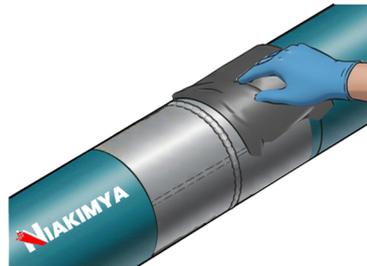
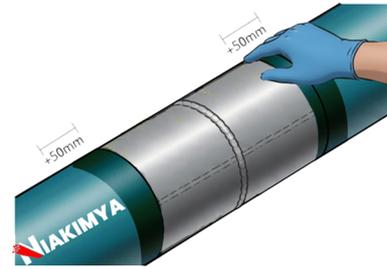




1. First, the surface of the pipe should be preheated to a temperature of 70-65 degrees Celsius. Using a sandblasting machine, the surface of the pipe should be roughened and free from contamination.



2. Use a cotton cloth to clean the surface of any dust and dirt to ensure that the appropriate roughness has been achieved. The time interval between sandblasting and application should not exceed 2 hours.



3. In the overlaps on both sides, use sandpaper or a metal brush to create the appropriate roughness and then clean the surface. Make sure that the temperature of the enamel surface is 5 ± 95 degrees Celsius.



4. Remove the interleaf from the surface of the tape, then heat the adhesive with a gentle fire until the adhesive softens slightly, with the adhesive layer facing up, quickly place it in the center of the weld, align the center point with the weld seam, and fix it on the pipe with a roller. (Note that the pipe surface temperature should remain constant between 65 and 70 degrees Celsius)



5. Apply heat to the overlap area to melt the adhesive. Wrap the heat shrink tape around the pipe body. Align the overlap of the tape and adhere. Press the overlap area flat.



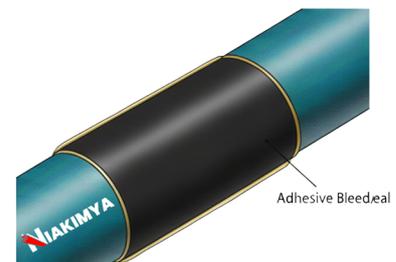
6. Heat the adhesive on the closure patch until it becomes soft and light. Immediately place the closure patch on the overlap, align it, and press it flat. Check the edges of the closed patch for firm adhesion; if not, lift one edge of the closed patch and heat it to melt the adhesive further and press it firmly quickly.



7. For uniform shrinkage, start with a medium heat in the middle of the tape and heat the tape evenly and all around. First shrink the heat shrink tape at the weld seam, then move the heat to both sides and shrink the tape evenly from bottom to top. Press the tape flat with a roller until all the air is removed.



8. After the tape has fully contracted, apply the excess heat to the tape in a circular motion up and down. Caution! Move the heat at a steady speed and avoid overheating at any point. Check the tape for melting by pressing with your finger and pressing the tape with a roller until the air is expelled when the surface of the tape is soft.



9. Check the overall appearance of the shrink wrap and if there are any bubbles, remove them with a roller.