



**IN FIELD PEEL AND REPAIR PROCEDURE FOR
WATERWRAP SHRINK SLEEVE
ON THREE LAYER POLYETHYLENE
COATED PIPES**

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SCOPE

1. DESTRUCTIVE TESTING

1.1 Adhesive Peel Strength

2. REPAIR

2.1 PERP 60E Repair Procedure

2.2 Completed PERP 60E Installation

1. DESTRUCTIVE TESTING

1.1 Adhesive Peel Strength

- One out of every 50 sleeves or alternatively one out of a day production (whichever is lower) shall be subjected to a manual peel test.
- Peel strength inspection shall be done at a sleeve temperature of 23 °C, both the substrate and the sleeve shall be at this temperature.
- Strips of 25 mm x 200 mm shall be cut perpendicular to the pipe axis either at 9 or 3 o'clock positions as per DIN 30670 in the area between the circumferential weld bead and the mill coating and one over the mill coating.
- Manually remove the first 30-40 mm of the leading edge of the strip by using a screwdriver, make sure that the initial adhesive bond line cut is essentially centered within the adhesive layer.
- Attach the peel strength test gauge to the leading edge of the test strip and fasten clamp.
- Holding the test gauge with both hands exert a steady force at a slow pulling speed of 100 mm/min (4 inches/min), and under an angle of 90° to the circumference of the pipe.
- At this point the peel strength shall be greater than 250 N/25 mm or 142 pli, and the bulk of the adhesive shall remain on the pipe.

2. REPAIRS

2.1 PERP Repair Procedure

- Cut repair patch from a roll of PERP 60E at least 2 inch larger in each direction than the area to be repaired. Round off the PERP 60E corners.
- Lightly abrade the area all around the damaged or peeled area with a Scotchbrite pad or fine sand paper. Prepared area to be bigger than the patch to ensure that the patch is installed over an entirely roughened surface. Cut the loose peeled-off backing away.
- Cut the PERP filler S1137 to size and apply it to all areas till it becomes equal with the sleeve backing. Heat the mastic filler and smooth it down with a spatula.
- Preheat the damaged area with a propane torch with a gentle flame up to 70°C to 80°C.
- Preheat the inside of the repair patch with a propane flame until the adhesive becomes glossy and soft.
- While the adhesive is hot and soft, apply the patch centrally over the damaged or peeled area and heat until the adhesive melts. Check that the adhesive is soft to the touch with gloved finger.
- Carefully heat and roll the repair patch to eliminate air entrapments and ensure good bonding. Repeat this if necessary

2.2 Completed PERP 60E Installation

- There are no upstanding edges
- Visible adhesive flow at the edges.
- The PERP has fully conformed to the coating.