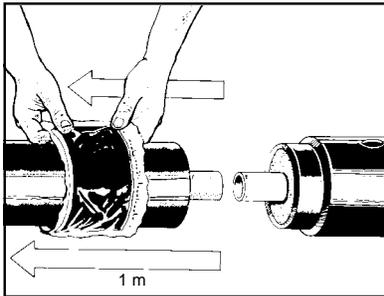




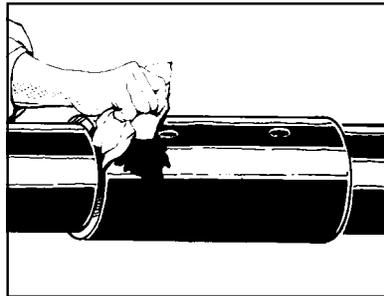
**Material and equipment**

- Appropriate size TPSM/138 sleeve
- Propane gas tank, regulator and gauge
- Raychem thermo-indicator
- Hose and Raychem torch (or equivalent)
- Safety equipment as prescribed by local regulations

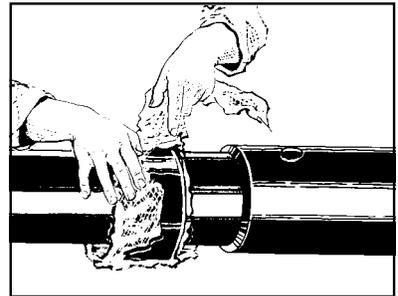


**Preparation**

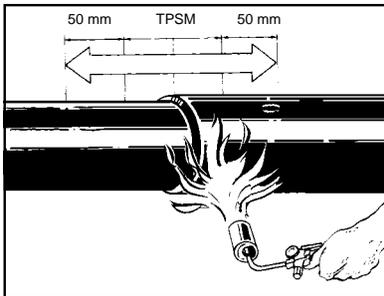
Before welding the service pipe, slide one sleeve over each pipe end and position about one meter away from the cutback area.



After the joint is foamed, jacket and casing areas should be dry and free of foreign materials such as oils, greases, dirt and excess polyurethane foam. To remove grease, use a cloth soaked with degreasing solvent. Follow the handling instructions given by the solvent supplier.

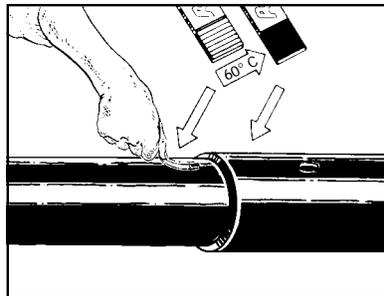


Remove the plastic bag from the sleeve. Do not remove the inside release liner yet.

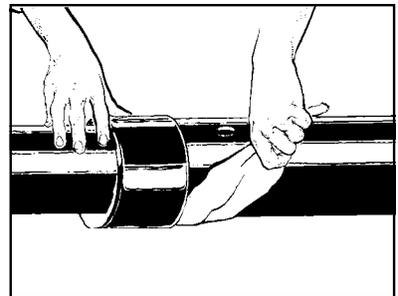


**Preheating**

Preheat oversized casing and jacket areas evenly to approximately 60°C using a soft flame. Let the heat penetrate well.



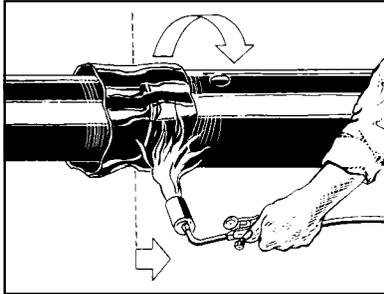
Check temperature with the Raychem thermo-indicator. An immediate color change indicates enough heat has been applied.



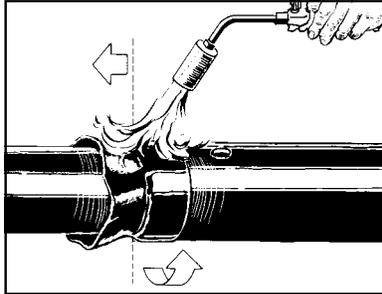
**Sleeve installation**

Center the sleeve over the casing end and remove the inner release liner.

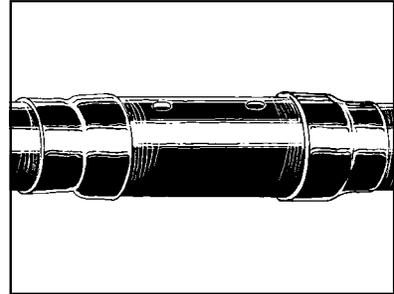
# TPSM\*/138



Using a steady yellow flame, shrink the sleeve in the center, starting at the top and gradually working downwards in a paintbrush motion. Work toward one end until the material has fully recovered and adhesive exudes from the sleeve end.



Repeat the process working toward the opposite end. Apply heat evenly around the sleeve, moving the flame constantly. Repeat the sequence for the other sleeve. Installation is finished when the sleeve is completely smooth and adhesive exudes at sleeve edges.



### Visual inspection

Sleeves will be smooth without upstanding edges, dimples or cold spots. Adhesive exudation will be evident along total circumference of the sleeves.

\* TPSM/138 and Raychem are trademarks of Tyco.

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