GTS-65 (2-Layer)

Global Transmission Sleeve (Application Without Epoxy Primer)

Product Description

1

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.

Storage & Safety Guidelines

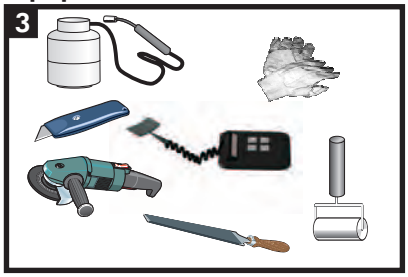
2

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.

Equipment List

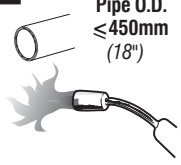
3



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.

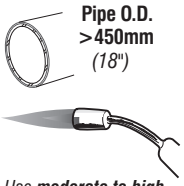
Flame Intensity & Torch Size

4



*Use **moderate** flame intensity for pre-heating and shrinking.*

Minimum Torch Size:
150,000 BTU/hr.

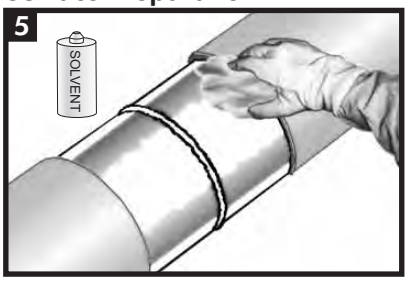


*Use **moderate to high** flame intensity for pre-heating and shrinking.*

Minimum Torch Size:
300,000 BTU/hr.

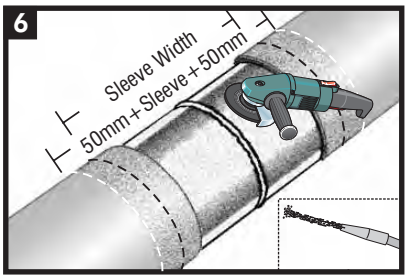
Surface Preparation

5



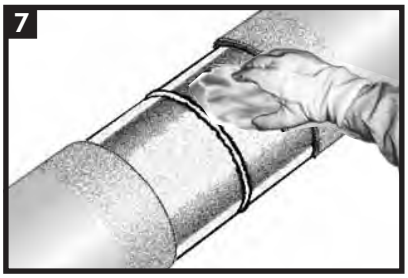
Ensure that the mainline coating edges are beveled to 30°. If there is the presence of oil, grease, or other surface contaminants; clean the exposed steel and adjacent pipe coating with a solvent cleanser.

6



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.

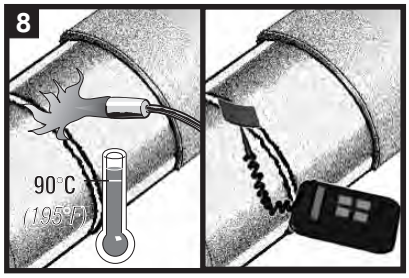
7



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

Pre-Heat

8



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

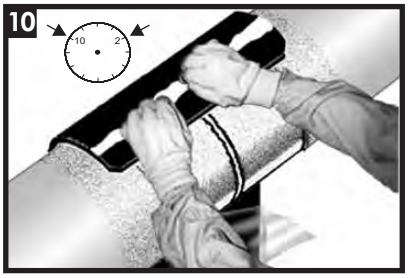
NOTE: USE WIND GUARDS DURING HEAVY WIND TO PROTECT THE FIELD JOINT FROM DEBRIS AND TO MAINTAIN EFFICIENT APPLICATION TIMES.

Sleeve Installation

9

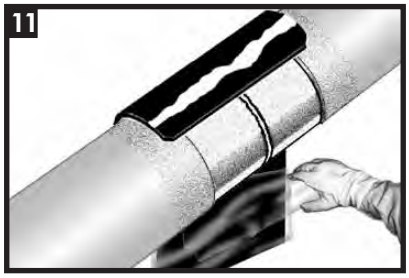
As an option, slightly trim corners of pre-attached closure. Partially remove the release liner and gently heat the underlap approximately 150 mm (6") from the edge.

10



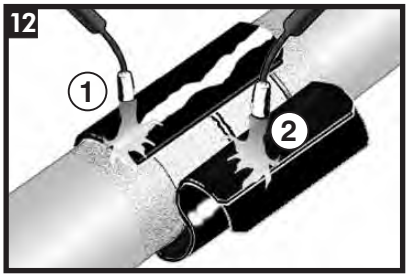
Centre the sleeve over the joint so that the sleeve overlaps between the 10 and 2 o'clock positions. Press the underlap firmly into place.

