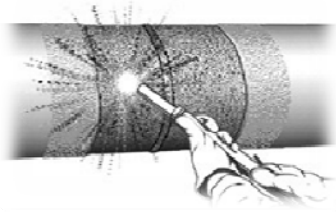


**DATA SHEET HS-3401HT60 (3 layer)**

Sleeve Operating temp	TEST METHOD	Typical Value
Pipeline Max Operating Temp		65°C (149°F)*
Minimum Installation Temp		65°C (149°F)*
Mainline Coating Compatibility		PE,PP,FBE
Total Thickness		2.2 ~ 3.2 mm
<b>Adhesive Properties</b>		
Softening Point	ASTM E28	105°C
Lap Shear @ 23°C	EN 12068	2.6 N/mm <sup>2</sup>
Lap Shear @ 60°C	EN 12068	0.3 N/mm <sup>2</sup>
Thickness		1.0 ~1.8 mm
<b>Backing Properties</b>		
Tensile Strength	ASTM D638	25 Mpa
Elongation	ASTM D638	400%
Hardness	ASTM D2240	55 Shore D
Volume Resistivity	ASTM D257	10 <sup>16</sup> ohm-Cm
Thickness		1.0 ~ 1.4 mm
<b>Sleeve Properties</b>		
Adhesion Strength @ 23°C	EN 12068	7 N/mm(Min)
Adhesion Strength @60°C	EN 12068	1 N/mm(Min)
Impact Resistance	EN 12068	>15 J
Indentation Resistance	EN 12068	0.8 mm (pass)
Cathodic Disbondment @ 23°C, 28 days	EN 12068	< 2.5 mm rad
Cathodic Disbondment @ 60°C, 28 days	EN 12068	< 7.0 mm rad
Low Temp. Flexibility	ASTM D2671-C	-25°C

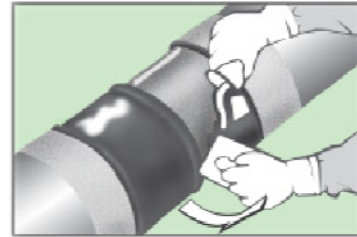
## Installation guide



Prepare the surface to be coated, according to SSPC-SP1, SP3 or SP6.



Use a propane torch to pre-heat the surface Min +65°C to Max +75°C



Mix the epoxy by 1(Cure) to 3(Base), apply mixed Epoxy Primer minimum 0.15mm thickness.



Cut corners at one sleeve end, remove release liner and gently



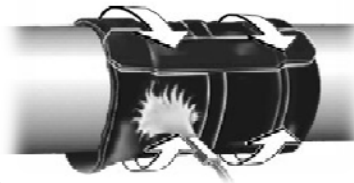
Center heated adhesive over the joints, overlaps at 10 o'clock position and press down firmly after remove of release liner.



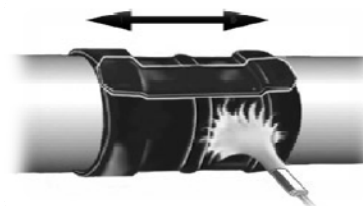
Gently heat backing of the under and the adhesive side of overlap. Press the overlap into place.



Fix the center of pre-heated Patch Closure on the overlap end to form a complete seal.



Start to heat the sleeve in the center, then around the pipe circumferentially.



Finish off by heating over the entire sleeve vertically to ensure a uniform adhesion.



Visual inspection to ensure that adhesive flow is at overlaps around, the edges and no crack or hole on

# Ordering Code

<p><b>CHA-16-18-BL</b></p>	<b>Standard Cut Sleeve</b>		
	Super Heavy Duty Thick.(S)	Heavy Duty Thick.(H)	Regular Thick.(R1)
	BL-Black, YE-Yellow		
	12", 18", 24" (300, 450, 600mm)		
	2" ~ 60" (DN50-1500)	2" ~ 60" (DN50-1500)	2" ~ 16" (DN50-400)
	A type : Hot Melt		B type : Mastic
	B : 1.2mm, A : 1.8mm	B : 1.0mm, A : 1.6mm	B : 0.75mm, A : 1.25mm
C-Cut Sleeve with Patch Closure			
<p><b>RHA-100-18-BL</b></p>	<b>Bulk Roll</b>		
	Super Heavy Duty Thick.(S)	Heavy Duty Thick.(H)	Regular Thick.(R1)
	BL-Black, YE-Yellow		
	12", 18", 24" (300, 450, 600mm)		
	100ft (30m)		
	A type : Hot Melt		B type : Mastic
	B : 1.2mm, A : 1.8mm	B : 1.0mm, A : 1.6mm	B : 0.75mm, A : 1.25mm
R-Bulk Roll			
<p><b>RPBA-50-12-BL</b></p>	<b>Bulk Roll Patch Closure</b>		
	Regular Thickness		
	BL-Black, YE-Yellow		
	12" (300mm), 18" (450mm)		
	50ft (15m)		
	1.2mm		
	RP-Bulk Roll Patch Closure		

\* Note: 1. Min. Sleeve Width=Bare Steel Width +2"(50mm) min. on each side of the pipe joint.  
 2. Various width, length and thickness are available for project requirements.

<b>Product Selection Guide</b>		
1.	Max Operation Temperature	65 °C
2.	Compatible Line Coating	PE,PP,FBE
3.	Min. Pre-heat Temperature	65 °C
4.	Recommended Pipe Preparation	SA2 ½ (SSPC-SP10)
5.	Soil Stress restrictions	Moderate