



Materials and equipment

1. Appropriate size WPC120 sleeve and WPCP IV closure
2. Propane torch
3. Propane gas tank, hose, regulator and gauge
4. Contact pyrometer
5. Hand roller (straight)

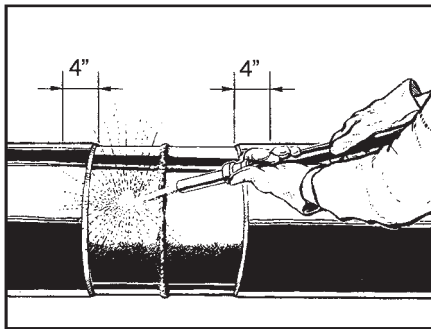
6. Standard safety equipment such as gloves, goggles, hard hat, etc.

Installation has to be done according to local government regulations and usual safety precautions.

Note:

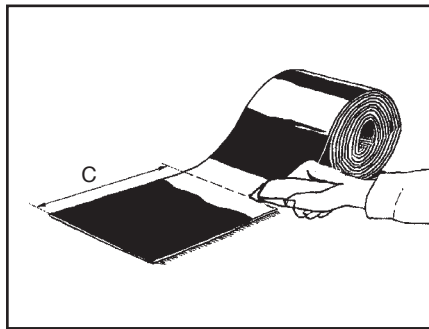
For sleeves 12"(300 mm) in diameter and larger, two people are needed.

For proper selection of joint protection materials, see Product Selection Guide or contact your local Sales Engineer.

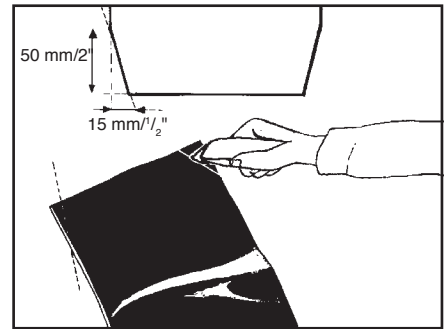


Joint cleaning

1. Weld area must be thoroughly cleaned with a grit blaster to a white metal finish, SIS Sa 2 1/2 or better. Adjacent line coating must also be gritblasted to a clean surface. The exposed steel and coated areas should be wiped clean of all foreign materials.

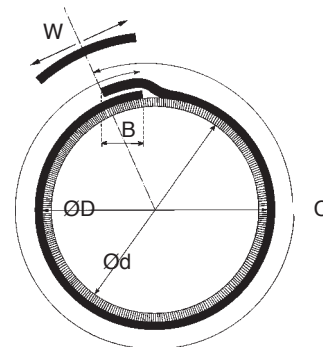


2. Cut the sleeve to the appropriate length according to below table.

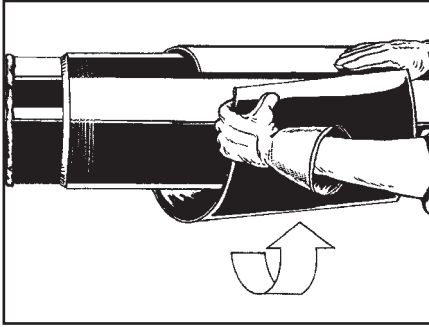


3. Cut the corners of the underlying end of the sleeve to approximately 1/2" x 2" (15 mm x 50 mm)

Ø D mils inches (0,001)	Ø d mm	C in./mm	B in./mm	W in./mm
3500	80	15/380	2/50	4/100
4500	100	19/485	2/50	4/100
5563	125	23/585	2/50	4/100
6625	150	27/685	2/50	4/100
8625	200	36/915	2/50	4/100
10750	250	44/1115	2/50	4/100
12750	300	50/1265	2/50	4/100
14000	350	55/1395	2/50	4/100
16000	400	62/1575	2/50	4/100
18000	450	68/1730	2/50	4/100
20000	500	75/1900	2/50	6/150
22000	550	81/2055	2/50	6/150
24000	600	87/2205	2/50	6/150
26000	650	95/2415	2/50	6/150
28000	700	102/2590	2/50	6/150
30000	750	107/2720	2/50	6/150
32000	800	114/2895	2/50	6/150
34000	850	121/3075	2/50	6/150
36000	900	127/3225	2/50	6/150
38000	950	134/3400	2/50	6/150
40000	1000	140/3555	2/50	6/150



WPC 120

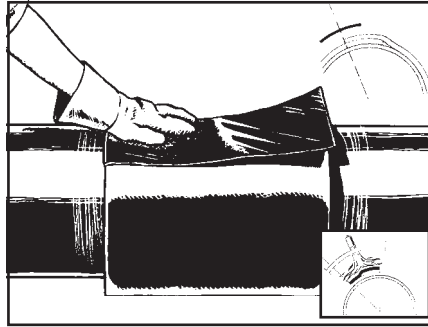


Sleeve assembly

1. Wrap the WPC120 sheet around the pipe about 1 meter away from the weld. The sheet should overlap the sheet (excluding closure) by 2" (50mm) minimum.

