Heat Activated Shrink Wraps and Tapes

Description:

Corroshrink CS Series shrink wraps and tapes are shipped in predetermined bulk rolls depending on the width requested. The adhesive is built into the wrap, and only becomes apparent upon heat activation, protecting it from environmental factors. Closure strips are supplied as a separate component, and come in various lengths to match the width of respective wrap being installed. For smaller width applications using the tape products, the closure strips can be easily cut to the appropriate length.

Storage of Product:

It is important to understand that CS-60 is a product containing built in adhesive that is activated by heat. Precautions should be taken to ensure proper storage temperature above temperatures noted on product datasheet that will activate the adhesive. This includes radiant heat from direct sunlight. In addition, extreme cold can cause damage to shrink materials. CS-60 must be stored out of the sun or other harsh weather conditions, and at temperatures above -4 Deg. F (20 Deg. C) and below 95 Deg. F (65 Deg. C).

Suggested Equipment Necessary:

Propane tank, hose, torch with regulator, surface prep tools to scuff the area, knife, roller, rags and cleanser, digital thermometer with probe, and necessary safety equipment (gloves, safety glasses/goggles, hard hat, steel toe boots, etc.

Surface Preparation For Best Results:

- Make sure coating edges are beveled at least 30 Deg., if any presence of surface contaminants, entire area must be cleaned with a solvent cleaner
- Pipe must be dry before next step, using abrasion tool (ex. wire brush, sand paper, etc.), scuff up the pipe to a minimum of ST3/SP3, Lightly scuff area adjacent to the cutback area at least 2" (5cm) beyond each shrink wrap end
- Wipe area to remove any remaining debris

Completion and Verification Measures For Best Results:

- Use hand roller to gently roll over entire surface to help work out remaining air bubbles, this must be done while shrink wrap is still hot, immediately following horizontal strokes in previous step, reheating if necessary to fully complete this step
- For added assurance, it is recommended to perform roller process on the closure strip area, from the center working toward edges with firm press
- Ensure the area is free from visual flaws, such as; sleeve is in full contact in all areas, adhesive flows out of edges on all edges, there are no cracks or holes in the sleeve backing
- Allow shrink wrap to cool a minimum of 2 hours prior to backfilling and burying pipe
Certain backfill material may damage shrink wrap, and reduce corrosion protection provided by CorroShrink, make sure backfill material is free from sharp stones or other large particles, further protection of the shrink wrap may be necessary

General Product Installation Guidelines:

- Closure Strips should be sized appropriately to match the width of shrink wrap/tape being installed
- Overlap - each section should be cut to provide for a minimum of 4" (10 cm) overlap around the pipe
- It is important to make sure the shrink wrap and closure strip have no visible damage or contamination prior to installing
- **IMPORTANT - Shrink wrap/tape must be installed in the direction as it is spooled off the bulk roll, failure to do so will inhibit the shrinking process from working properly**

CAUTION - BEFORE YOU BEGIN PLEASE READ



Closure Strips must be used for all wrap/tape installations to avoid peeling back caused by overheating



IMPORTANT - Shrink wrap/tape must be installed in the direction as it is spooled off the bulk roll, failure to do so will inhibit the shrinking process from working properly

STEP-BY-STEP

STEP 1. Preparation

- Ensure free of debris and contaminants to ensure proper bonding (See "Suggested Surface Preparation" for optimal results)
- Cut Corroshrink wrap/tape to desired length to properly overlap a minimum of 4" (10 cm)
- Cut closure strip to properly span entire seam (corresponds with width of wrap/tape)



STEP-BY-STEP CONTINUED ...

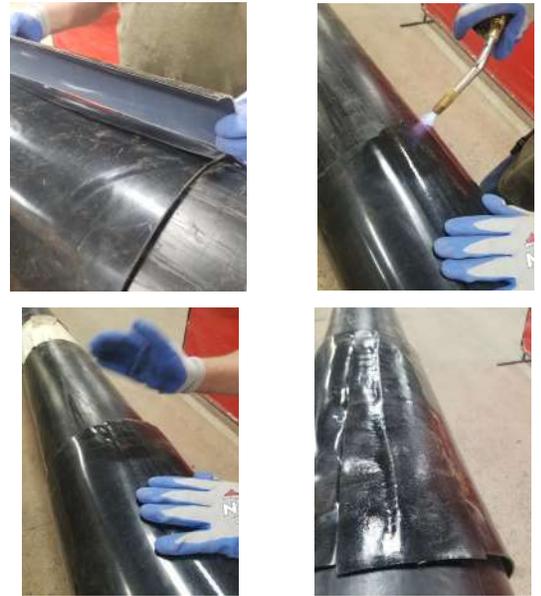
STEP 2. Tack shrink wrap/tape to surface

- Pre-heat the joint area to a minimum of 150 Deg. F (65 Deg. C)
- Gently heat first 6 inches (15 CM) of wrap and for the full width to activate adhesive and tack it to the pipe at the 2 O'Clock position
- Center wrap over the joint and wrap from backside under the joint then up and back over the front
- Loosely wrap the pipe joint, while ensuring proper overlap, confirming the seam is at the 12 O'Clock position, or close to it
- Use same gentle heating technique as before on the full width of the wrap to tack overlap into place



STEP 3. Apply the closure strip

- Pre-heat closure strip to activate adhesive, then center closure strip on the seam/overlap
- Press firmly to ensure closure strip holds
- Heat closure strip to fully activate adhesive, patting it down periodically with a gloved hand
- Continue process moving from one end to the other until closure strip is fully bonded
- For best results, heat closure strip in the middle and work your way toward the edges to work out any wrinkle or air pockets



STEP 4. Shrink the wrap/tape

- Begin heating the shrink wrap in the center, using long gradual passes up and down, observing shrink wrap settling into place snug to the pipe with no bubbles, and working all around the pipe remaining in the center
- Once center is shrunk and snug to pipe, continue heating in the same process toward one end of the shrink wrap/tape
- Repeat previous process beginning back in the center and working toward other end of shrink wrap/tape
- Process is complete when adhesive is seen coming out the edges of the wrap, all the way around the full circumference of the pipe, and on both ends
- To work out any pockets of glue build up, continue heating from side to side around entire area ("Completion and Verification Measures" section for some best practices to finalize process)

