THERMAFLEX ®

Instruction Leaflet

Insulation Coupler/Reducer PU

Insulation kit for insulating connections of all Flexalen® pre-insulated pipe systems on site

Design

Heat-shrinkable sleeves

2K PUR Set

Heat Shrinkable socket
with mastic inside at pipe ends

Ventilation - and Weld plug

Required Tools

Cleaner

Tissues

Emery cloth

Gas burner

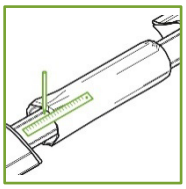
Tent (depending on
weather conditions)

Application Instruction

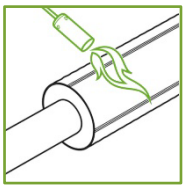
Application conditions and pipe preparation

- Ambient temperature: +5 to +40°C
- No rainy or windy (≥3 bfr / 3.4-5.4 m/s) weather conditions
- Service pipe and casing pipe are free from dirt and condensation

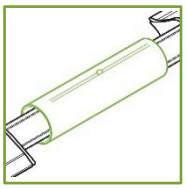
} use a tent to create correct conditions if required



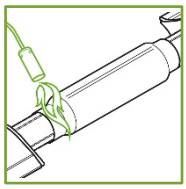
01.
Mark the length of the heat-shrinkable socket on the casing pipe. The minimum overlap should be 75mm. Clean casing pipe and grind with emery cloth.
Mark the position of the sliding socket on the casing pipe on both sides for proper positioning.



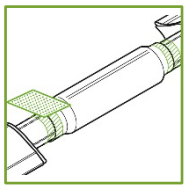
02.
Activate casing pipe with a quick "hard" flame (NOT applicable for Flexalen® 600 casing pipe).



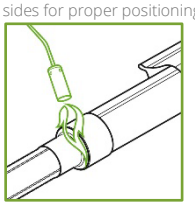
03.
Unpack shrinkable socket and center it over the joint. Make sure that the foaming hole is on top.



04.
Shrink the casing at both ends, with a soft yellow flame. Afterwards, the surface of the shrinkable socket should be soft, not burnt.

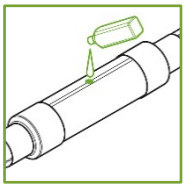


05.
Grind shrinkable socket with emery cloth.

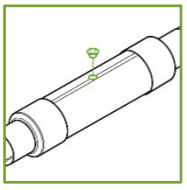


06.
Unpack sleeves and center them right above each edge transition shrinkable socket/casing pipe. Shrink it with a soft yellow flame from the middle towards the edges.

Note: Let the socket cool down (hand warm) before starting with foaming process.

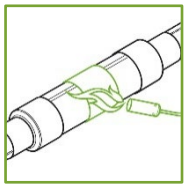


07.
Mix the 2K PU liquid components and shake mixture (time depending on temperature). Pour the foam in the pre-drilled foaming hole of the shrinkable socket. See separate instruction leaflet for 2k PUR foam Set for instruction on quantity and safety.



08.
Mount the ventilation plug. Let the foam react (at least 20min). Then remove the lip from the plug.

Attention: if weldable plug is used proceed with step 10 on the next page



09.
Grind the socket around the foaming hole / plug. Center the third heat shrinkable sleeve above it and shrink it with a soft yellow flame from the middle towards the edges.

Disclaimer
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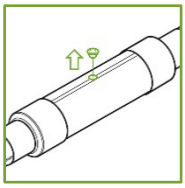
FOR WELDABLE PLUG PROCEED WITH THE INSTRUCTIONS BELOW, AFTER COMPLETING STEP 8:



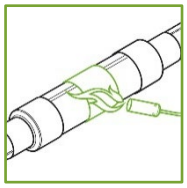
10.
When the foam has hardened, remove the ventilation plug. Attention: Do not damage the edge of the hole.

Remove the remaining foam and grind the area around the foaming hole (approx. Ø100mm).

11.
Screw the welding plug onto the handle of the heating element and temper the element to 250°C +/- 10°C. Pre-heat with a light pressure first the weldable plug for about 10 sec, then pre-heat both (Plug and casing) for the time needed to create a welding bead of approx. 1mm.

12.
When heating lips appear (approx. 1mm) on both the socket and the welding plug remove welding mirror. Press the welding plug (with care) into the foaming hole until welding lips appear on the socket and the plug.

13.
After approx. 1 minute the handle can be removed, and the welding plug is mounted.



14.
Grind the socket around the foaming hole / plug. Center a sleeve above it and shrink it with a soft yellow flame from the middle towards the edges.

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