11



Remove the remaining release liner.

12



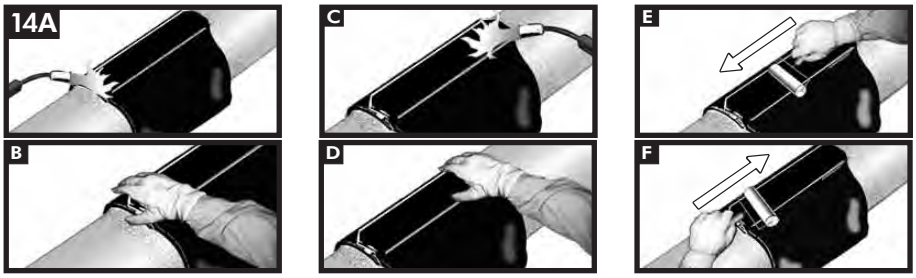
Wrap the sleeve loosely around the pipe, ensuring the appropriate overlap. Gently heat the backing of the underlap and the adhesive side of the overlap.

GTS-65 (2-Layer)

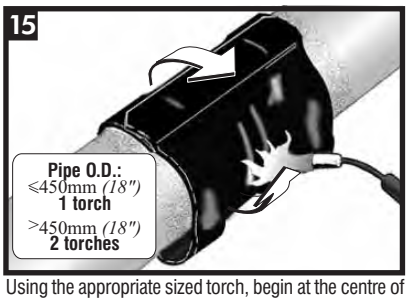
Global Transmission Sleeve (Application Without Epoxy Primer)

Sleeve Installation Cont'd

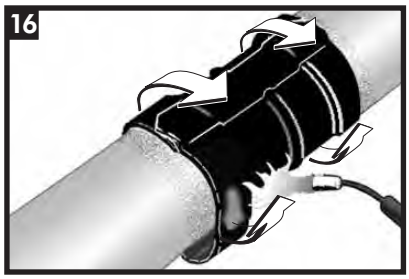
Press the closure firmly into place.



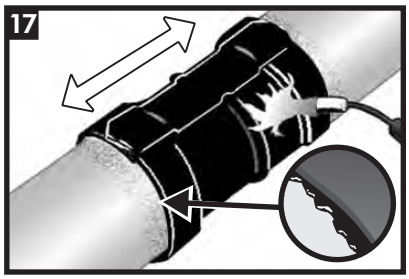
Gently heat the closure and pat it down with a gloved hand. Repeating this procedure, move from one side to the other. Smooth any wrinkles by gently working them outward from the centre of the closure with a roller.



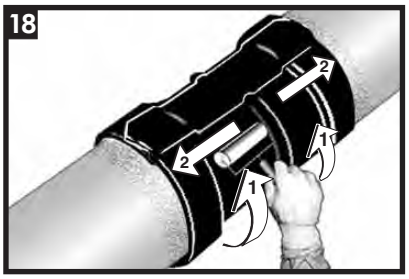
Using the appropriate sized torch, begin at the centre of the sleeve and heat circumferentially around the pipe. Use broad strokes. If utilizing two torches, operators should work on opposite sides of pipe.



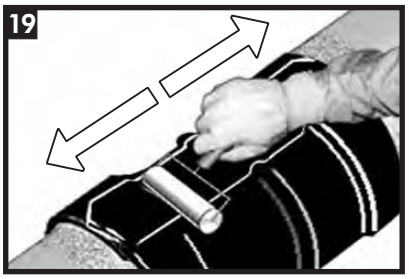
Continue heating from the centre toward one end of the sleeve until recovery is complete. In a similar manner, heat and shrink the remaining side.



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.

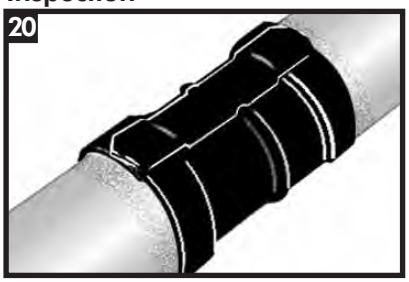


While the sleeve is still hot and soft, use a hand roller to gently roll the sleeve surface and push any trapped air up and out of the sleeve, as shown above. If necessary, reheat to roll out air.



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.

CANUSA-CPS
A ShawCor Company