INSTALLATION INSTRUCTION FOR WELDED SEAM

Horizontal drilling kit shrink sleeve/ Fibertec

The horizontal drilling kit with high tech Fibertec material was specially developed to provide the corrosion protection of horizontal drillings. It comes complete with highly peel and shear resistant hot melt adhesives and, with the additional security of the Fibertec mat, affords exceptional protection for the pipe wrapping during the boring process, irrespective of whether only the outer wrapping or entire pipelines are to be safely protected. The horizontal drilling kit consists of a shrink-type sleeve and a precisely fitting Fibertec mat. The excess length of the mat of 950 mm brings the critical front part of the sleeve well ahead of the welded seam area.

Installation is easy and can also be carried out retrospectively. The shrink sleeve is applied in the conventional manner but must be preheated to a temperature of approx. 90°C. The Fibertec mat is then placed centrally around the sleeve and carefully pressed down. Curing is carried out by sunlight or with a UV lamp.

The combination of the corrosion protection system (approved in accordance with EN 12068/DIN 30672 C/750 DVGW) and a GRP protective mat (Fibertec) ensures the maximum mechanical load resistant capacity for horizontal drilling operations.

How to process Fibertec „Process only outdoors”

The length of the mat is calculated from the circumference of the pipe + approx. 50 mm overlap. Uncoated and dry edges must be trimmed off before installation. Roughen the sleeve and approx. 300 mm of the existing pipe-coating with emery cloth and dry the area to be glued. Pull off the coloured backing (pipe side) from the Fibertec mat. Pull off the upper transparent plastic sheet in the area of the overlap and place the mat centrally on the shrink-type sleeve.

Press down the mat with a roller.

Wind the transparent adhesive tape around the pipe (of whatever size) so as to achieve a flat join between the existing coating and the Fibertec. For pipe sizes up to ND 400, wind the clear tape tautly over the whole surface, in order to ensure that it is pressed tightly on to the pipe. After curing, the transparent sheet can be completely removed. The maximum processing time is 5 minutes in bright sunlight or 15 minutes under an overcast sky.
INSTALLATION INSTRUCTION FOR FULL COATING

How to process PSI Fibertec
„Process only outdoors“

The mat length is calculated as follows: Pipe circumference + about 50 mm overlap. Uncoated and dry edges have to be cut off prior to the assembly. Start the assembly at the opposite end of the drill hole so that the overlap edges of the Fibertec sleeves point towards the feed direction.

1. Use a cloth to remove any dirt or dust from the entire pipe envelope to be coated with Fibertec sleeves, dry the adhesive area and roughen it with emery cloth.

2. Remove the coloured film (pipe side) from the PSI Fibertec sleeve. Remove the transparent film from the top around the overlap and place the sleeve around the pipe. It is normal that the exterior film is partly difficult to remove; therefore, you have to proceed with reasonable care.

3. Carefully press against the mat with a roll. Make sure that the overlap is offset lengthwise (e.g. alternatively twelve o’clock and three o’clock).

4. Completely remove the transparent film. Then wrap the stretch film included in the delivery tightly around the entire surface of the PSI Fibertec sleeve in order to obtain a perfect contact pressure with regard to the pipe. The stretch film also serves as a weather shield during the curing process. You must leave 50mm at the end of the sleeve uncovered so that the next sleeve can be overlapped wet on wet.

5. Repeat steps 2 to 4 until the entire pipe is protected. Ensure at least 50 mm overlap from sleeve to sleeve.

6. If you interrupt the work, you have to protect at least 100 mm at the end of the Fibertec sleeve with a UV-impermeable tape. This way, the next sleeve can be overlapped once more wet on wet.

7. The stretch film can be removed completely after the curing process. The processing time amounts to 5 minutes max. when exposed to sunlight and 15 minutes max. with cloudy skies.
HOW TO PROCESS PSI FIBERTEC

Note:
The processor has to independently verify the use of PSI Fibertec for the respective application and the stress to be expected. Applicable DVGW rules have to be observed for the coating of pipes and subsequent coating systems in case of trenchless laying.

Storage and safety advice:
Avoid temperatures above +25°C and below +5°C, direct exposure to sunlight, rain, snow, dust or other unfavourable environmental influences. Processing must take place in compliance with the regionally decisive health and safety regulations.

Unser Tipp:
Cure the side turned away from the sun with a UV lamp. If the sky is overcast, cure the entire Fibertec mat with the UV lamp in order to shorten the thermosetting time.

Caution:
Boring must not take place until the Fibertec mat is fully cured (min. Shore D 80° ±5°).