

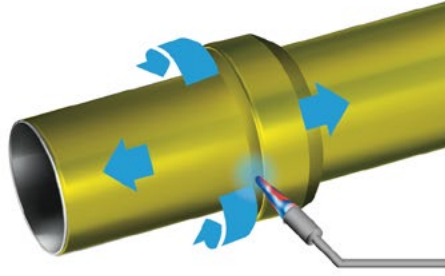


DEKOTEC®-MTS55 DI/-MTS55 HS65

1. Preparation

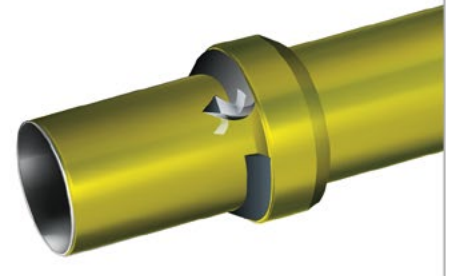
- During all application steps, you must wear appropriate personal protection equipment, such as safety shoes, helmet, protective goggles and welding gloves, as prescribed by local health and safety regulations. We strongly recommend that new staff becoming involved in using shrink sleeves receive training prior to working on them.
- Adjacent factory coatings must be chamfered at an angle of $\leq 30^\circ$.
- For pipe diameters of sizes $> 400\text{mm}$ (16"), we recommend the use of 2 applicators.
- The surface must be dry and free from grease, oil, dust and other impurities prior to surface cleaning with a cleanliness level of at least St 2 or Sa2½ ISO 8501-1. Surface roughness (ISO8503-1) 50-100µm. Protect the cleaned surface from dust and moisture.
- Never touch the cleaned surface with bare hands.

2. Drying



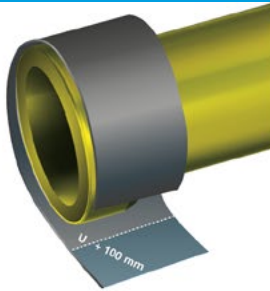
- Thoroughly dry the surface to be coated (steel and adjacent factory coating).
- The surface temperature must be $\geq +23^\circ\text{C}$ ($\geq +73^\circ\text{F}$) and $+3^\circ\text{C}$ ($+5.4^\circ\text{F}$) above the dew point.

3. DEKOTEC®-DI Mastic



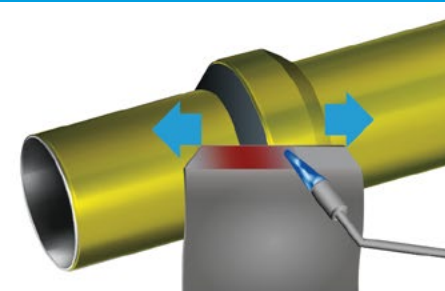
- Cut the DEKOTEC®-DI Mastic lengthwise in such a way that a closed ring is created in front of the bell.
- Firmly press down the DEKOTEC®-DI Mastic with the self-adhesive sides on the pipe and the end face of the bell. Then use a hot spatula to smooth. Avoid overhang of DEKOTEC®-DI Mastic on the bell.

4. Cutting



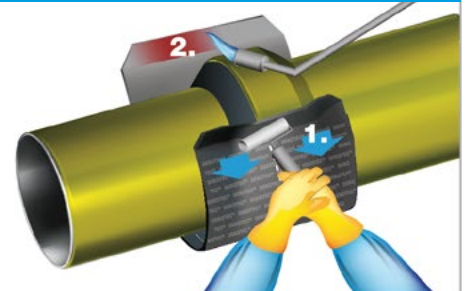
- When using master rolls, the sleeves must be cut to the required length and must have 45° chamfers.
- The cutting length of the DEKOTEC® sleeves corresponds to the largest circumference of the bell plus 100 mm.

5. Sleeve installation



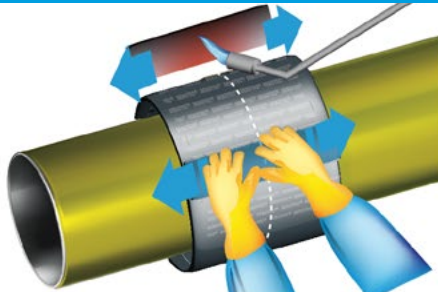
- Warm the adhesive side of the sleeve on the side with the 45° chamfer to a length of approx. 200mm (8").
- Caution:** Only warm the sleeve along the width of the bell (contact surface).

6. Sleeve installation



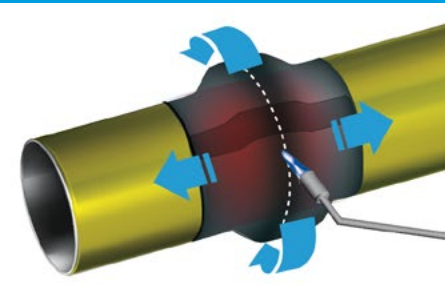
- Press the warmed side of the DEKOTEC® sleeve onto the bell in such a way that the central marking is positioned on the edge of the bell.
- Warm the loose end of the sleeve to a length of approx. 100 mm and press onto the already installed end. (100 mm overlap).

7. DEKOTEC®-CLP Attaching the sealing flaps



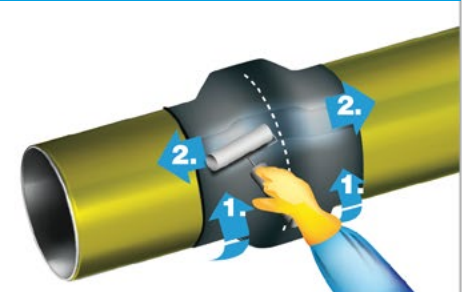
- Warm up the adhesive side (silver) of the DEKOTEC®-CLP sealing flap until the surface is shiny.
- Apply the DEKOTEC®-CLP in the overlap area of the sleeve by firmly pressing down on the surface with the centre markings superimposed.
- Support the free-standing underside of the sleeve to the right and left of the bell from the inside when pressing down. (With clean gloves only)
- Avoid bending the sealing flap.

8. Sleeve installation Shrinking



- Warm the sleeve from the bell to the edge of the bell pipe around the circumference with even movements.
- Warm the sleeve from the bell to the edge of the insertion pipe around the circumference with even movements.

9. DEKOTEC®-MTS Manschetteninstallation Glättung



- 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