

## HDPE Heat Shrink Pipe

DS 921 E 0912



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Technical Data

**HDPE Heat Shrink Pipe for tight and longitudinal force locked connections.**

<b>Kind of Product</b>	Thick wall smooth coupler incl. mastic to connect all kind of pipe materials to each other or to other materials as e.g. HDPE, PP, steel, ductile iron
<b>Norm</b>	No norms available
<b>Sizes</b>	For pipe sizes ID 63,75,90,110,125,140,160,180,200,225,250,280,315,355,400,450,500,560,630,710,800, 900,1000,1200 mm Other sizes on request. Wall thickness 3.0 – 12.0 mm depending on coupler size.
<b>Standard Coupler Length</b>	Standard length 500, 600, 700 mm. Other length on request
<b>Material Properties</b>	Polyethylen acc ASTM D 3350 PE 344443 C with density of >0,94 g/cm <sup>3</sup> at 23°C, drifted and shrinkable. Tensile Strength acc ASTM D 638 of 24 MPa Special non toxic mastic nitrate free and chloride-free suitable for sensitive PT steel applications
<b>Colors</b>	HDPE black. Other colors on request.
<b>Product Properties</b>	Shrinkable with flame Shrinkage about 10% of initial ID size Longitudinal force locked connection with Peel Strength acc ASTM D 1000 of 50 N Pressure tightness on HDPE to HDPE and PP to PP pipe connection of 100 mbar without lost and 300 mbar with less than 7% lost within 5 minutes. Excellent corrosion protection properties Minimum fully recovered thickness of 2,5 mm after shrinkage
<b>Shrinking Operation</b>	In order to obtain best possible results the surface of the connecting materials have to be clean and dry. Dry weather conditions during shrinkage operation required of cause. Big coupler sizes and cold weather conditions effect longer heating period. For coupler sizes bigger 400 mm shrinkage operation with 2 persons should be considered. Heat Treatment is made using a soft flame licking the heat shrink coupler surface starting in the centre towards the edges unless the mastic will show up to leak out and the coupler will be tight-fitting. If possible to achieve, the flame should lick all around the coupler. The 'delay effect' will accumulate heat shrinkage still after finished heating. Let cool down the coupler to surrounding temperature before treatment. Avoid to fast heating noticeable by 'blue' glossy surface effect. Avoid 'waves' and 'lips' at the coupler ends resulting on too fast and too much heating.
<b>Fittings</b>	Heat Shrink Reductions and Heat Shrink End Caps available PESTEC Grout Ports suitable on Heat Shrink pipes
<b>Packing</b>	Each coupler supplied in protection foil
<b>Storage</b>	Storage temperature max 30°C for 90 days without major size reduction. Storage preferred indoor and in vertical position.
<b>Options</b>	Heat Shrink Sleeves for economical non longitudinal force locked applications

**Contact us for more details.**

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