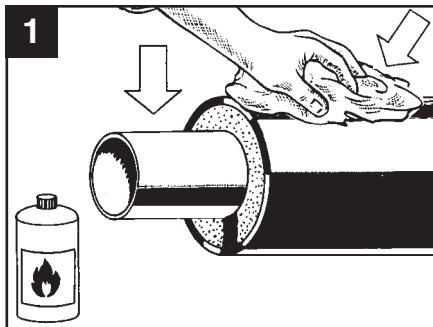




Material and equipment

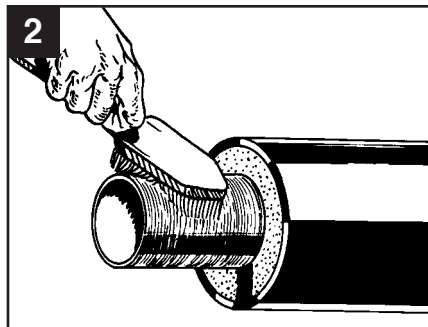
- Appropriate size DHEC end cap
- Propane gas bottle, regulator and gauge, hose and torch BN40
- Abrasive tape (grain 60-80) + steel brush
- PE cleaner + dry cleaning rags
- Gloves and safety goggles
- Standard safety equipment as prescribed by local regulations
- In case of rain use a tent or umbrella
- District Heating temperature stick



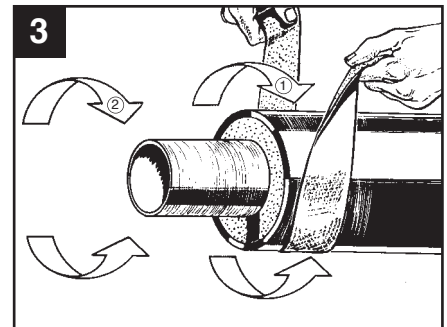
Preparation

The casing pipe and the service pipe must be dry and free of foreign materials such as oils, greases, foam, etc.

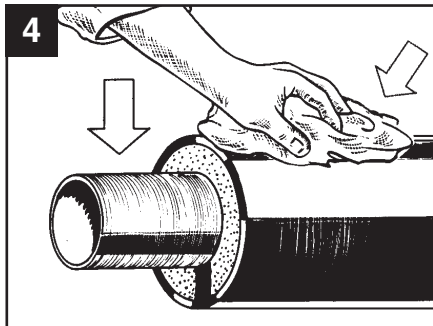
Note: If welding is done before installation, position the end caps away from the weld area. If necessary, protect the end cap against direct contact with the welding or brazing flame.



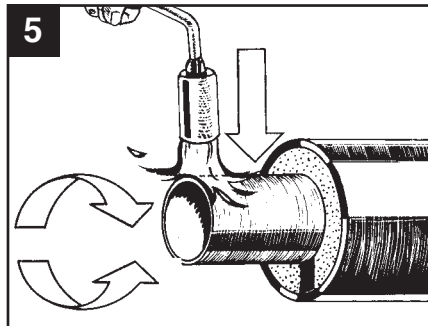
Remove all loose particles from casing pipe and service pipe. Deep scars in the casing pipe must be removed or scraped flat.



Firstly abrade the casing pipe using a fresh abrasive tape. Then abrade the service pipe to remove the contamination.

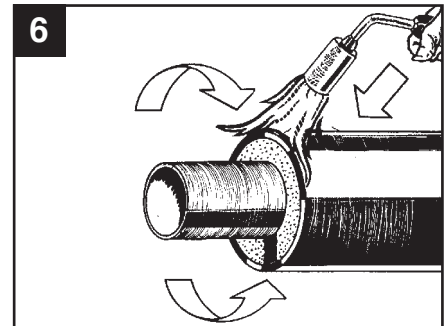


Remove all loose particles from abrading on casing pipe and service pipe with a dry and clean rag.

