

# XCS

## Protective coating for cold conditions, including cold weather applications and rehabilitation of pipe coating

### Product Description



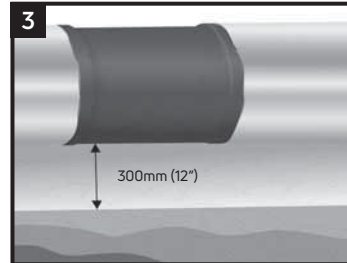
Canusa XCS Sleeves can be shipped pre-cut with a preattached closure, or as bulk rolls with separate closures. The adhesive is protected from contamination by an inner liner.

### Equipment List



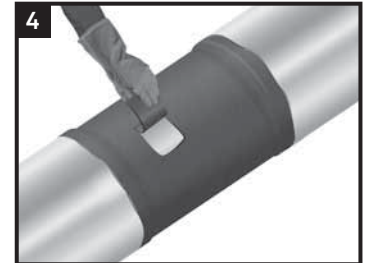
Propane tank, hose, torch & regulator; Appropriate tools for surface abrasion; Knife, roller, rags & approved solvent cleanser; Digital thermometer with suitable probe; Standard safety equipment; gloves, goggles, hard hat, etc.

### Pipeline Excavation



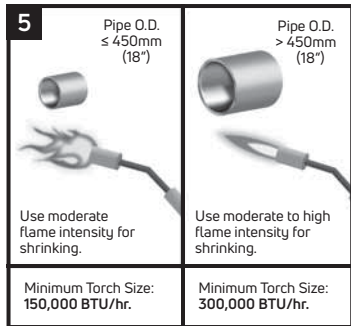
Pipeline must be excavated sufficiently to allow clearance for wrapping and recovering the sleeve. The recommended minimum clearance between bottom of the pipe and ditch should be 300mm (12"). All local regulations should be considered in regards to proper excavation.

### Existing Coating Removal

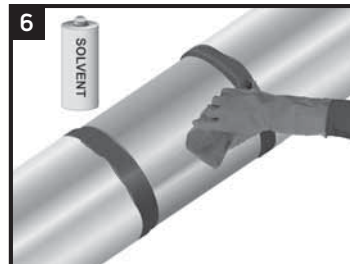


Manual coating removal, being labour intensive, may only be economical for shorter sections. Longer sections (> 1000 feet (304m)) may require automatic systems be considered.

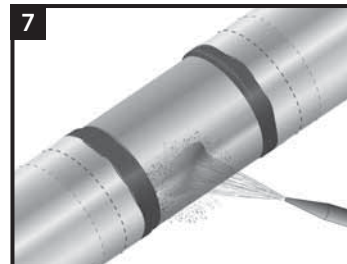
### Flame Intensity & Torch Size



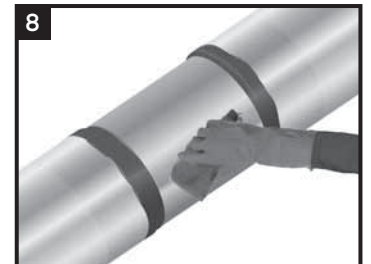
### Surface Preparation



Clean exposed steel and adjacent pipe coating with a solvent cleanser to remove the presence of oil, grease, and other contaminants.

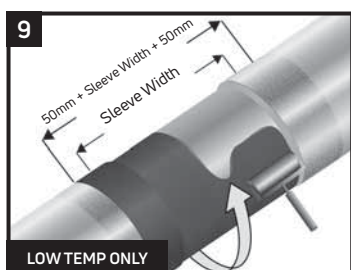


Ensure that the pipe is dry before cleaning. Prepare the steel joint area to a minimum of St3/SP3 (recommended Sa2½/SP10).



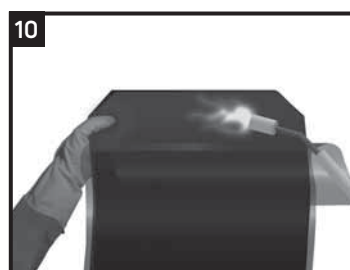
Wipe clean or air blast the steel and pipe coating to remove foreign contaminants.

### G Primer Application (Optional)

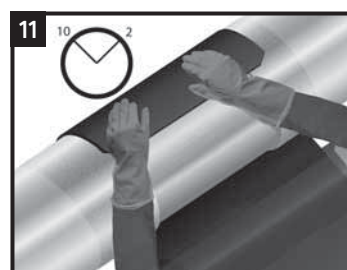


For low temperature installation -0°C (32°F) or when the operating temperature is below 10°C (50°F), use Canusa G Primer 1 US Gal. Stir the Canusa G Primer to ensure the liquid is well mixed before applying. Using a suitable roller or applicator pad, apply the Canusa G Primer to all exposed bare metal and the full width of the sleeve, plus 50mm (2") on each side. Ensure that the primer is applied as a uniform layer.