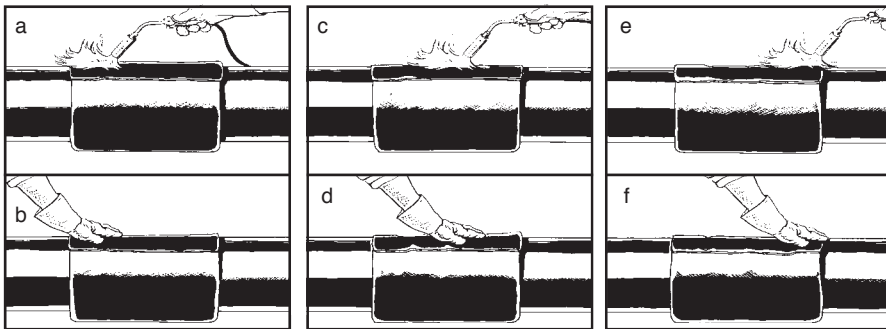
Note:

This will make a tube 2-3" (50-75 mm) larger than the pipe in diameter. Sheet end that comes over the top of the pipe should be on the top of overlap.



WPCP IV closure application

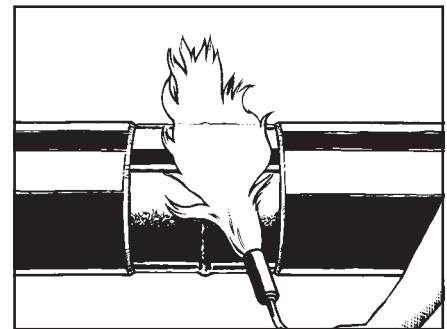
1. Press the WPCP IV closure in position, centering over the exposed sheet end. (For UNI-sleeve products, the closure is preattached and already centered in position.)



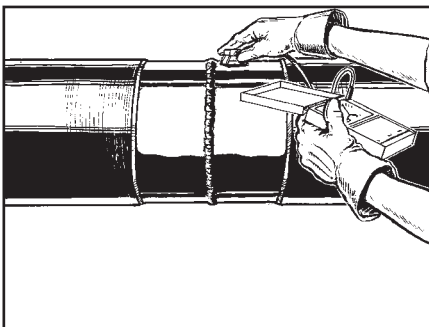
2. Using a torch, adjust flame length to approximately 20" (500 mm) to produce a yellow flame.

Using the yellow portion of the flame, heat the closure evenly until the pattern of the fabric reinforcement is visible.

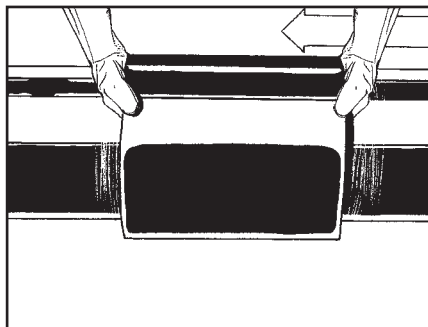
With gloved hand, pat down the closure and smooth any wrinkles by gently working them outward from the center of the closure.



3. Using a torch, evenly preheat the bare steel surface to a minimum of 445°F (230°C) but not higher than 500°F (265°C). Adjacent line coating must be heated to a minimum of 275°F (135°C). (When construction conditions require, the area may be preheated with a ring burner and protective blankets or an induction heater.)

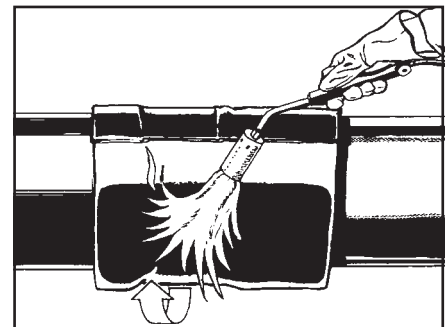


4. Using a pyrometer, ensure that proper preheat has been achieved. Wait 30 seconds after heating before verifying temperature to avoid incorrect temperature measurements.



