

GTS-65 (2-Layer)

Global Transmission Sleeve (Application Without Liquid Epoxy)

Product Description



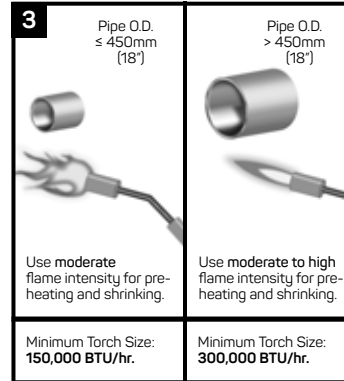
GTS-65 Global Transmission Sleeves are shipped pre-cut with a pre-attached closure. Bulk quantities are also available. The sleeve adhesive is protected from contamination by an inner liner.

Equipment List

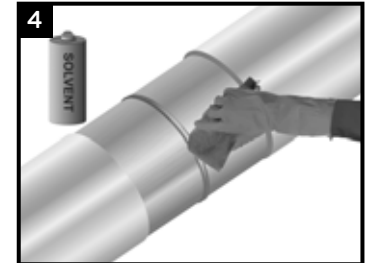


Propane tank, hose, torch & regulator, appropriate tools for surface abrasion, knife, roller, rags & Canusa approved solvent cleanser, digital thermometer with suitable probe, standard safety equipment: gloves, goggles, hard hat, etc.

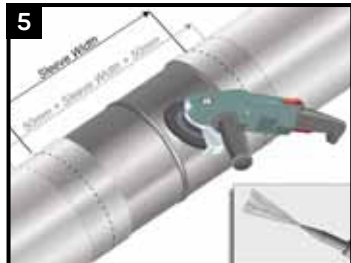
Flame Intensity & Torch Size



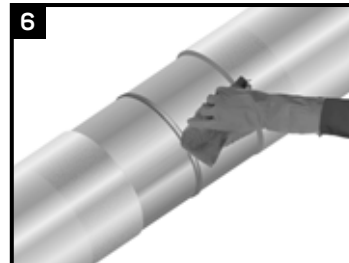
Surface Preparation



Ensure that the mainline coating edges are beveled to 30°. If there is the presence of oil, grease, or other surface contaminants; clean the exposed steel and adjacent pipe coating with a solvent cleanser.

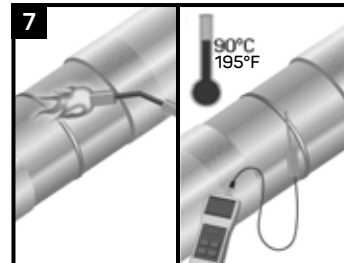


Ensure that the pipe is dry before cleaning. Using a power wire brush, abrade the pipe to a minimum of St3/SP3 (abrasive blast to Sa2.5/SP10 recommended). Lightly abrade the pipe coating adjacent to the cutback area to a distance of 50mm (2") beyond each end of the sleeve width.



Wipe clean or air blast the steel and coated areas to remove foreign materials.

Pre-Heat

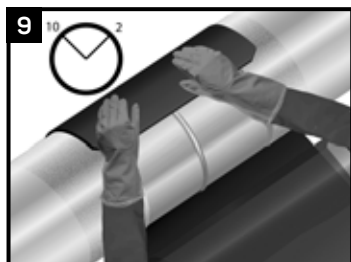


Pre-heat the joint area to $90^{\circ}\text{C} \pm 5^{\circ}$ ($195^{\circ}\text{F} \pm 10^{\circ}$) with the appropriate propane torch. Using a temperature measuring device, ensure that the correct temperature is reached on the steel and at least 50 mm (2") on each side of the sleeve width. Do not use an intense flame on the mainline coating.

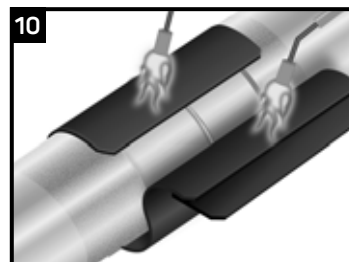
Sleeve Installation



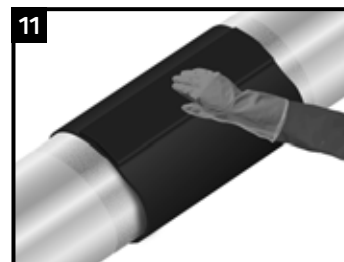
As an option, slightly trim corners of pre-attached closure. Partially remove the release liner and gently heat the underlap approximately 150 mm (6") from the edge.



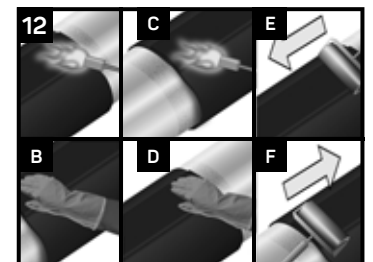
Centre the sleeve over the joint so that the sleeve overlaps between the 10 and 2 o'clock positions. Press the underlap firmly into place.



Remove the remaining release liner. Wrap the sleeve loosely around the pipe, ensuring the appropriate overlap. Gently heat the backing of the underlap and the adhesive side of the overlap.

