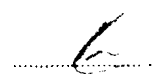


CRP GROUP LTD		PRODUCTION METHOD SHEET	
URADUCT - APPLYING BANDING IN PRE-CUT FORM USING PNEUMATIC TOOLS			
SEQUENCE	DESCRIPTION		
1.	<u>INTRODUCTION</u> This method applies to the preparation, assembly and application of metallic banding to CRP Uraduct, using Signode (or similar) pneumatic tensioning and sealing tools. The banding is supplied cut to size. The Signode tool must be adjusted to apply the correct tension, prior to commencement of banding. This can be done at CRP or on site.		
2.	<u>SAFETY REQUIREMENTS</u>		
2.1	Cut banding can be very sharp - suitable gloves must be worn whilst handling the banding.		
2.2	Eye protection must be worn at all times when handling or using the equipment.		
3.	<u>EQUIPMENT/MATERIAL REQUIRED</u>		
3.1	CRP Uraduct mouldings.		
3.2	Signode or similar pneumatic tensioning and sealing tool.		
3.3	Banding as per order requirements cut to size or in reels.		
3.4	Seals as per order requirements.		
3.5	Compressed air supply.		
3.6	Anti-seize compound, if required.		
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		Authorised By:-	
		Date:-	27/11/96

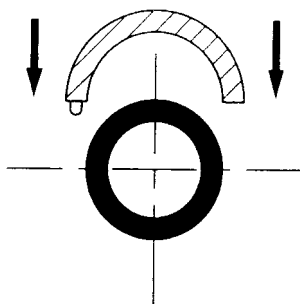
CRP GROUP LTD		PRODUCTION METHOD SHEET	
URADUCT - APPLYING BANDING IN PRE-CUT FORM USING PNEUMATIC TOOLS			
SEQUENCE		DESCRIPTION	
4.	<u>PREPARATION</u>		
	NOTE: In order to prevent corrosion of internal parts and possible fouling of the air-motor, the compressed air must be <u>CLEAN, DRY AND LUBRICATED</u> .		
	When installing the compressed air supply, a filter, regulator, lubricator unit should be stationed within 15 feet (4.6m) of the banding tool, and the supply should incorporate a drain cock which should be inspected and drained daily.		
	Maximum safe operating pressure is 90 psi (6 Bar) minimum air pressure required to operate the sealer is 70 psi (5 Bar).		
	4.1	Inspect the tensioning tool for damage or defects and check that the correct jaws are fitted for the width of the banding in use.	
	4.2	Check that the tool air motor valve collar is turned fully anti-clockwise, to off. Ensure that the tool jaws and tensioning wheel are free of obstruction before connecting the compressed air supply to the tool.	
	4.3	Check that the air pressure is sufficient to attain the required banding tension.	
4.4	The banding tension will have been pre-set at CRP and should not require further attention. It is advisable to re-check the banding tension prior to actual assembly.		
	This is achieved by assembling the band and seal as detailed in Section 5, and operating the tool to tension the band but not seal or cut it. At this point, check the banding tension is correct. The band should be secure, but not so tight as to cause deformation of the Uraduct. Reset the band tension if required as detailed in 4.5.		

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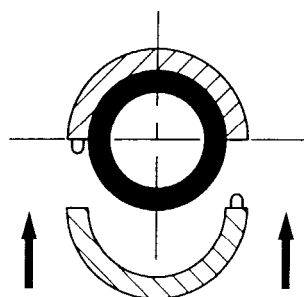
CRP GROUP LTD		PRODUCTION METHOD SHEET	
URADUCT - APPLYING BANDING IN PRE-CUT FORM USING PNEUMATIC TOOLS			
SEQUENCE	DESCRIPTION		
4.5	The banding tension setting may be adjusted as follows:- Signode PNSC-34 Type: The tool may be one of three designs each having different tension adjusters. 1) Tools fitted with a locknut/stud assembly at the rear of the air-motor, the tension is adjusted by slackening the locknut and turning the stud using a 4mm allen key, clockwise to decrease tension, anti-clockwise to increase. 2) Tools fitted with a screwdriver slot under the air motor on-off valve, the tension is adjusted by turning the valve fully on to expose the screwdriver slot, then turning the inner screw until the motor slows or speeds up - the tension will decrease or increase with motor speed. 3) Later models have no separate manual adjustment, the tension is changed by adjusting the air pressure regulator. Fromm Type: The tool may be one of two designs, Two Button or Single Button. The tension is adjusted by turning the set screw under the sealing valve lever, clockwise for higher tension.		
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CRP GROUP LTD		PRODUCTION METHOD SHEET	
URADUCT - APPLYING BANDING IN PRE-CUT FORM USING PNEUMATIC TOOLS			
SEQUENCE	DESCRIPTION		
5.	<u>APPLICATION OF BANDING</u> Refer to CRP Drawing B405516 - Uraduct Banding Sequence		
5.1	Assemble the Uraduct mouldings around the pipe or cable as illustrated in Drawing B405516 Steps 1 and 2, so that the moulding location dowels fully interlock. The Uraduct opposing sections should be overlapped by half their length for better joint stability. Use end termination mouldings, if supplied, to close the overlap distance at either end of the Uraduct string. Where end terminations are not supplied manually cut Uraduct to obtain a flush first end.		
5.2	Take the pre-assembled band complete with its clip from its packaging.		
5.3	Hold the band with the seal overlap and return edge facing the Uraduct as illustrated in Drawing B405516, Step 3.		
5.4	Feed the banding underneath the Uraduct, keeping the seal in position over the top of the Uraduct, on the side of the operator, and feed the banding through the seal as illustrated in Drawing C405516, Steps 4 and 5.		
5.5	If required apply anti-seize compound to the underside of the banding for a length of 100-150mm in front of the seal, as illustrated in Drawing B40.5516, Step 6. Note: Use non-metallic based lubricants for this operation.		
5.6	Hold the seal, pull the loose end of the banding backwards and bend up slightly so as to take up slack and maintain tension.		
5.7	Ensure the banding is at mid point in the Uraduct groove, or the tool jaws may not engage properly onto the seal.		
5.8	Position the tool over the loose end of the band reel and operate the tool in accordance with the manufacturers instructions, to tension, seal and cut the band. This action is indicated in Drawing B405516 Step 7.		
5.9	Check the band position and tension.		
5.10	Proceed with banding application for the remainder of the Uraduct.		
PMS No.-	3 6 0	Originator:-	M Sutton
Issue No.-	0 1	Date:-	21/1 1/96
Authorised By:-			
Date:-		27/11/96	

