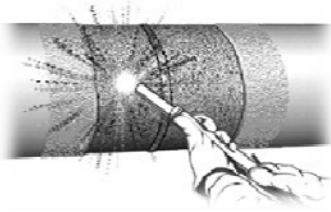


**DATA SHEET HS-3401HT80 (3 layer)**

Sleeve Operating temp	TEST METHOD	Typical Value
Pipeline Operating Temp		80°C (176°F)*
Minimum Installation Temp		80°C (176°F)*
Mainline Coating Compatibility		PE,PP,FBE
<b>Adhesive Properties</b>		
Softening Point	ASTM E28	118°C
Lap Shear @ 23°C	ISO 21809-3	350 N/cm2
Lap Shear @ 80°C	ISO 21809-3	8 N/cm2
<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
<b>Sleeve Properties</b>		
Adhesion Strength @ 23°C	ISO 21809-3	80 N/Cm
Adhesion Strength @80°C	ISO 21809-3	7 N/Cm
Impact Resistance	ISO 21809-3	>15 J
Indentation Resistance	ISO 21809-3	0.6 mm (pass)
Cathodic Disbondment @ 23°C, 28 days	EN 12068	< 2.6 mm rad
Cathodic Disbondment @ 80°C, 28 days	EN 12068	< 11 mm rad
Low Temp. Flexibility	ASTM D2671-C	--25°C

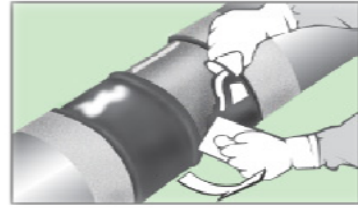
## Installation guide



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



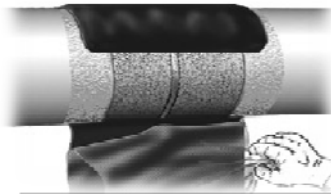
Use a propane torch to pre-heat the surface Min +80°C to Max +100°C



Mix the epoxy by 1(Cure) to 3(Base), apply mixed Epoxy Primer minimum 0.15mm thickness. on all exposed bare metal plus 10mm (0.5") onto the adjacent pipe coating using the applicator pads as supplied or an approved tool.



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



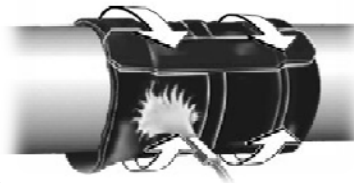
Center heated adhesive over the joints, overlaps at 10 o'clock position and press down firmly after remove of release liner



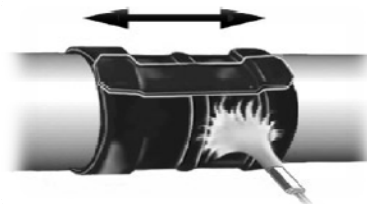
Gently heat backing of the under and the adhesive side of overlap. Press the overlap into place.



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. While heating, the embossed or dimpled pattern on the sheet surface should change to a smooth surface

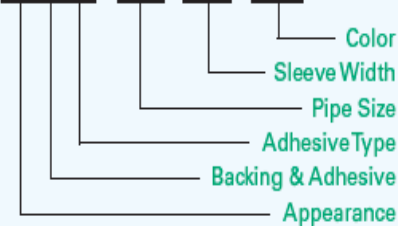
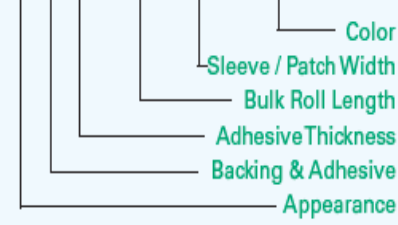
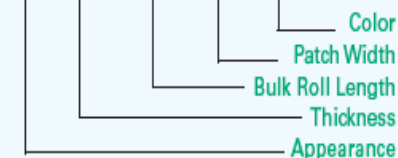


Finish off by heating over the entire sleeve vertically to ensure a uniform adhesion.



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

## Ordering Code

<b>CHA-16-18-BL</b> 	Standard Cut Sleeve		
	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			
<b>RHA-100-18-BL</b> 	Bulk Roll		
	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			
<b>RPBA-50-12-BL</b> 	Bulk Roll Patch Closure		
	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.

Product Selection Guide		
1.	Max Operation Temperature	85 °C
2.	Compatible Line Coating	PE,PP,FBE
3.	Min. Pre-heat Temperature	80 °C
4.	Recommended Pipe Preparation	SA2 ½ (SSPC-SP10)
5.	Soil Stress restrictions	Moderate