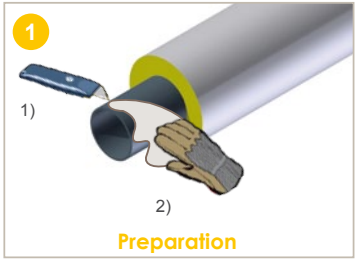
Composition of the i5 kit:

- 1 drilled end of line muff
- 1 steel cap
- 1 heat-shrinkable sleeve

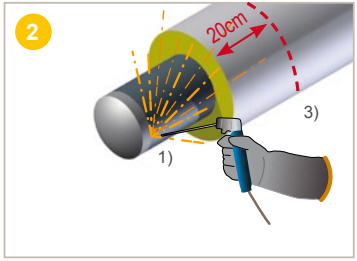
- 1 box of Polyol
- 1 box of Isocyanate
- 1 mixing spatula

- 1 vent plug
- 1 female closure plug
- 1 male closure plug
- 1 closure patch (FOPS)
- 1 weld-on plug

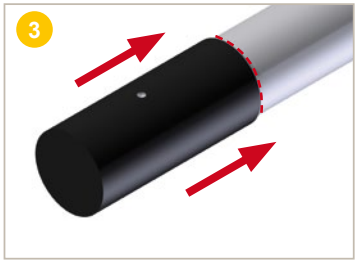
i5 Injected end of line kit



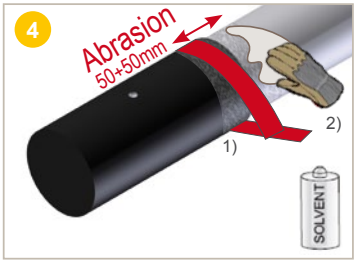
2) **Scrape** the PUR foam off the front (all signs of damp PUR foam must be removed from the ends).
3) **Clean** the ends of the pipes or parts with a cloth to remove any water, mud or sand.



1) **Weld** the steel cap.
2) Now **perform** a hydraulic pressure test on the network before insulating the end of the network.
3) **Draw** a line on the casing 20 cm away.
⚠ You are recommended to insulate ends of line in dry weather.

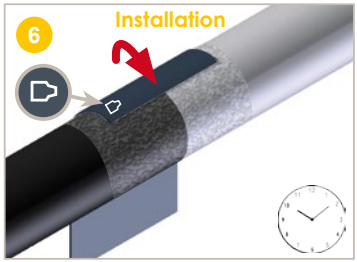


⚠ Make sure that the steel weld has cooled down before **sliding** the muff.
Slide the end of line muff at the stripped area so that it covers the pipe casing by **20 cm**.
⚠ The steel cap must not touch the muff.

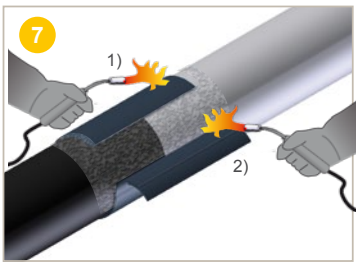


1) **Roughen** the surface (150 mm on each side) with abrasive paper or a wire brush.
2) **Clean** and degrease the roughened surfaces with a cloth dipped in ethanol (min. 94 %).

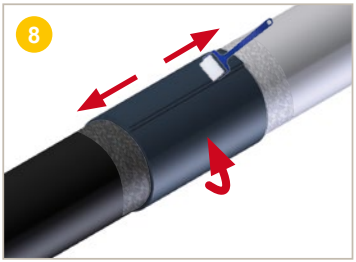
Use a blowtorch to **warm** the surfaces to be covered up to at least 65 °C.
Check the temperature on all surfaces with a thermometer.



Fit the heat-shrinkable sleeve on the joint so that the overlap lies between the 10 o'clock and 2 o'clock positions
Remember to remove its protective film.
⚠ **Respect the implementation direction using the indicator:** large diameter muff side, small diameter pipe side.



Leave 1 to 2 cm clearance to ensure correct shrinkage.
1) **Warm** the overlapping part of the heat-shrinkable sleeve slightly.
2) Then warm the adhesive of the other part of the sleeve called the "**adhesive patch**".



Press both ends of the heat-shrinkable sleeve firmly.
Remove the air bubbles with an application roller on the closure.

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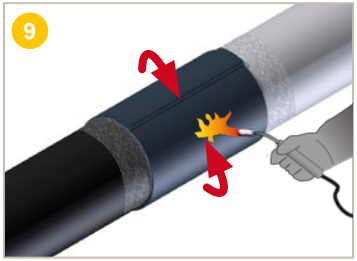

Shrink the heat-shrinkable sleeve around its circumference using large movements, starting at the centre.
Use a single blowtorch for diameters <= 450 mm and 2 blowtorches for diameters > 450 mm. If 2 blowtorches are used, use them on opposite sides of the pipe.

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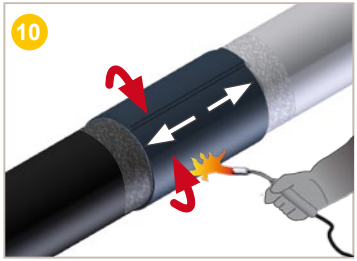

Continue heating starting from the centre and going towards the ends until shrinking is complete. Finish with horizontal movements over the whole surface of the sleeve.

