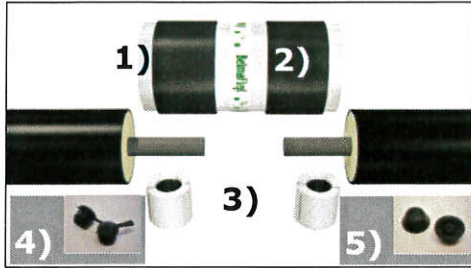
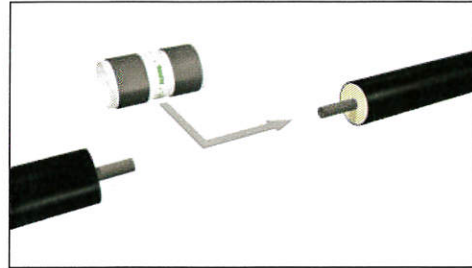
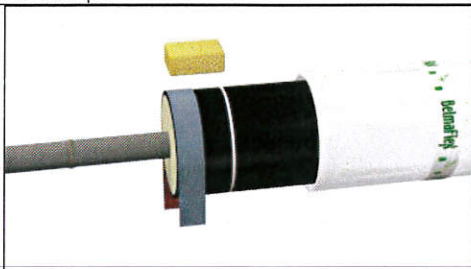


**DOUBLE SEALED JOINT FOR FOAMING**


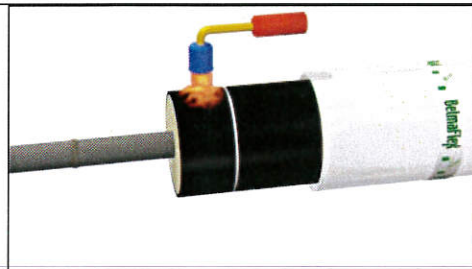
- 1) Shrink sleeve
- 2) Shrink collar
- 3) Mastic tape



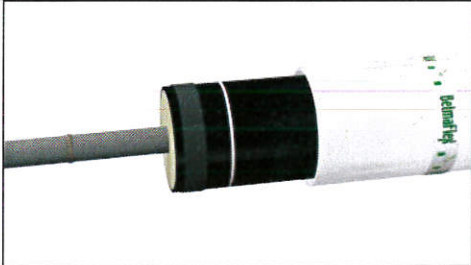
Place the shrink sleeve with the shrink collars on one end of the pipes. Connect the pipes. Pressure test, eventually



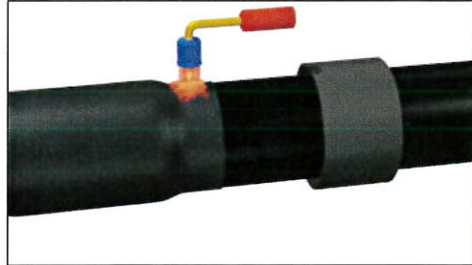
Remove insulation foam from around the pipe ends. Clean the jacket pipes at least 150 mm. from both pipe ends. The surface must be CLEAN and DRY.



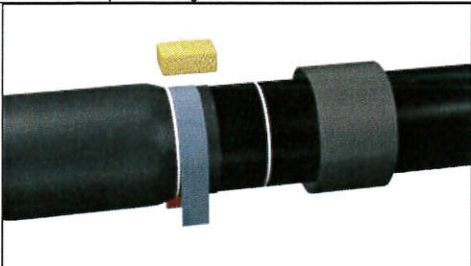
Pre-heat the jacket pipes at least 150 mm. from both sides of the pipe ends until the surface has a matt, silky look



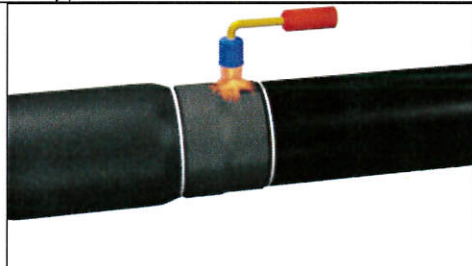
(if shrink sleeve is complete with mastic, pass to the next step)  
Install the mastic tapes around the jacket pipes approx. 20 mm. from the jacket pipe edges. Press the tape ends together.