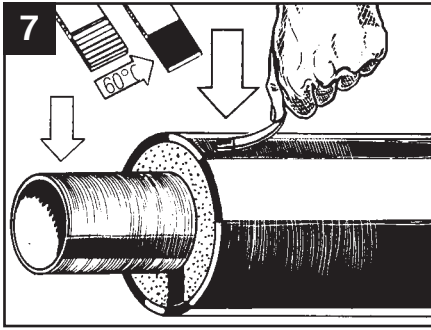


Pre-heating

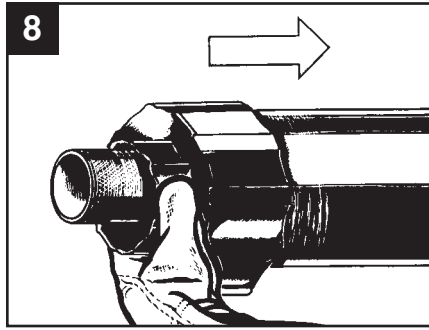
Preheat the service pipe first to 60°C minimum. Avoid direct contact between flame and foam.



Preheat the casing pipe to 60°C minimum.

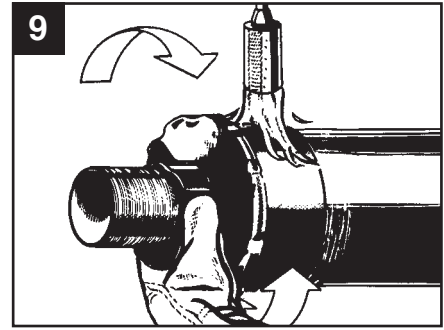


Check the temperature of casing pipe and service pipe with the temperature indicator. If you see an immediate color change, then the correct temperature has been reached.



Positioning

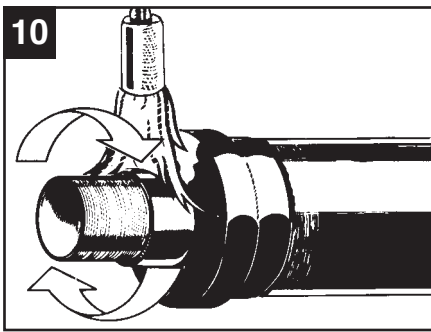
Position the end cap as far as possible over the pipe end.



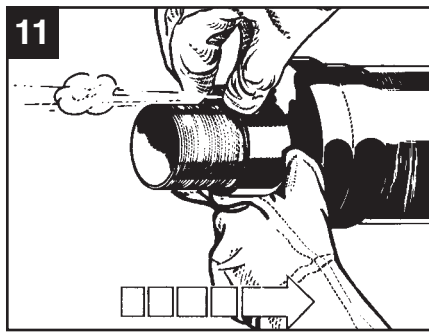
Installation

Start heating the end cap over the casing pipe first. Move the flame in circular motion around the pipe, until the end cap has fully recovered onto the casing pipe. Allow it to cool a little before shrinking the end cap over the step-down and the service pipe.

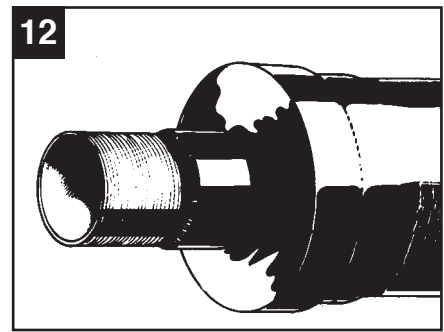
Note: If a second end cap has to be installed on the other pipe side of the welded joint, shrink it down first only on the casing pipe before proceeding with the next step.



Shrink the end cap over the step-down and onto the service pipe, keeping the flame moving around the pipe. Stop heating when the end cap has fully recovered and the appearance of the part has become totally smooth.



If necessary, squeeze the end cap together on the service pipe to relieve air entrapments. You can determine whether the adhesive has melted properly by carefully pushing the hot end cap a short distance along the service pipe. The small wrinkles which form, should pull themselves immediately flat again.



Inspection

The end cap should be fully recovered onto the casing pipe and service pipe without air entrapments. There should be no burn-holes or upstanding edges.

Berry Plastics warrants that the product conforms to its chemical and physical description and is appropriate for the use stated on the technical data sheet when used in compliance with Berry Plastics written instructions. Since many installation factors are beyond the control of Berry Plastics, the user shall determine the suitability of the products for the intended use and assume all risks and liabilities in connection herewith. Berry Plastics liability is stated in the standard terms and conditions of sale. Berry Plastics makes no other warranty either expressed or implied. All information contained in this technical data sheet is to be used as a guide and is subject to change without notice. This technical data sheet supersedes all previous data sheets on this product.

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