

# STUART LEAK REPAIR (SLR) APPLICATION INSTRUCTIONS

Stuart Leak Repair is designed to seal low pressure leaks (up to 5 psi) and prevent corrosion on steel gas distribution lines. Read these instructions thoroughly before applying product to insure proper application.

You will need the following parts:

- Densyl Mastic
- Duct Tape
- WLOX Shrink Sleeve
- Closure Seal (CLH)
- Finger Skirting\*- if applying sleeve over coupling
- Wide Mouth Propane Torch
- Propane Bottle with proper Regulator & Fittings

**Step 1:** Thoroughly clean section of pipe to be coated removing all dirt, mill scale, oils, grease, rust, water, dust and foreign matter



**Step 2:** Plug hole with Densyl Mastic and overlap hole area by 1/2".



**Step 3:** Tightly wrap duct tape several times around pipe to insure mastic stops the leak and check for leaks with soap



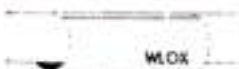
**Step 4:** Apply heat to entire area which will be covered by sleeve. Avoid burning duct tape and pipe coating. Use only enough heat to dry the pipe and insure it is heated to 140° F. **NOTE-** Move torch quickly and constantly.



**Step 5:** Check to be sure sleeve is at least 4" longer than the circumference of pipe OD. **See note on second page if applying sleeve over coupling.** Remove separator sheet from WLOX sleeve.



**Step 6:** Wrap sleeve around pipe



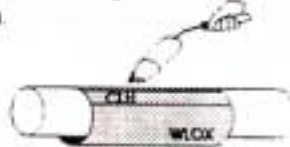
**Step 7:** Secure sleeve temporarily by lightly heating mastic and sleeve backing at overlap area.



**Step 8:** Overlap sleeve and press down.



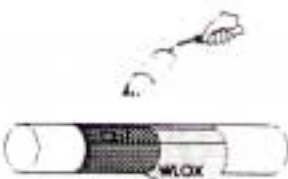
**Step 9:** Remove separator from Closure Seal (CLH) and lightly heat CLH adhesive. Center CLH over the overlap area. Heat back of CLH and press down onto sleeve. Note- Be sure the length of Closure Seal is the same as sleeve width.



**Step 10:** Apply heat to center part of sleeve moving torch swiftly and circumferentially around the pipe. You will see the sleeve start to shrink.



**Step 11:** When center of sleeve has conformed to pipe, move torch circumferentially around pipe toward one end.



**DIRECTIONS CONTINUED ON BACK**

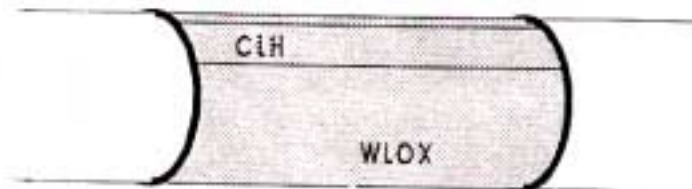
**Step 12:** When center and one end of sleeve has conformed to pipe, move torch circumferentially around pipe toward other end.



**Step 13:** Flash entire area of sleeve surface one last time to ensure sleeve thoroughly conforms to pipe irregularities and has full recovery potential. When done, you should see at least 1/8" of black mastic "oozing" out around edges of sleeve eliminating potential of "water channel". See finished illustration below.

**Application Tips:** To avoid burning sleeve, move torch quickly and constantly. The area of sleeve will continue shrinking even after the flame has been redirected. Keep torch head at least 6" from sleeve surface. Sleeve material is almost molten when hot and will puncture easily. Do not touch the sleeve when hot! It could damage material and/or burn operator. Sleeve will cure in 10-15 minutes depending on ambient temperature. However, it may be quenched with water to accelerate process. Sleeve (or any part of the sleeve) can also be reheated at any time if necessary.

### Finished SLR



### IMPORTANT:

**Check for leaks and allow sleeve to cool down and cure prior to backfilling!!**

**Note:** If applying the sleeve over a coupling, a finger skirting material must be wrapped around pipe and taped BEFORE installing shrink sleeve. The skirting material is required to prevent puncture of the sleeve at the coupling transition area which could occur while the sleeve is hot during shrink process. See illustration below.



#### Sleeve Layflat Chart\*

Pipe Size OD (inches)	Minimum Sleeve Cut Length	Pipe Size OD (inches)	Minimum Sleeve Cut Length
2.375	11.0	10.75	41.0
3.5	14.5	12.75	48.2
4	16.1	14.00	52.2
4.5	18.1	16.00	59.0
5.563	22.0	20.00	65.0
6.625	27.5	22.00	78.0
8.625	33.5	24.00	84.6

\* The cut lengths listed on this chart are approximate and to be used for estimating purposes only. It is strongly recommended to measure exact pipe circumference at the location where sleeve is to be applied and add 4" for overlap prior to cutting sleeve material.

Should you have any problems or questions regarding the application of this material please contact Stuart Steel Protection Corporation at 908 469-5544