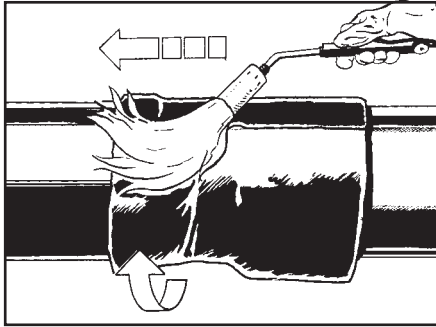
Sleeve recovery

1. Slide the sleeve over the joint area, centering it over the weld.

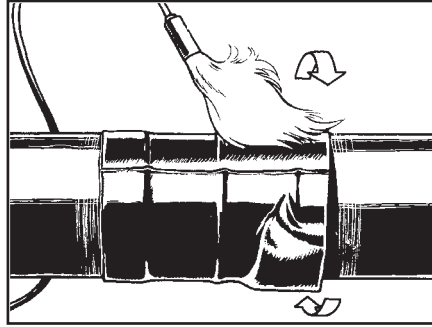


2. Using the torch, adjust flame length to approximately 20" (500 mm) to produce a yellow flame. Using the yellow portion of the flame, begin at the center of the sleeve and heat circumferentially around the pipe, using a constant paintbrush motion.

WPC 120



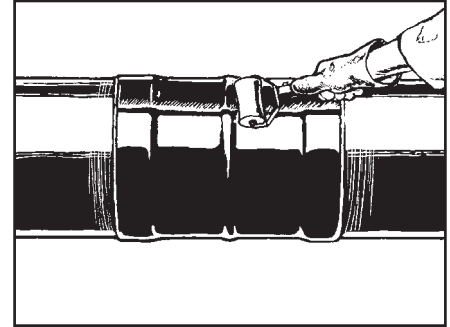
3. Continue heating toward one end of the sleeve, followed by the other.



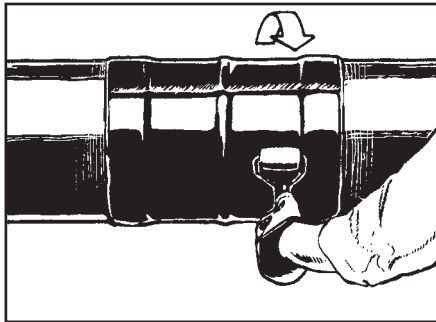
4. Continue shrinking until the sleeve is completely recovered and soft to the touch.

Note:

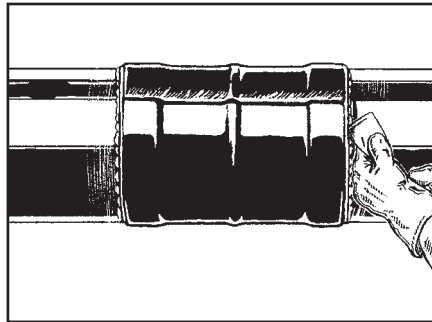
Sleeve may be recovered starting at one end and proceeding toward the opposite end, depending on conditions (i.e., wind).



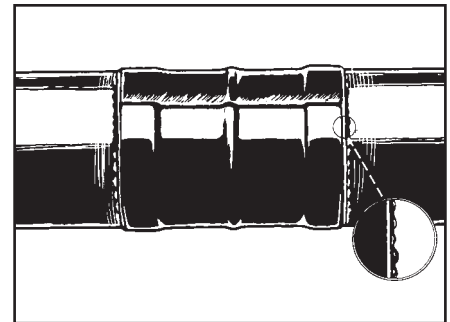
5. When the sleeve has been shrunk onto the joint area and is still hot and soft, run a small hand roller over the sleeve to push out any trapped air.



6. Particular attention should be paid to the weld and cut-back area. If necessary, areas may be reheated to roll out air.



7. When the sleeve has cooled, examine the edges for proper adhesion. Using a paintscraper, smooth the outcoming adhesive. A proper bond is achieved when the adhesive is well-bonded to the coating surface.



8. Sleeve is fully recovered when all of the following have occurred:

- 1) The sleeve has fully conformed to the pipe and adjacent coating.
- 2) There are no cold spots or dimples on the sleeve surface.
- 3) Weld bead profile can be seen through the sleeve.
- 4) After sleeve is cool, adhesive flow is evident on both edges.

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



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