### Sleeve Installation

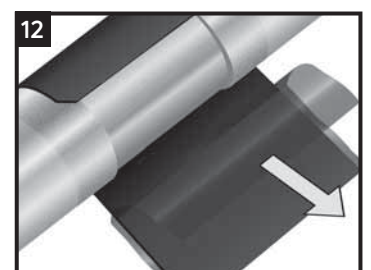


Partially remove the release liner and gently heat the underlap approximately 150mm (6") from the edge.

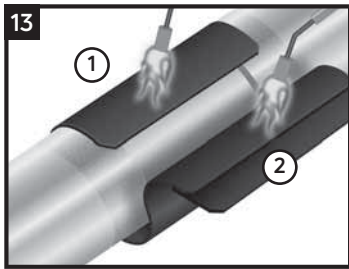


Centre the sleeve over the joint so that the sleeve overlaps between the 10 and 2 o'clock positions.

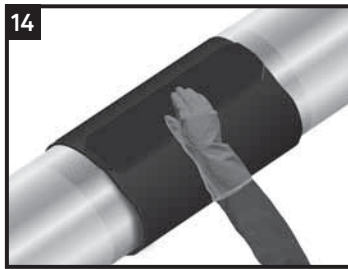
### Sleeve Installation Cont'd



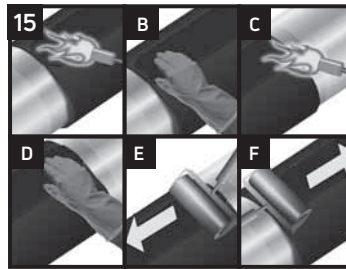
Remove the remaining release liner.



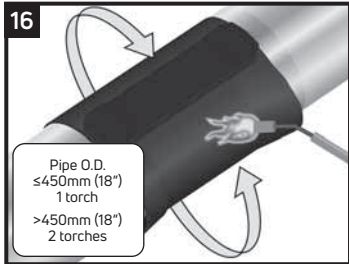
Wrap the sleeve loosely around the pipe, ensuring the appropriate overlap. Remove the remaining release liner from the hold-down strip tape on the underlap of the closure.



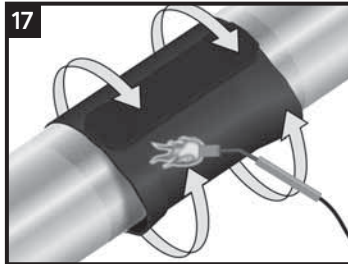
Press the closure firmly into place.



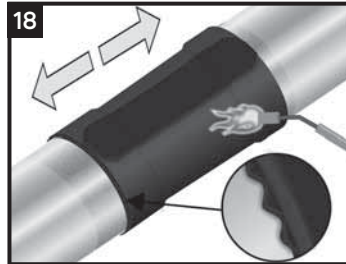
Gently heat the closure and pat it down with a gloved hand. Repeating this procedure, move from one side to the other. Smooth any wrinkles by gently working them outward from the centre of the closure with a roller.



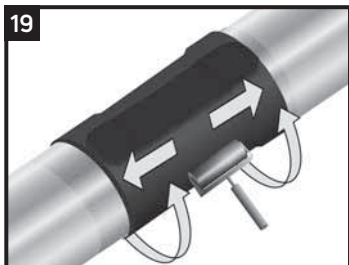
Using the appropriate torch, begin at the centre of the sleeve and heat circumferentially around the pipe. Use broad strokes. If utilizing two torches, operators should work on opposite sides of pipe.



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.



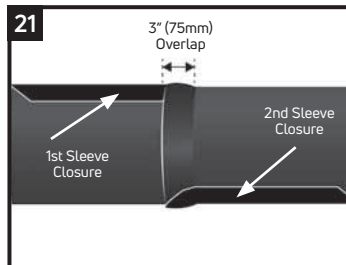
Shrinking has been completed when the adhesive begins to ooze at the sleeve edges all around the circumference. Finish shrinking the sleeve with long horizontal strokes over the entire surface to ensure a uniform bond.



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.



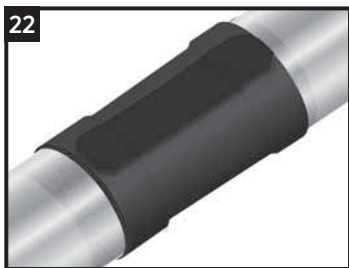
Continue the procedure by also firmly rolling the closure with long horizontal strokes from the weld outwards.



### Overlapping Sleeves (optional)

Wrap additional sleeves with a 3" (75mm) overlap and a staggered closure seal position. Recover sleeve starting at overlap of previously applied sleeve with two torches.

### Inspection



Visually inspect the installed sleeve for the following:

- 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.

### Storage & Safety Guidelines

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.

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 system registered to  
 ISO 9001

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

Part No. 99060-268

IG\_Rehab Sleeve - XCS\_rev012