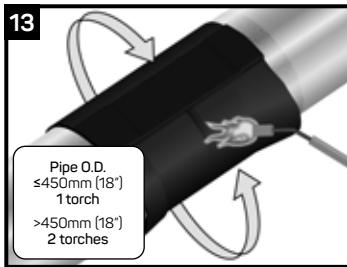


Press the closure firmly into place.

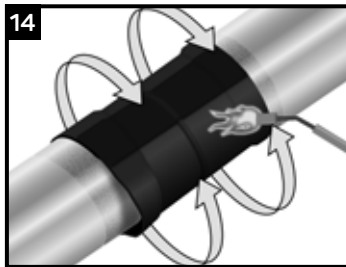


Gently heat the closure and pat it down with a gloved hand. Repeating this procedure, move from one side to the other. Smooth any wrinkles by gently working them outward from the centre of the closure with a roller.

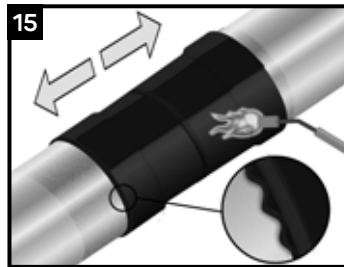
Sleeve Installation Cont'd



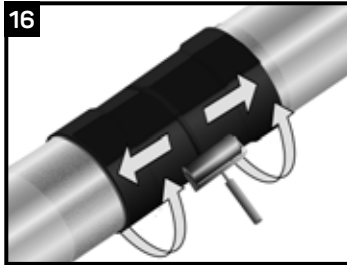
Using the appropriate sized torch, begin at the centre of the sleeve and heat circumferentially around the pipe. Use broad strokes. If utilizing two torches, operators should work on opposite sides of pipe.



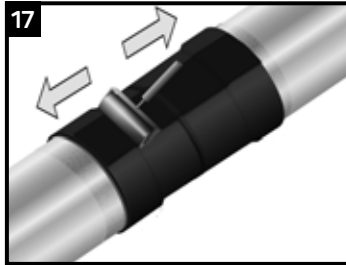
Continue heating from the centre toward one end of the sleeve until recovery is complete. In a similar manner, heat and shrink the remaining side.



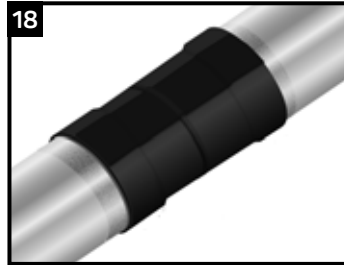
Shrinking has been completed when the adhesive begins to ooze at the sleeve edges all around the circumference. Finish shrinking the sleeve with long horizontal strokes over the entire surface to ensure a uniform bond.



While the sleeve is still hot and soft, use a hand roller to gently roll the sleeve surface and push any trapped air up and out of the sleeve, as shown above. If necessary, reheat to roll out air.



Continue the procedure by also firmly rolling the closure with long horizontal strokes from the weld outwards.



Inspection

Visually inspect the installed sleeve for the following:

- Sleeve is in full contact with the steel joint.
- Adhesive flows beyond both sleeve edges.
- No cracks or holes in sleeve backing.

Backfilling Guidelines

After shrinking is complete, allow the sleeve to cool for 2 hours prior to lowering and backfilling. To prevent damage to the sleeve, use selected backfill material, (no sharp stones or large particles) otherwise an extruded polyethylene mesh or other suitable shield should be used.

Storage & Safety Guidelines

To ensure maximum performance, store Canusa products in a dry, ventilated area. Keep products sealed in original cartons and avoid exposure to direct sunlight, rain, snow, dust or other adverse environmental elements. Avoid prolonged storage at temperatures above 35°C (95°F) or below -20°C (-4°F). Product installation should be done in accordance with local health and safety regulations.

These installation instructions are intended as a guide for standard products. Consult your Canusa representative for specific projects or unique applications.

Canusa-CPS A division of Shawcor Ltd.

Head Office

25 Bethridge Road
Toronto, ON, Canada M9W 1M7
Tel: +1 416 743 7111
Fax: +1 416 743 5927

Canada

Dome Tower St. 2200,
333-7th Avenue SW
Calgary, AB, Canada T2P 2Z1
Tel: +1 403 218 8207
Fax: +1 403 264 3649

Americas

5875 N. Sam Houston Pkwy W.,
Suite 200
Houston, TX, USA 77086
Tel: +1 281 886 2350
Fax: +1 281 886 2353

Middle East

Plot # 37-WR43, Sector no.: ICAD III
Musaffah South, PO Box 2621
Abu Dhabi, The United Arab Emirates
Tel: +971 2 204 9800

Europe, Africa & Russia

Dellaertweg 9-E, Gebouw
"Le Carrefour"
2316 WZ Leiden,
The Netherlands (NL)
Tel: +31 71 80 802 70
Fax: +31 71 80 802 71

Asia-Pacific

101 Thomson Road,
#11-03 United Square
307591 Singapore
Tel: +65 6749 8918
Fax: +65 6749 8919

Quality Management system registered to ISO 9001

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

Part No. 99060-038

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