



# HT-406 Installation Manual

HTIM  
2.201

GENERAL INSTALLATION INSTRUCTIONS

4.19.05

## INSTALLATION INSTRUCTIONS

### UNLOADING & HANDLING

Lift joints from trucks. DO NOT DROP SHARP OR HEAVY OBJECTS ON INSULATED UNITS. DO NOT use chains or other devices which might puncture insulation jacket.

### STORAGE

Pipe is stockpiled off the ground. Do not exceed a stacking height of 6'. Prevent dirt and debris from entering pipe. Fittings, joining materials, etc. must be stored indoors to protect them from freezing, overheating, moisture, or loss.

### LAYING OF PIPE UNITS – TRENCHING

All sharp rocks, roots, and other abrasive material must be removed from the trench. The trench bed should be 6" of sand or backfill as specified by the engineer providing a smooth and uniform stabilizing surface (sandbags may be used as a means to keep the pipe off the ground until backfilling is started). The trench width should provide a minimum of 6" from trench wall to jacket O.D. and a minimum of 6" between pipe units. Trench depths will be indicated on the contract drawing and in line with good construction practices. Trench depth should allow for a minimum cover of 24" on top of the insulated unit.

### FIELD JOINING METHODS

HT-406 piping and fittings shall be joined in the field using approved methods of welding for appropriate pipe. Installation drawings will be provided to indicate location of each individual piece of preinsulated pipe. Preinsulated pipe will be marked with Job Number and Piece Number correlating to those on the installation drawings. Installation of pipe must follow the installation drawings. **Field changes to fabricated units must be authorized in writing by the factory.**

### HYDROSTATIC TESTING

Anchor blocks shall be poured and cured, prior to testing. Bleed all air from lines to eliminate possible incorrect readings. The hydrostatic pressure test shall be performed per the engineer's specification with a factory recommendation of one and one-half times the normal operating pressure for not less than two hours. Inspect all fittings, valves, and couplings at this time. *Appropriate safety precautions shall be taken to guard against possible injury to personnel in the event of a failure.*

### FIELD JOINT INSULATION

See Drawings furnished with job material.

### BACKFILL FINAL

Before backfilling is started, the trench should be cleaned of any trench wall cave-ins and general trash, especially metal. Backfilling should be done with sand or other engineer-approved material 6" below the casing to 1' above. Engineer-approved backfill may be used to fill the rest of the trench. This material should be free of rock, roots, large

**WHEELED OR TRACKED VEHICLES SHALL NOT BE USED FOR TAMPING!**

## SHIPPING & HANDLING INSTRUCTIONS

**HANDLE COATED PIPE WITH EXTRA CARE! THIS PIPE CAN DAMAGE WHEN HANDLED, MOVED OR STORED IMPROPERLY!**

### UPON RECEIPT OF MATERIALS

Make an overall inspection of the load, checking all bands and braces to see if they are intact. Also, check the load for shifting. If the load has shifted, or if the braces and bands are broken, examine each pipe for damage. **HAVE THE TRUCK DRIVER MAKE AN ITEMIZED NOTATION OF ANY DAMAGE ON THE DELIVERY RECEIPT AND HAVE IT SIGNED BY THE DRIVER.**

### CHECK PACKING LIST

Compare materials received with those listed on the packing list. Count all pipe and boxes. **NOTE ANY SHORTAGES ON DRIVERS DELIVERY RECEIPT.**

### CHECK BOXES

Open all boxes and inspect for damages, shortages, and correct size. **REPORT ANY DISCREPANCIES WITHIN 30 DAYS AFTER RECEIPT.**

### CLAIMS FOR DAMAGES

Claims for damages in transit or lost goods must be made within 30 days. The filing of any claim is the Purchaser's Responsibility. Thermacor will file any claim on Purchaser's behalf upon receipt of the following:

1. Written authority to file such a claim.
2. Written notice of loss or damage (signed and noted Bill of Lading) by truck driver or carrier freight agent.

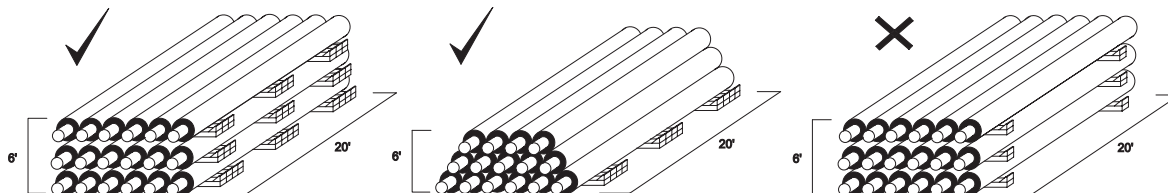
### UNLOADING PIPE

Pipe may be unloaded by hand or with fork lifts\*, cherry pickers, or cranes. **DO NOT HOOK** pipe ends. Minimum 4" wide straps or slings should be used.

\*Fork Lift – When using Fork Lift, wide tines or a large surface covering the fork tines must be used to prevent coating damage. Fork Lift must be able to handle the weight of the insulated pipe length.

### PIPE STOCKPILING

Pipe should be stored on level ground, elevated to be as dry as possible, and in such a way that the pipe ends do not lie in water or on the ground. To prevent deformation of the jacket and insulation due to the weight of the pipe, place a series of supports (3 for 20' or 5 for 40') of ample size generally constructed from 2" x 4"s under the pipe as shown below. Supports should increase in width as weight load increases so that the top supports of a fully loaded stockpile should be approximately 10" wide, gradually increasing to the bottom level, approximately 18" wide. Pipe can be pyramided (within reasonable and safe limits) approximately 6' high after a properly braced or chocked base is formed. Pipe stored outside for long periods of time can be covered with blue mesh tarpaulin (plywood can also be used). **Do not prevent airflow as jacket can be deformed from heat buildup.**



### BE VERY CAREFUL NOT TO DROP THE PIPE!

**NOTE: Thermacor does not approve of the practice of installing pipe and fittings and backfilling the pipe before testing. Thermacor will not allow or pay claims for charges which arise in locating and digging up leaks regardless of cause**