

1. INTRODUCTION

The following guidelines are offered for the installation of Rayrim and TPDM.

2. SAFETY

It is recommended that local safety regulations are adhered to and that installations are carried out in a well-ventilated area with adequate fume extraction. It is further recommended that operators wear heat resistant gloves when installing and handling hot heat shrink products. Avoid contact with molten material and wash hands before eating, drinking, or smoking.

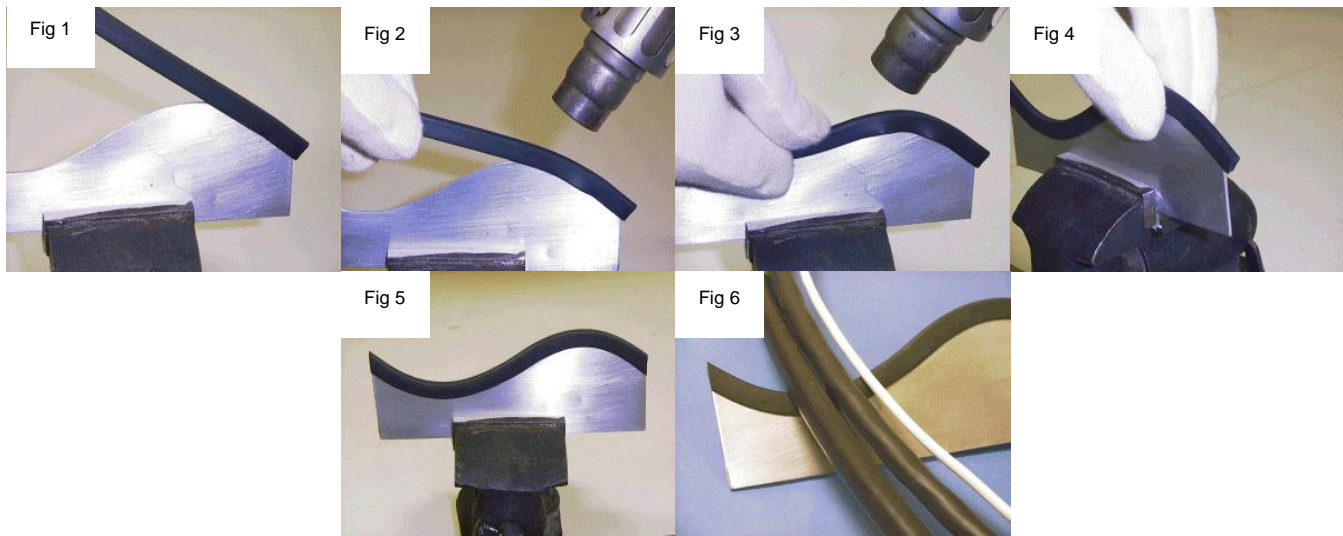
Appropriate Personal Protective Equipment (PPE) should be worn, and installation should take place with fume extraction or in a well-ventilated area.

3. GENERAL INFORMATION

- a. The product is installed using hot air tools. Deburr sharp edges of the substrate.
- b. On the application of heat above 80°C the adhesive will start to melt and flow. Above 120°C the profile will change from a “V” to a “U” section to grip the substrate profile.
- c. Prior to installation the panel edges should be thoroughly degreased with a suitable solvent e.g., I.M.S.
- d. An installation temperature of + 150°C to + 200°C is preferable.
- e. Installations should be allowed to cool naturally to room temperature prior to handling.
- f. To remove the product, heat the product and pull away from the substrate using a suitable gripping tool such as a pair of Pliers.

4. TYPICAL INSTALLATION USING A HOT AIR GUN

- a. The end of the product strip should be heated until the adhesive is tacky and then applied to the substrate with a gloved hand. With the end thus anchored, see Fig 1, the spine of the product can be heated and fed onto the edge of the substrate at a rate of approximately 20cm/minute, keeping the product reasonably taut and performing the operation continuously. See Figs 2 and 3.
- b. The edges can then be heated and pressed into place using a gloved hand or suitable flat surface, applying gentle pressure to ensure proper adhesion. See Fig 4. Any excess adhesive may be removed with a suitable solvent.
- c. The product can be cut to length once the spine has been firmly settled and aligned on the substrate. See Fig 5.
- d. The installed product gives protection to other products which might otherwise be damaged by sharp edges. See Fig 6.
- e. Avoid overheating the product after shrinkage has occurred. Stop heating immediately if the product blisters, chars or shows other signs of degradation. Avoid inhaling fumes which may be released and ventilate the area thoroughly before resuming work.



5. REVISION HISTORY / REASON FOR CHANGE / RELATED DOCUMENTS

Revision number	Date	Prepared By	Approved By	Remarks
A	Jan 2023	Kamalaravanan	Richard Kewell	Doc no changed from PIP-067 to 114-120015
A1	Nov 2023	Kamalaravanan	Richard Kewell	Inclusion of TPEM