Polyurethane Foam Mixing Instructions

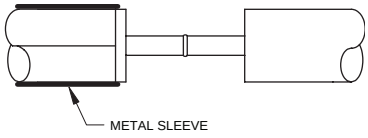
Materials Included:

1 Container of Isocyanate (Part "A")
1 Container of Resin (Part "B")
2 Measuring Cups (8 oz or 32 oz) for Measuring Each Foam Component Separately
Wooden Stir Sticks
Disposable Foam Mixing Pails
Sealant
Reusable Polyethylene Mold (1 for every 10 kits)

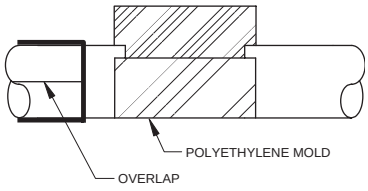
1. **Determine Foam Requirement:**
   Locate closest carrier pipe and jacket size combination in the Foam Table on page FKII 14.102. **The quantity listed is the total of both the "A" and "B" components.** Measure one-half the listed amount of Part "A" using the "A" measuring beaker, and one-half the listed amount of Part "B" into the "B" measuring cup.
2. **Mix and Pour Foam:**
   Pour Part "A" (iso) into the mixing pail first. Using wooden stir stick, mix vigorously as Part "B" (resin) is added. Stir for 20 to 25 seconds and immediately pour material through the hole in fitting cover or sleeve. (Be prepared for a quicker reaction time on warm days.)
3. **Allow to Cream:**
   Allow four to five minutes foam reaction time before continuing. If the total foam quantity is over 64 oz., perform multiple pours until the total volume is delivered.

Straight Run Joint Kit

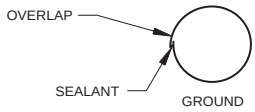
1. Slide a pre-cut sleeve of jacket material onto one end of the pipe. Make the field weld and pressure test as specified for your project.

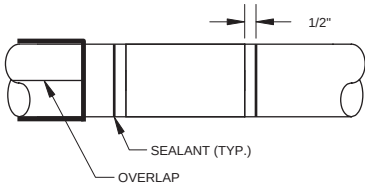


2. After testing, apply a reusable polythelyene (PE) mold with the seam at the top of joint and secure with contractor supplied duct tape.
3. Follow foam mixing instructions precisely using closest quantity (see Foam & Tape Table on FKII 14.102) and pour immediately into the mold. Allow foam to rise to top, then seal seam with tape. Allow foam to cure 5-10 minutes then remove any excess foam, then the mold.

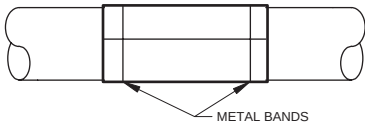


4. Apply ring of sealant 1/2" from edge of metal jacket on both sides of the field joint. Apply sealant 1/2" from overlap edge of metal sleeve, making sure that the overlap is facing down towards the ground.





5. Slide metal sleeve over insulated joint so that there is an equal amount of overlap on either side. Make sure that the metal sleeve is facing the bottom of the joint.
6. Use two metal bands to secure sleeve to jacket.



THERMACOR

Field Insulation Kit

Installation Instructions

SPIRAL-THERM POUR FOAM

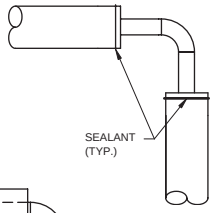
FKII

14.142

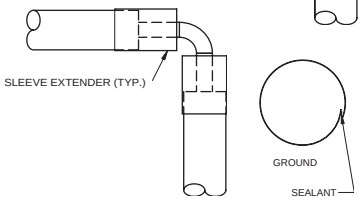
3.14.07

Field Insulation of Elbows

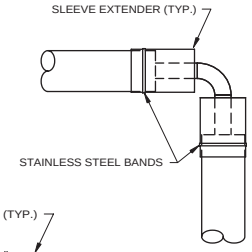
1. Remove five inches of insulation and jacketing from each pipe section end and slide sleeve extenders over each end of pipe adjacent to the fitting. Weld and test- fit as specified for your project.



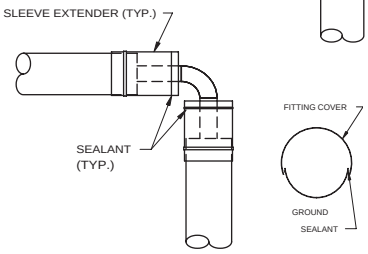
2. Apply ring of sealant 1/2” from the edge of the jacket on both sides of the fitting. Apply sealant 1/2” from the overlap edge of the sleeve extender and wrap sleeve extender around elbow cutback. Make sure sleeve extender lines up with fitting weld and that the sleeve overlap is facing down towards the ground.



