**Heat Shrink Sleeve procedure:**

**Surface preparation:** Surface preparation shall be made as per following:

1. The pipe including fittings shall be cleaned from loose mill scale, rust, dirt, grease, moisture and other foreign materials. Surface preparation grade shall be equal to SSPC SP3 for pipes and SSPC SP2 for valves, flanges and fittings or more.
2. Remove the excessive weld sputter, slag sharp, edge, burrs and knurls by grinding wire brushing or other suitable method.

**Primer Application:** Primer shall be applied to clean bear pipe surface in accordance with following requirement.

1. The primer shall be applied to clean pipe surface in a uniform, thin, rapid dry film at coverage of approximately 13 square meter of pipe surface per a liter. This is accomplished by suitable hand brushing or other suitable method.
2. The pipe surface is externally coated and painted with primer to dry to the “ Tacky to Tacky”.

**Installation:**

1. Wrapped pipes shall be normally be installed on the sand bags or skids which have no sharp edge to prevent damage on wrapping face.
2. Wrapping pipe after testing shall not be handled or store in a manner to protect the wrapping from damage.
3. Wrapping pipe shall not be permitted contact sharp edge prior nor shall personnel be allowed to stand or walk on the wrapping line at any time.
4. Wrapping pipe shall be lifted lower or suspended by the use of rubber or canvas belt slings to prevent injury to the wrapping pipe. Use of ropes of any kind, hooks, chain or cables not be permitted