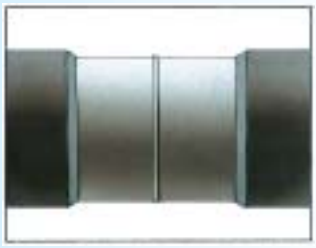
INSTALLATION INSTRUCTIONS FOR THE SLEEVE TYPE "MZA"

(D.V.G.W. APPROVED TO DIN 30672 / EN 12068 CLASS C-50)

Grit-blat the steel surface by projection of selected abrading materials to obtain a finishing standard Sa $2^{1}/_{2}$ according to ISO 8501-1.
Clean the steel surface from residual abrading material.

Smooth by hand-grinder surface irregularities as arc-burns etc.

Bevel the mill-coating edge with an angle of approx. 30°



Heat the steel surface and the adjacent overlap area of the mill-coating with propane torch (strong flame). In case of pipe size over 14" is recommended to operate with two workers.
Reach the uniform temperature of 100°C minimum.
The use of digital thermometers "fast reading", thermocromic chalks or other devices to check the temperature is recommended.

Take from the "kit" the gloves, applicator, stirring stick and sealed epoxy cans. Wear the protective gloves.

Open the can and pour the content of "B" (orange color, hardner) into "A" (white color, resin). Stir carefully the compound reaching homogeneous grey color.


Pour progressively the compound on the upper part of the pipe and – using the applicator pad supplied with the "kit" – smear on the steel surface. Be careful not to leave un-coated areas, not to apply the primer on the mill-coating and assure uniform application over the surface.


Unroll the sleeve and wrap over the pipe. Overlap the edges by approx. 10 cm. Be careful not to dirty the sleeve with contaminating materials as dust, sand etc.

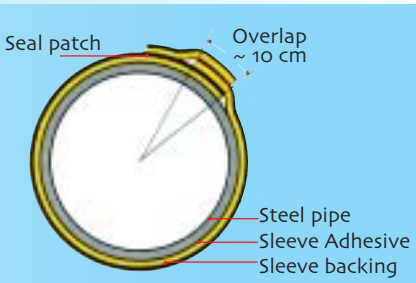

Activate sealpatch adhesive by gently heating the adhesivised side with the flame. Position and apply the sealpatch in the center part of the sleeve edge. Heat strongly and press on the entire lenght with gloved hand to assure good bonding.


Start to shrink the sleeve by heating from the central part and proceeding toward right and left side following the visible shrinkage of the material. Keep massaging the sleeve with gloved hand during the shrinkage to assist the expulsion of any intrapped air.

Roll (optional) the overlap area, sealpatch area and mill-coating overlap area. Heat gently duting rolling to keep adhesive fluid and workable. The coming-our of some adhesive from the edge of the sleeve proof the good execution of the installation.

Section of the coated joint showing the overlap area and the sealpatch.

ATTENTION: dispose the residual of the epoxy primer according to prescriptions in force.



Tip. Faentina Casanova - Faenza (2ips-installation-9/2003 - MZA)