



■ **Shrinkable Sleeve DK-HSS®80**

High temperature resistant heat shrink sleeve for corrosion protection of welded joints of steel pipes.



■ **COMPOSITION**

3-ply system.  
 2-component water-based epoxy resin - "Epoxy" part A-base and "Hardener" part B - hardener  
 The carrier film is a radiation-crosslinked polyethylene thermo-indicator tape.  
 The adhesive is a thermoplastic polymer.  
 The cuff lock is a co-extruded radiation-crosslinked polyethylene tape with thermoplastic polymer adhesive.  
 Black color.

■ **SPECIAL ADVANTAGES**

3-ply system, equivalent to factory-made 3-ply PE coating.  
 The system is designed for applications with minimal pipe preheating.  
 Fast assembly combined with high productivity.  
 Provides maximum protection against corrosion.  
 The pit backing provides easy post-heat control and can be checked at any time.  
 High adhesion characteristics.  
 Compatible with factory coatings made of PE, PP, FBE, PU, CTE and bitumen.  
 Complies with international standards DIN 12068 and AWWA C214.

■ **PRINCIPLE OF HEAT SHRINKING**

The heat-shrink sleeve consists of a carrier film made of extruded cross-linked polyolefin and an inner adhesive layer of thermoplastic material.  
 The system is designed for applications with minimal pipe preheating.  
 During installation, a 2-component epoxy is applied to the prepared pipe surface, then the heat shrink sleeve is immediately wrapped around the weld over the wet epoxy.  
 Heat is then applied to the cuff and the cuff contracts, forming a tight shrinkage around the weld.  
 When cured, the epoxy forms strong mechanical and chemical bonds with the pipe surface and the adhesive layer of the collar.  
 The radiation-crosslinked outer layer forms a strong barrier against mechanical damage and moisture penetration.

■ **AREA OF APPLICATION**



**Shrinkable Sleeve DK-HSS®80** is a proven solution for permanent protection of welded seams against corrosion. It is used when carrying out works on insulation and re-insulation of oil pipelines, water pipelines and gas pipelines.  
**Shrinkable Sleeve DK-HSS®80** is also an ideal choice for pipes with both small and large nominal sizes.

■ **RELATED PRODUCTS**

**Repairing System DK-PROTEC® (Filling mastic / Fusible rod / Repair patch)** - a system for repairing damage to anticorrosive coatings of pipelines.  
**Repairing System DK-PROTEC®** can be used without any special tools as a quick solution for repairing damage to corrosion resistant coatings of pipelines.

## ■ PRODUCT PROPERTIES

Properties	Unit	Shrinkable Sleeve DK-HSS®80	Test method
Thickness, at + 25 ° C	mm	2.9	ASTM D1000
Width, at + 25 ° C	mm	450±2 600±2	ASTM D 2369
Shore hardness at + 25 ° C	D	50	ASTM D 2240
Shock resistance, at + 25 ° C	J	15	EN 12068 Annex H
Adhesion to a primed steel surface and factory coating, not less: -at + 23 ° C -at + 80 ° C	N / mm	5.0 0.2	EN 12068 Annex C

*Other sizes and tolerances available on request*

## ■ APPLICATION TERMS

Properties	Unit	Shrinkable Sleeve DK-HSS®80	Test method
Surface condition of steel pipes: -cleaning level -degree of roughness	--- µm	Sa 2.5 50 - 100	ISO 8501-1 ISO 8503-1
Pipe surface temperature	°C (F°)	≥ +3°C (+5.4°F) above dew point	---
Temperature range: -application -operating	°C (F°)	+5 to +50 (+41 to +122) -20 to +60 (- 4 to +140)	Manufacturer's recommendation

## ■ CONTENTS OF DELIVERY

Shrinkable Sleeve DK-HSS®80		The cuff lock			Epoxy resin	
Pipe size in DN	Pipe circumference length, mm	Cuff length, mm	Overlap length, mm	Cuff and lock width, mm	"Epoxy" part A - base, mm	"Hardener" part B - hardener, mm
50	190	290	100	450	10.6	3.5
65	240	340	100		10.6	3.5
80	280	380	100		10.6	3.5
100	359	470	111		13.7	4.6
125	439	560	121		20.1	6.7
150	519	640	121		20.1	6.7
200	679	800	121		26.2	8.7
250	840	970	130		32.6	10.9
300	1000	1130	130		38.7	12.9
350	1117	1250	133		42.5	14.2
400	1276	1420	144		48.6	16.2
450	1436	1590	154		54.6	18.2
500	1595	1750	155		60.7	20.2
550	1755	1920	165		66.8	22.3
600	1914	2100	186	72.8	24.3	
650	2074	2260	186	78.9	26.3	
700	2233	2440	207	85.0	28.3	
750	2393	2600	207	91.1	30.4	
800	2552	2760	208	97.1	32.4	
900	2871	3100	229	109.3	36.4	
1000	3190	3430	240	121.4	40.5	

*Other lengths and widths available on request*

## ■ PACKAGING, STORAGE AND TRANSPORTATION

**Packaging:** metal / polymer / carton box, packing is non-refundable after use.

**Storage:** in original packaging, in a dry place without load in a horizontal position, in warehouses, open areas under a canopy, protected from sunlight and atmospheric precipitation. When storing **Shrinkable Sleeve DK-HSS®80** and transporting it to the work site, store and transport in a vertical position, no more than six rows - boxes with tape and three rows - containers with Epoxy & Hardener. Transportation and storage at a distance of at least 1 m from heat sources.

Shelf life in original packaging is at least 36 months from the date of manufacture.

Storage temperature: ≤ +50°C (+122°F)

**Transportation:** on pallets, in original packaging, by all means of transport.

## ■ Consult with us for specific projects or unique applications

The product information shown here our application recommendations and other product related documents are made for your convenience only. 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.

All information contained in this document is to be used as a guide and does not constitute a warranty of specification. The information contained in the document is subject to change without notice.

For this reason, no liability can be accepted for inaccurate advice or any failure to provide advice.

The user is responsible for checking the applications of the product and verifying its suitability for the intended use.

This is the original translation of product information from the Polish language.

In case of any discrepancy or any dispute arising on the interpretation of this product information, the Polish text of the respective Polish product information, which is available at [www.dkd-korporation.com](http://www.dkd-korporation.com), shall be decisive.

The legal relationship shall be governed by Polish law.



**DKDK INDUSTRIAL CORPORATION**

DKDK INDUSTRIAL CORPORATION  
ul. Grzybowska 87  
00-844 Warszawa, Polska  
tel.: +48 539 980 916  
info@dkdk-corporation.com  
www.dkd-korporation.com