

INSTALLATION PROCEDURE FOR JOINT CLOSURES
FOR DUO-THERM PIPING SYSTEM

Materials & Equipment

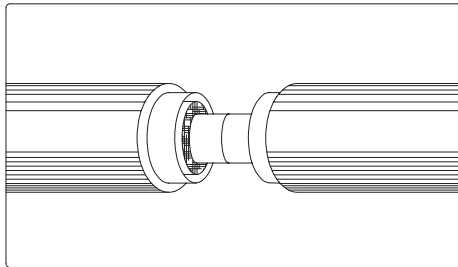
MATERIALS:

1. Sectional Insulation
2. (2) 1/2" Stainless Steel Bands (for insulation)
3. Split Conduit Sleeve
4. HDPE Split Sleeve
5. Pour Foam, Components "A" & "B"
6. ERM Jumper Cable (Per Kit)
7. Heat Shrink Sleeve

EQUIPMENT PROVIDED BY CONTRACTOR:

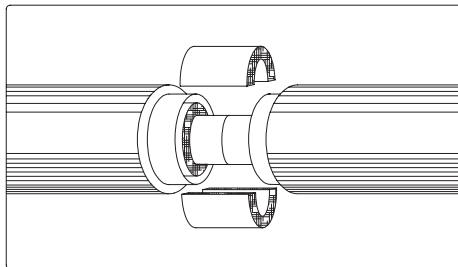
1. Clean Rags
2. Duct Tape
3. Hole Saw, 1" Hole Cutter
4. Safety Equipment as Prescribed by Local Regulations
5. Tape Measure
6. Propane Torch
7. Analog OHM Meter
8. Crimpers

Step 1.



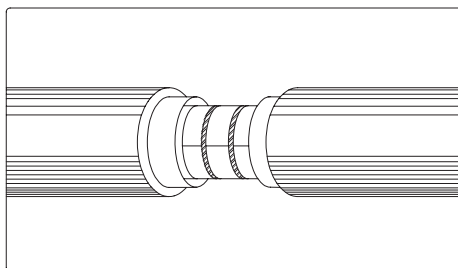
Carefully cut and remove shipping straps from carrier pipe and conduit. Factory recommends use of a grinder to remove straps. **DO NOT CUT OR GOUGE PIPE WHEN REMOVING STRAPS.** Weld carrier pipes together at joint. After weld has cooled, hydro-test as per specifications.

Step 2.



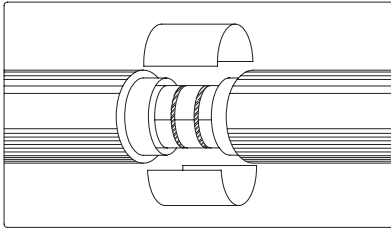
After pressure test, insulate the joint using sectional insulation.

Step 3.

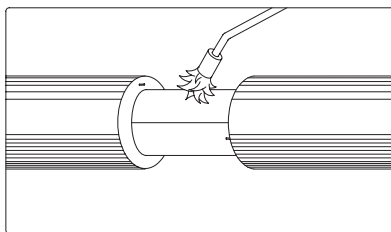


Secure insulation in place using (2) 1/2" stainless steel bands.

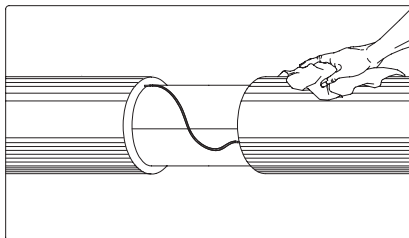
IMPORTANT: THE JOINT AND JOINT MATERIALS MUST BE KEPT DRY!!

Step 4.

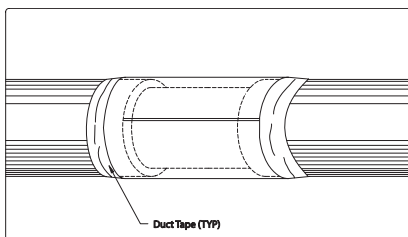
Place split conduit sleeve over joint and weld in place. After weld has cooled, pressure test as per specifications.

Step 5.

Use a propane torch with a light, billowy flame to dry the area out.