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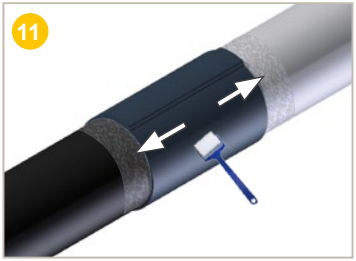

While the sleeve surface is still hot and malleable, use the application roller to **smooth and evacuate** the air bubbles.
Use the same procedure on the closure.

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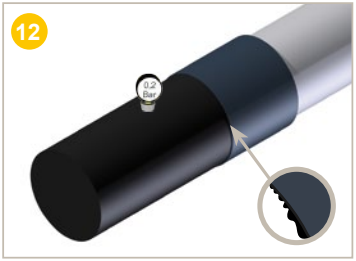

The system is correctly installed when:
• The sleeve is in contact with the surfaces to be protected and have no openings.
• The adhesive is visible on both ends of the sleeves.
• No holes or cracks are visible

13 **Recommendations :**

It is recommended to perform an airtightness test at 0.2 bar with a hand pump and pressure gauge. If this is impossible, make a visual check. It is essential to allow the materials to cool down to ambient temperature before injecting polyurethane foam. In case of doubt or if a fault is observed, remake the junction completely.

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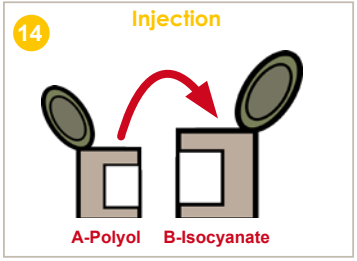

Take components **A** and **B** out of the kit boxes and check the diameters.
⚠ Check the kit use-by date. Pour component **A** into component **B**, **mix** together using the spatula supplied. The mixture is ready when it is homogeneous, with no signs of different colours.

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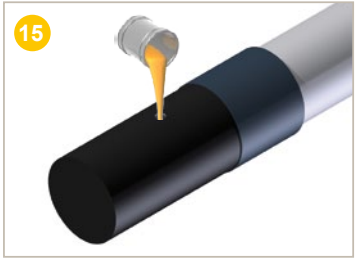

Pour the mixture into one of the 26 mm diameter HDPE end of line muff injection holes.
Make sure all of the mixture is removed, using the spatula supplied.

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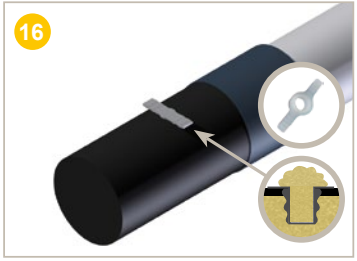
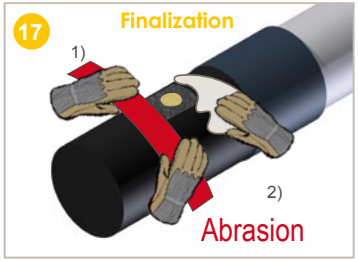


1) **Push** the vent plug fully into the injection hole.
2) As soon as the expanded mixture has hardened, remove the plug with the tab provided.
Clean off any excess PUR foam.

i5 Injected end of line kit

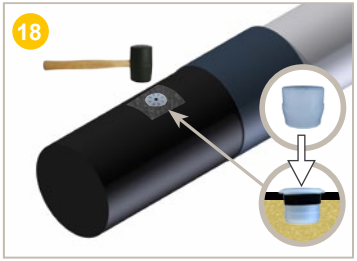


1) **Roughen** the surfaces to be covered (hole Ø + 50 mm on side) with abrasive paper or a wire brush.
2) **Clean** the roughened surface to remove any polyethylene or sand particles with a dry cloth (or blow off with the flame).

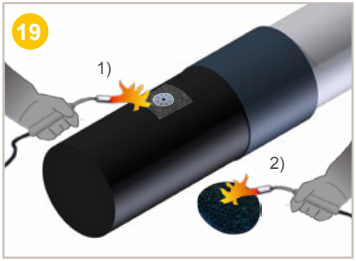
The system is correctly installed when:

• The entire closure patch (FOPS) is in contact with the surfaces to be protected.

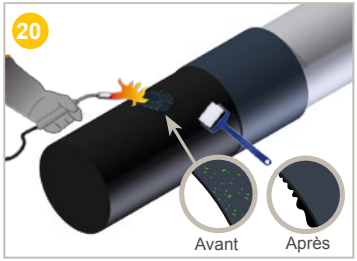
• The adhesive is visible all around the closure patch.



1) **Press** the female closure plug by hand fully into the HDPE muff injection hole.
2) Then knock the male closure **plug** into the female closure plug with a mallet.



1) Use a blowtorch to warm the surfaces to be covered (hole Ø + 50 mm on side) up to at least 65 °C. Check the temperature with a thermometer.
2) Heat slightly (2 to 3 seconds) the closure patch (FOPS) on the side opposite the coloured dots and then glue it onto the plug.



Finalise the bonding by warming until the coloured dots of the FOPS disappear
While the closure patch (FOPS) is still hot and malleable, use the application roller to **smooth** and **evacuate** the air bubbles.