

## GENERAL REQUIREMENTS

### REGARDING STAFF AND RULES IN ORDER TO PROPER ASSEMBLING OF THE PRE-INSULATED JOINTS

The assembling of the joints shall be performed exclusively by trained staff in respect to both, installation of the heat-shrinkable sleeves and thermal insulation of the joints. Proper and efficient installation of the heat-shrinkable joints, sleeves, collars, end-caps etc. requires to acknowledge and strictly follow instructions recommended by CEGA as well as to possess and use necessary materials and an equipment ie.:

- product adequate to diameter of the jacket pipe and/or carrier pipe;
- driller and reamer Ø24mm;
- welding unit for welding plugs;
- hammer for impaling the venting plugs;
- propane-butane gas burner BN40 (or similar) for diameters 90-315mm and BN60 for bigger diameters, gas tank, pressure reducer, connection hose;
- an abrasive canvas (granularity 40-60);
- an acetone or ethylic alcohol (90%) and cleaning cloth;
- protecting goggles and gloves;
- other protecting equipment required by law;
- an umbrella or tent in case of rain and/or snow and/or heavy sunshine;
- other necessary equipment and tools;

During hot days the foaming shall be performed in the morning hours, so the temperature of the PUR components shall not exceed 25°C.

**Foaming shall not be performed when the outside temperature is below 0°C.**

Before start of the junction encapsulation there shall be done as following:

- remove ca. 0,5-1cm of the foam from each end of the preinsulated pipe, however in a careful way to avoid damage of the alarm wires;
- clean the surface of the steel pipe (sand, mud), dry if necessary;
- check connections of the alarm wires, such a test shall be confirmed by the relevant protocol;
- the surface of the jacket pipe shall be degreased and carefully cleaned by the cloth, than it shall be tarnished by the abrasive canvas (granularity 40-60) and heated up by a gas burner to ca. 60°C;

**All encapsulation actions shall not be performed during rain, snow and/or humidity and/or heavy sunshine, unless a tent is used to cover a pipe junction.**

Before foaming the proper tightness of every joint shall be confirmed by the air pressure leakage test.