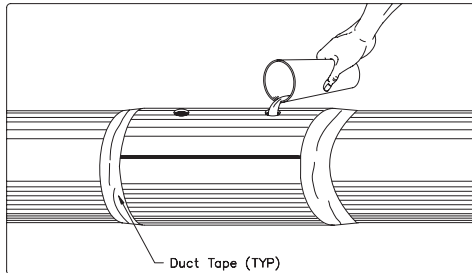
Step 6.

Clean HDPE jacket and wrap around sleeve with rag to remove any dust or dirt. Center the sleeve over the joint. Mark each end of PTJC on the HDPE jacket. On top of the jacket, make a mark 9" from the cutback on each side to locate pour holes.

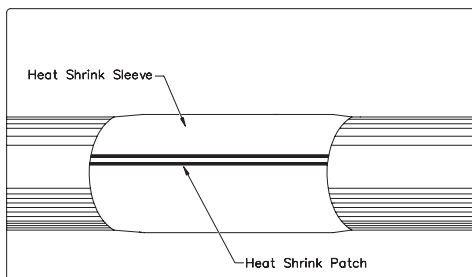
Step 7.

Wrap the HDPE sleeve tightly over insulated joint with longitudinal seam at 2 o'clock position. After the sleeve is wrapped around the joint, make sure the ends are square to each other at the overlap area. Seal ends with duct tape.

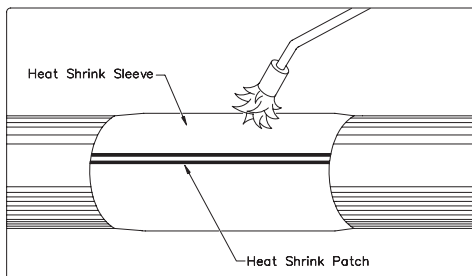
IMPORTANT: THE JOINT AND JOINT MATERIALS MUST BE KEPT DRY!!

Step 8.

Drill two 1" holes in the top of the sleeve. Mix required foam per Foam Kit Instructions and pour into 1" hole. Allow foam and gas (Air) to escape through holes and cover the holes with duct tape when the foam comes out of the holes. See Foam Kit Instructions for quantities, etc. (Foam Quantities over 64oz. requires multiple pours). After allowing 4 to 5 minutes for foam to completely fill the void, trim excess foam from the joint and remove the duct tape.

Step 9.

Allow 4 to 5 minutes reaction time for foam to completely fill the void. If the total foam quantity is over 64 oz., perform multiple pours until the total volume is delivered. Trim excess foam from the joint with a knife. Remove duct tape used temporarily seal seams.

Step 10.

Using a soft billowy flame, heat the patch with a smooth brushing motion until it becomes soft and shiny. Remove heat and press the patch to the sleeve with a gloved hand to form a bond. Heat the rest of the heat shrink sleeve into place, starting at the bottom center of the sleeve and working up and out toward the ends. The mastic should be visible on both sides after the sleeve has cooled.

IMPORTANT: THE JOINT AND JOINT MATERIALS MUST BE KEPT DRY!!



DUO-THERM "505" JOINT CLOSURE INSTRUCTIONS

FKII
14.804

DUO-THERM "505" JOINT CLOSURE

4.08.09

STANDARD POUR FOAM MIXING QUANTITIES

Conduit Size (in)	HDPE Jacket (in)	Foam Thickness	HDPE Sleeve	"A" Component (fl. oz)	"B" Component (fl. oz)
6 5/8	9.0	1"	30"W x 14"	10	10
8 5/8	11.0	1"	30"W x 14"	13	13
10 3/4	13.2	1"	30"W x 14"	16	16
12 3/4	15.2	1"	30"W x 20"	19	19
14	16.4	1"	30"W x 20"	20	20
16	18.5	1"	30"W x 20"	23	23
18	20.5	1"	30"W x 24"	26	26
20	22.5	1"	30"W x 24"	29	29
22	24.5	1"	30"W x 30"	31	31
24	26.5	1"	30"W x 30"	34	34
26	28.5	1"	30"W x 30"	37	37
28	30.5	1"	(2) 30"W x 20"	39	39
30	32.5	1"	(2) 30"W x 20"	42	42
32	34.5	1"	(2) 30"W x 20"	44	44
34	36.5	1"	(2) 30"W x 20"	47	47
36	38.5	1"	(2) 30"W x 24"	50	50

*Contact Thermacor for pour foam amounts where foam insulation thickness is greater than 1".

IMPORTANT: THE JOINT AND JOINT MATERIALS MUST BE KEPT DRY!!