

**Wrap-around Pipe Sleeve with Thermal Indicator**  
**Installation Instructions**

AG-WPCT-REV9-0309



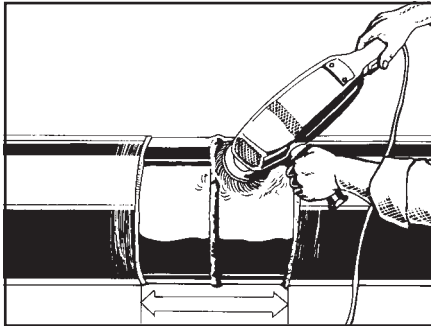
**Materials and equipment**

1. Appropriate size WPCT sleeve and WPCP IV closure patch
2. Torch
3. Propane gas tank, hose, regulator and gauge

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

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

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



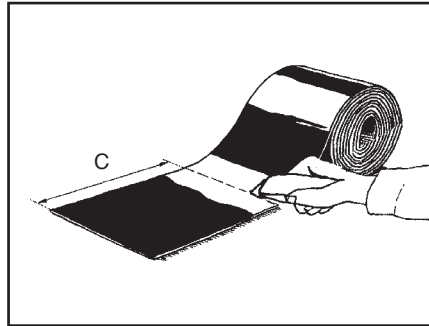
**Sleeve application**

1. Clean exposed steel and adjacent pipe coating to be covered by WPCT sleeve with a hand or power wire brush, to remove loose and foreign materials. Wiping may be necessary to remove the particles from cleaning.

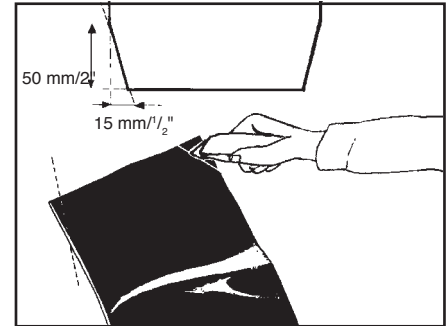
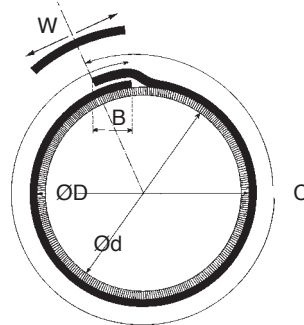
**Note:**

*Coal tar* - remove outer paper wrap 5" (125 mm) to 6" (150 mm) adjacent to cut-back to expose coal tar.

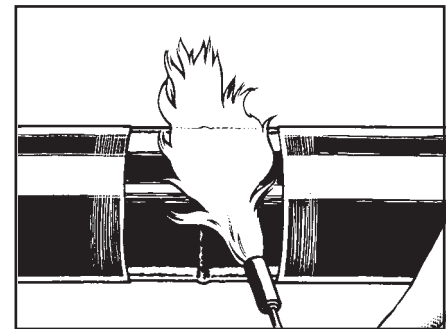
*Painted coatings* - remove whitewash paint on the surface of coating to be covered by WPCT sleeve.



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



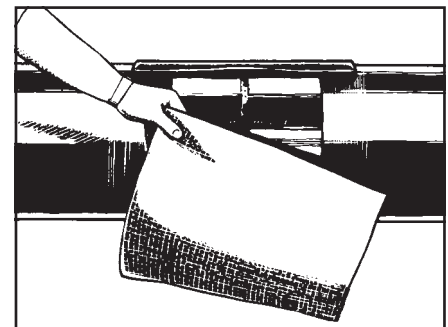
3. Cut the corners of the underlying end of the sleeve to approximately 1/2" x 2" (15 mm x 50 mm).



4. Preheat joint area until hot to the hand, approximately 140°F (60°C) minimum. Preheating reduces installation time and ensures proper bonding.

**Note:**

Two people working on opposite sides of the pipe are recommended for installing sleeves on pipe 16" (400 mm) in diameter and larger.



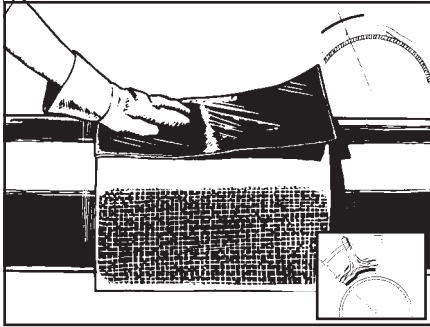
5. Remove the protective release plastic from the coated sleeve. Center sleeve over the weld so it is evenly overlapping adjacent pipe coating. Wrap loosely around pipe so that the logo runs around the pipe.

**Note:**

- 1) Clean overlap area of the sleeve to remove dirt and other foreign materials.
- 2) Edges of sleeve should extend 2" or more onto adjacent pipe coating.
- 3) Overlapping ends of sleeve should align evenly.
- 4) Position overlap to permit easy access for installing closure.