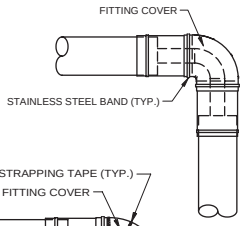
3. Attach one metal band to each sleeve extender at the overlap end about 1” back from the edge.



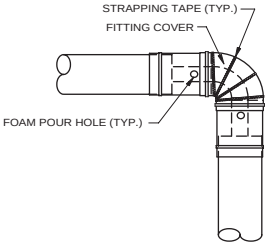
4. Apply sealant 1/2” from the edge of the sleeve extender to seal fitting cover. Apply sealant to the longitudinal seams of the metal fitting cover.



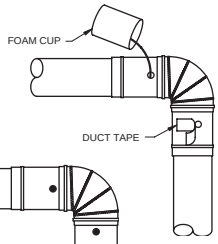
5. Install metal fitting cover with the overlap pointed towards the ground. Use remaining (2) bands to seal the circumferential seams of cover.



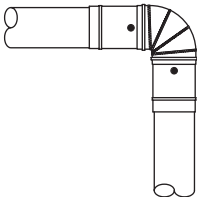
6. Wrap fitting cover with 1/2” widestrapping tape (to be removed after foaming), avoid wrapping too tightly because it may distort fitting cover. Drill (2) 3/4” diameter holes in sleeve extenders at edge of fitting cover.



7. Follow foam mixing instructions precisely using closest quantity (see Foam Table on FKII 14.102) and pour immediately into opening in cover.



8. Allow foam to rise to top, then seal holes with duct tape. 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. Remove tape and excess foam from joint. Remove a small portion of foam from each hole and seal with sealant, making sure sealant is flush with metal jacket.



THERMACOR

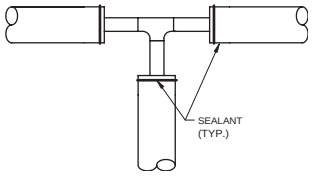
Field Insulation Kit
Installation Instructions

SPIRAL-THERM POUR FOAM

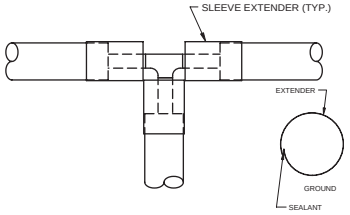
FKII
14.143
3.14.07

Field Insulation of Tees

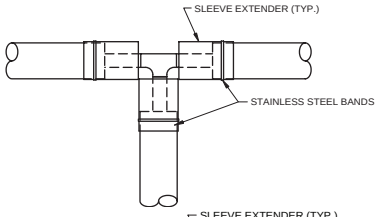
1. Remove five inches of insulation and jacketing from each pipe section end and slide sleeve extenders over each end of pipe adjacent to the fitting. Weld and test- fit as specified for your project.



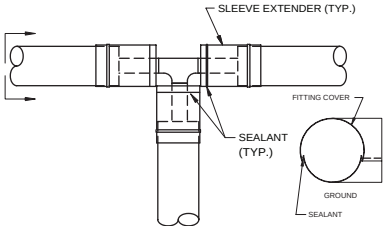
2. Apply ring of sealant 1/2” from the edge of the jacket on all sides of the fitting. Apply sealant 1/2” from the overlap edge of the sleeve extender and wrap sleeve extender around elbow cutback. Make sure sleeve extender lines up with fitting weld and that the sleeve overlap is facing down towards the ground.



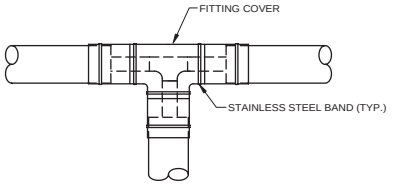
3. Attach one metal band to each sleeve extender at the overlap end about 1” back from the edge.



4. Apply sealant 1/2” from the edge of the sleeve extender to seal fitting cover. Apply sealant to the longitudinal seams of the metal fitting cover.



5. Install metal fitting cover with the overlap pointed towards the ground. Use remaining (3) bands to seal the circumferential seams of cover.



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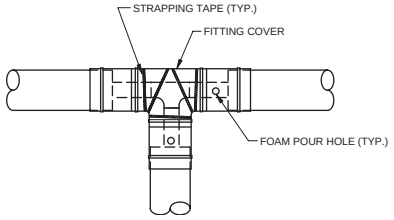

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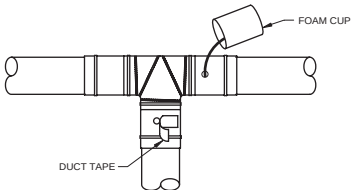

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