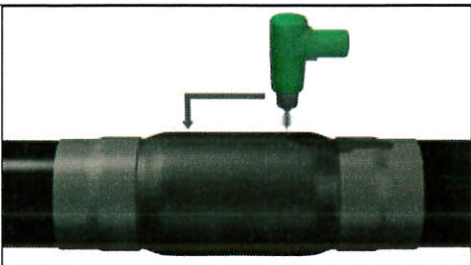
Remove the packing from the shrink sleeve. Check that the sleeve is CLEAN and DRY, inside and outside. Centre the shrink sleeve on the joint. Check that the sleeve is correctly positioned. Shrink the outermost 100 mm. at both ends.



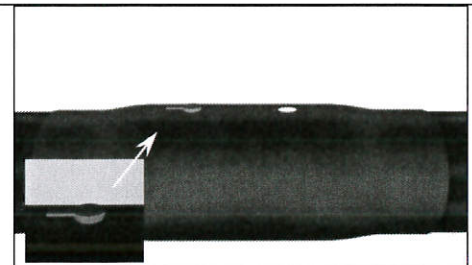
Clean the roughened surface to remove any polyethylene or sand particles, using a rag with alcohol.



Remove the packing and paper from the shrink collar. Check that all paper has been removed. Centre the collar on the shrink sleeve end and shrink the collar from the middle towards its sides. Repeat with the other shrink collar at the other end.



Drill a hole in the sleeve for the foam

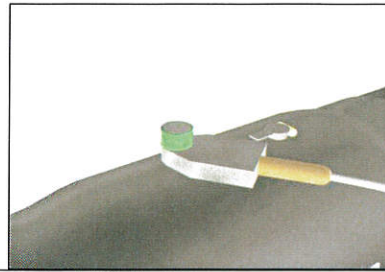
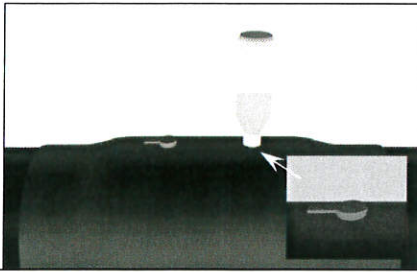


Install ventilation plug in one of the holes



# ECOLINE

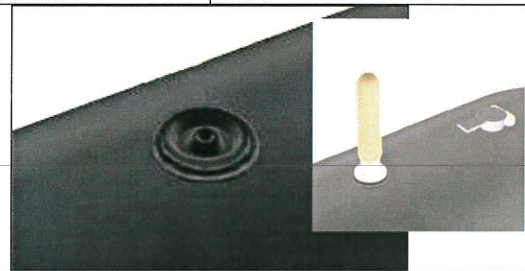
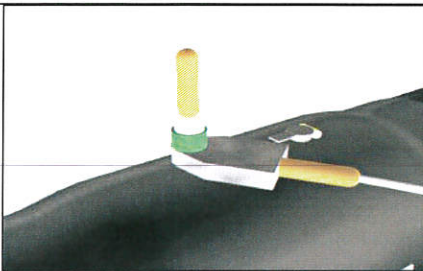
EUROPEAN COMPANY OF PRE-INSULATED PIPES



Foam the sleeve in the other hole. Install the other ventilation plug. Besides, we refer to the instructions for use of the foam supplier. Remember to clean the surface around the holes

Heat the welding tool up to 260°C ±10°C  
Heat the hole while the tool is pressed down.

Dimensioni guaina PEAD	Tempo di riscaldamento
066 + 125	10 sec.
140 + 200	20 sec.
225 + 315	30 sec.
355 + 500	40 sec.
560 + 630	50 sec.



Place the welding plug in the plug keeper.  
Press the welding plug downwards in the reflector, and heat the edge of the hole and the plug at the same time

When both parts are well heated, take away the reflector and press immediately the welding plug down in the hole. Press down until the welding plug flushes with the upper edge. Do not press further down. Press constant and soft for at least 1 min.  
There has to be 1 or 2 homogeneous welding beads around the welding plug. Do not take away the plug keeper till the surface is hand warm.  
Repeat the process with the other plug.



Check the joint.  
The joint is complete.