



DEKOTEC®-BTS

General work steps:

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 $> 400\text{mm}$ (16"), we recommend the use of 2 applicators.
- Required surface cleanliness: The surface must be dry and free from grease, oil, dust and other impurities. Steel surfaces must have a cleanliness level of min. St 2 or Sa 2.5 (ISO 8501-1). Surface roughness (ISO8503-1) 50-100 μm .
- When using master rolls, the sleeves must be cut to the required length (see table) and must have 45° chamfers.
- The cutting length must be taken from the cutting length table.
- For the best shrink results, a 30mm high performance burner attachment must be used

2. Cleaning



- Clean the surface with a lint-free cloth – do not touch the cleaned surface with bare hands.

3. Drying



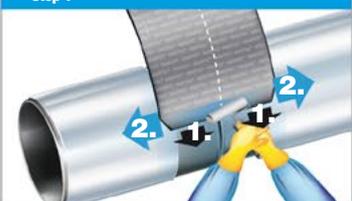
- Thoroughly dry the surface to be coated (steel and adjacent factory coating).
- The surface temperature must be $\geq +23^\circ\text{C}$ ($\geq +73^\circ\text{F}$) and $+3^\circ\text{C}$ ($+5.4^\circ\text{F}$) above the dew point.

4. Optional DENSOLEN®-HT Primer Application



- Stir the **DENSOLEN®-Primer** thoroughly in its original container prior to use until there is no sediment remaining.
- Apply an even, thin layer to the cleaned and dried surface using a brush or a short-pile roller (polyamide/nylon).
- Include factory coating in the primer in the width of the prepared surface.
- After use, carefully close the primer container. Clean the brush or paint roller with petrol (80/110).
- Ventilate the primer coat until it is no longer sticky (finger test).

5. DEKOTEC®-BTS Sleeve Installation Step 1



- When using master rollers, the sleeves must be cut to the required length (see 1st Preparation) and must have 45° chamfers.
- Press down the **DEKOTEC®-BTS** in a 2 o'clock position so that the centre marking is positioned on the sleeve above the weld seam.
- Remove air pockets using a roller, as shown in the image.
- Place the sleeve tightly onto the factory coating without applying any pressure.

Caution: Remove the separating film of the sleeve during installation.

6. DEKOTEC®-BTS Sleeve Installation Step 2



- Press the loose end firmly onto the surface of the already installed end so that the centre marking on the sleeve on both ends is superimposed. Overlap the sleeve ends at approx. 100 mm (4") with no air.
- Activate the overlap area by stroking a yellow flame across it.
- Roller the overlap area firmly.

7. DEKOTEC®-CLP Sealing flap application



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

8. DEKOTEC®-BTS Sleeve installation Shrinking



- To shrink the **DEKOTEC®-BTS** sleeve, use a burner with blue-yellow intensity.
- Warm the sleeves from the centre to the edges around the circumference with even movements until attached.
- For pipe diameters of $> 400\text{mm}$ (16"), 2 burners must be used in the respective opposite position.
- The "DEKOTEC®" embossing will disappear when sufficient warmth is applied.
- Vigorous rolling of the overlap edge using a special roller, only in the steel area, in each case from the weld seam to the right and left.
- Roll out any air pockets with a special roller horizontally to the sleeve edges.

Caution: To make the rolling process easier, carefully warm the backing until it is soft. (Shine begins to appear at approx. $+150^\circ\text{C}$ ($+302^\circ\text{F}$))

9. DEKOTEC®-BTS Sleeve Installation Edge sealing



- To seal the sleeve edges, warm them around the circumference with blue-yellow flame intensity until they are fully attached.
- Vigorous rolling of the overlap edge using a special roller, always from right to left up to the edge of the sleeve.

10. DEKOTEC®-BTS Sleeve Installation Cooling time



- Once the sleeve has been fully applied, at least 2 hours are necessary to let the sleeve cool off to ambient temperature before it is possible to start to fill the pipes

Recommendation:

For much easier and safer processing of the overlap edge, we recommend the use of our special roller.

Cutting lengths for weld seam coatings

ND - Nominal Diameter (mm)	OD - Outer Diameter (mm)	ND (inch)	Sleeve length (mm)
100	114.3	4"	500
150	168.3	6"	670
200	219.1	8"	830
300	323.9	12"	1160
400	406.4	16"	1420
500	508.0	20"	1740
600	609.6	24"	2060
700	711.2	28"	2380
800	812.8	32"	2700
900	914.4	36"	3020
1000	1016.0	40"	3340
1200	1219.2	48"	3980
1400	1422.4	56"	4620

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