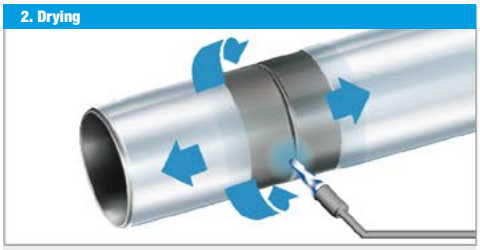
DEKOTEC®-MTS

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 ≤30°.
- For pipe diameters of sizes > 400mm (16“), we recommend the use of 2 applicators.
- The surface must be dry and free from grease, oil, dust and other impurities prior to surface cleaning with a cleanliness level of at least St 2 or Sa2½ (ISO 8501 1. Surface roughness (ISO85031) 50–100µm. Protect the cleaned surface from dust and moisture.
- Never touch the cleaned surface with bare hands.
- When using master rollers, the sleeves must be cut to the required length (see table) and must have 45° chamfers.

2. Drying



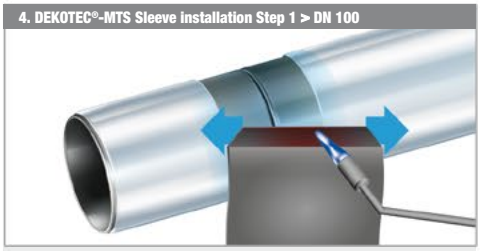
- Thoroughly dry the surface to be coated (steel and adjacent factory coating).
- The surface temperature must be ≥ +23°C (≥ +73°F) and +3°C (+5.4°F) above the dew point.

3. DEKOTEC®-MTS Sleeve installation ≤ DN 100

- Warm 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 to the right and left from the centre of the seam.

Caution: Risk of burns.

4. DEKOTEC®-MTS Sleeve installation Step 1 > DN 100

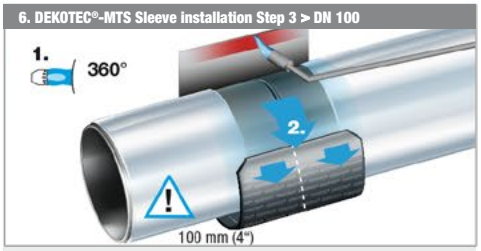


- Warm the adhesive side of the sleeve on the side with the 45° chamfer to a length of approx. 200 mm (8“).

5. DEKOTEC®-MTS Sleeve installation Step 2 > DN 100

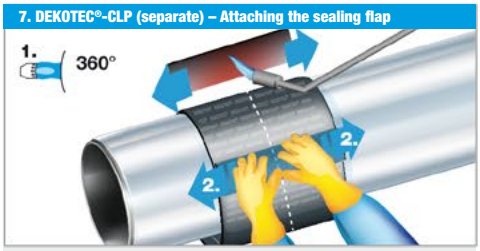
- Press the **DEKOTEC®-MTS** onto the dried surface in a 2 o'clock position so that the central marking of the sleeve is positioned above the weld seam.
- Remove air pockets with a roller as shown in the image.

6. DEKOTEC®-MTS Sleeve installation Step 3 > DN 100



- At the loose end of the **DEKOTEC®-MTS**, warm the adhesive side to a length of approx.100 mm (4“).
- Push the loose end firmly onto the installed end, so that the central markings are superimposed. The overlap is approx.100 mm (4“).
- For pre-installed **DEKOTEC®-CLP** sealing flaps, warm them too until the silver surface is shiny.

7. DEKOTEC®-CLP (separate) – Attaching the sealing flap

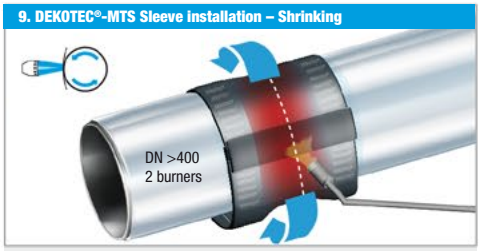


- Warm up the adhesive side (silver) of the **DEKOTEC®-CLP** sealing flap until the surface is shiny.
- Firmly press down **DEKOTEC®-CLP** in the overlap area of the sleeve. The central markings should be superimposed.
- Avoid bending the sealing flap.

8. DEKOTEC®-CLP (pre-installed) – Attaching the sealing flaps

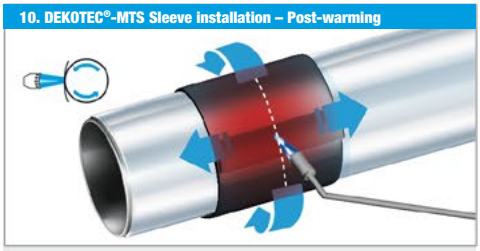
- Reduce the burner to low intensity (yellow flame).
- Warm the sealing flap in sections and pummel by hand until it is smooth and firmly attached everywhere

9. DEKOTEC®-MTS Sleeve installation – Shrinking



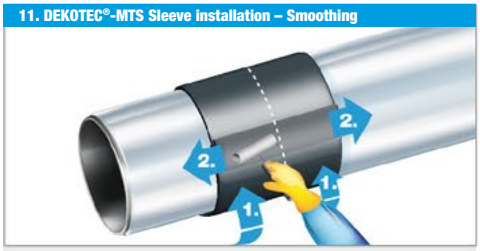
- To shrink **DEKOTEC®-MTS** use a burner flame of medium intensity.
- Warm the sleeve using even movements around the circumference, starting in the middle. Gradually work outwards towards the edges.

10. DEKOTEC®-MTS Sleeve installation – Post-warming



- Warm the entire **DEKOTEC®-MTS** sleeve evenly with a strong flame
- The “DEKOTEC“ embossing will disappear when sufficient warmth is applied.
- The adhesive must be visible on both sides of the sleeve around the entire circumference.

11. DEKOTEC®-MTS Sleeve installation – Smoothing



- Use a roller to remove air pockets. First roll around the circumference towards the overlap of the sleeve.
- Roll from the middle to the edges in the overlap area. Move the roller backwards and forwards in a zig zag motion to push the air forward.
- Prior to filling, allow the sleeve to cool to ambient temperature.

Cutting lengths for weld seam coatings

Pipe Size Diameter			Sleeve Length	Length DEKOTEC®-CLP
DN Nominal Diameter (mm)	OD Outer Diameter (mm)	inch	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 pipe outer diameter and a max. 4 mm thick factory coating. This must be checked prior to cutting. Other cutting lengths on request.

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