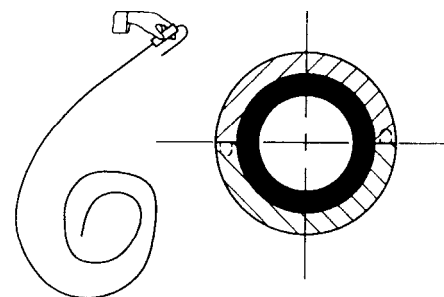
CAUTION— ALWAYS WEAR HAND & EYE PROTECTION



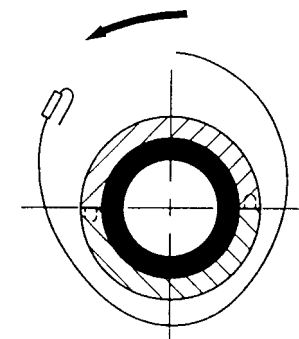
STEP 1



STEP 2

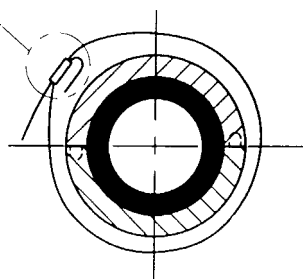


STEP 3



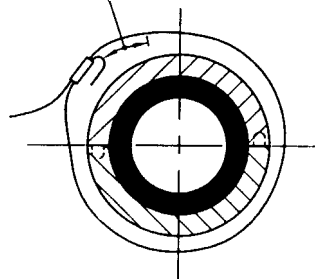
STEP 4

SEAL OVERLAP TO FACE INWARDS TOWARDS PIPE

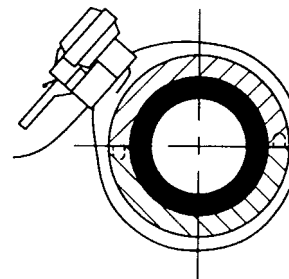


STEP 5

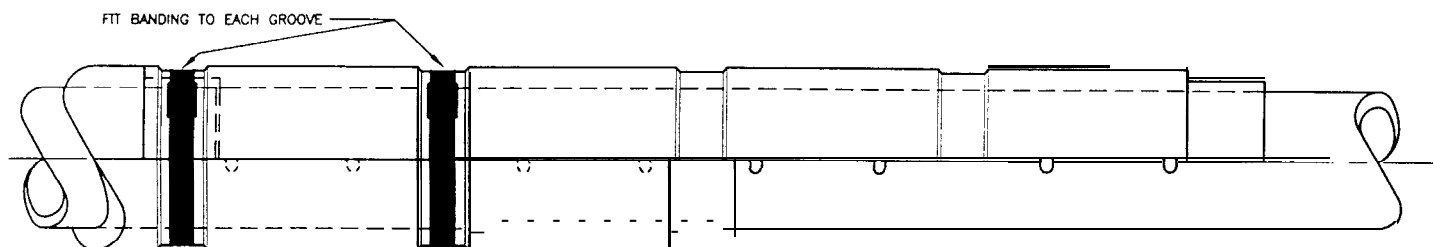
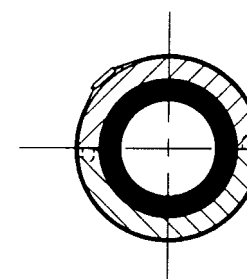
APPLY SUIABLE ANTI-SIEZE COMPOUND TO UNDERSIDE OF THIS ZONE ONLY IF REQUIRED



STEP 6



STEP 7



DIRECTION OF BANDING →

STEP 9

NOTE — DRAWING IS NOT TO SCALE

02	27/11/98	STEP 6 MODIFIED	PUH	TY	RM
01	19/07/95	FIRST ISSUE	PUH	TY	RM
No.	DATE	REVISION	DRAWN	CHK'D	APPR'D
CRP GROUP LIMITED STANLEY WAY, STANLEY, SKELMERSDALE, LANCASHIRE, WN8 5EA, ENGLAND. U.K. TELEPHONE : 01695 724343 U.K. FACSIMILE : 01695 721444					
CLIENT CRP GROUP LTD					
PROJECT URADUCT PROTECTION SYSTEM					
TITLE					
URADUCT INSTALLATION SEQUENCE FOR PRECUT BANDING					
SCALE : NTS	DRAWN BY PUH SHEET SIZE A3 PROJECTION 1				
PROJECT No. CR1004	DRAWING No. B 405516				ISSUE 01