

Installation Guide – Shrink Sleeve vs RD6-OS

Sleeve #	Description of step	RD6 OS #	Description of step
Surface prep station			Surface prep station
1	Clean exposed steel and adjacent pipe coating.	1	Clean exposed steel and adjacent pipe coating.
2	Make steel surface dry	2	Make steel surface dry
3	Prepare bare steel cutback to ISO 8501:1 class St 3 preparation standards	3	Prepare bare steel cutback using commercial blast (NACE 3), power tool, or wire brush
4	Prime the cutback area	4	Prime the cutback area
Move to coating station			Move to coating station
1	Preheat joint area to 150°F or 195°F <i>(typically this step requires 2-3 minutes)</i>	1	Close and clamp the wrap machine
2	Check for correct temperature on steel and coating	2	Adhere the leading edge of the RD6/OS to the joint
3	Install (position) sleeve	3	Turn the wrap machine 1½ revolutions
4	Heat the backing of the underlap	4	Cut the RD6 OS at the 9:00 position
5	Heat the adhesive of the overlap	5	Press down the 9:00 overlap and inspect the tape.
6	Heat the adhesive of the closure strip	6	Unclamp and remove the wrap machine
7	Press the closure into place		
8	Heat the closure and pat down. Repeat. Smooth wrinkles gently outward		
9	Heat the sleeve circumferentially		
10	Roll the closure firmly outwards from each side of the weld		
11	Visually inspect the sleeve		
12	Quench the sleeve		
12	Total steps required at coating station shrink sleeve	6	Total steps required at coating station RD6 OS

Typical elapsed time at coating station
4 – 5 minutes

Typical elapsed time at coating station
2 minutes