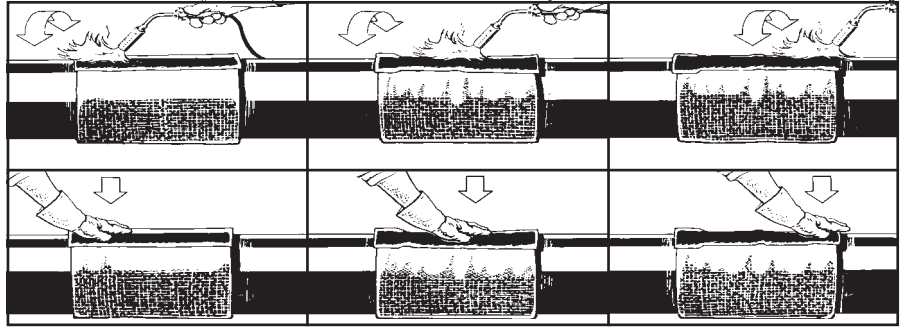
Ø D mils inches (0,001)	Ø d mm	C inches/mm	B in./mm	W in./mm
2375	50	12/305	2/50	4/100
2875	65	13/330	2/50	4/100
3500	80	15/380	2/50	4/100
4000	90	18/460	2/50	4/100
4500	100	18/460	2/50	4/100
5563	125	21,5/550	2/50	4/100
6625	150	25/640	2/50	4/100
8625	200	31,5/800	2/50	4/100
10750	250	38,5/980	2/50	4/100
12750	300	45,5/1150	2/50	4/100
14000	350	49,5/1260	2/50	4/100
16000	400	56/1420	2/50	4/100
18000	450	62,5/1590	2/50	4/100
20000	500	69,5/1770	2/50	6/150
22000	550	77/1950	2/50	6/150
24000	600	83/2110	2/50	6/150
26000	650	89,5/2270	2/50	6/150
28000	700	95,5/2430	2/50	6/150
30000	750	102,5/2600	2/50	6/150
32000	800	108,5/2760	2/50	6/150
34000	850	115,5/2930	2/50	6/150
36000	900	122/3100	2/50	6/150

# WPCT



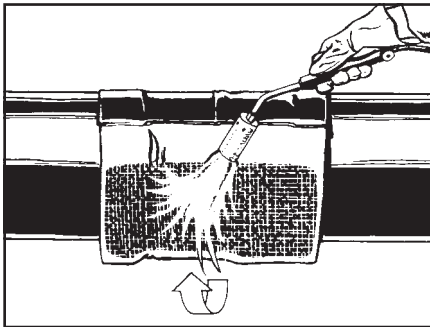
### WPCT IV closure application

1. Press WPCTIV closure in position, centering over the exposed sheet end. (For UNISLEEVE products, the closure is pre-attached and already centered in position.)  
The sheet should overlap the sheet (excluding closure) by 2" (50 mm) minimum.



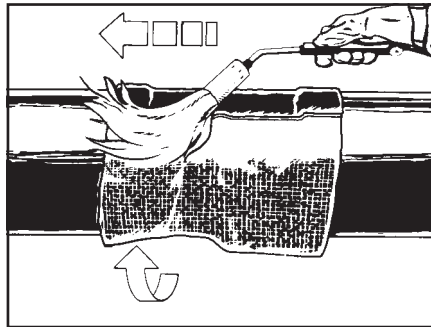
2. Using a torch, adjust flame length to approximately 20" (500 mm) to produce a blue tipped yellow flame. Using the yellow portion of the flame, heat the closure evenly until the pattern of the fabric reinforcement is visible.

With gloved hand, smooth any wrinkles by working outward from the center.



### Sleeve recovery

1. Using the torch, begin at the center of the sleeve and heat circumferentially around the pipe, using a constant paintbrush motion, until the embossed pattern on the sheet surface has changed to a smooth surface.



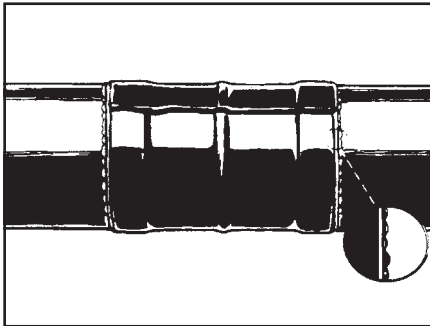
2. Continue heating toward one end of the sleeve, followed by the other.

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



3. During shrinkdown, occasionally check adhesive flow with a finger. Wrinkles should disappear automatically. Remember to wear gloves.

**Note:**  
While sleeve is hot, press or roll overlap and closure area to remove any air voids.



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

- 1) The WPCT sheet has a smooth surface.
- 2) There are no cold spots on the sleeve surface.
- 3) Weld bead profile can be seen through the sleeve.
- 4) After sleeve is cool, mastic flow is evident on both edges.
- 5) The sleeve has fully conformed to the pipe and adjacent coating.
- 6) The pattern on the backing has disappeared and the backing has a smooth surface.

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