



DUO-THERM "505" JOINT CLOSURE INSTRUCTIONS

FKII
14.801

DUO-THERM "505" JOINT CLOSURE

1.07.2020

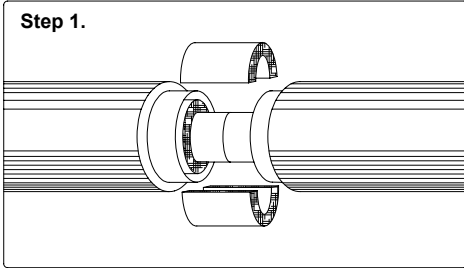
MATERIALS:

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

EQUIPMENT PROVIDED BY CONTRACTOR:

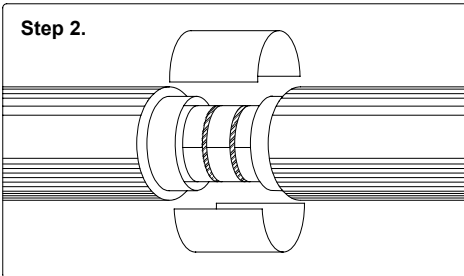
1. Clean Rags
2. Duct Tape
3. Hole Saw, 1" Hole Cutter
4. Safety Equipment as Prescribed by local Regulations
5. Tape Measure
6. Propane Torch
7. Analog Ohmmeter

Step 1.



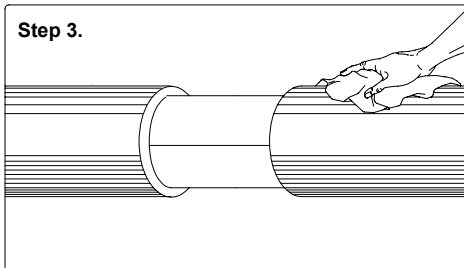
Carefully cut and remove shipping bars from carrier pipe and conduit. Factory recommends use of a grinder to remove bars. **DO NOT CUT OR GOUGE PIPE WHEN REMOVING BARS.** Weld pipe and hydro-test per specifications. After hydro test, insulate the joint using carrier pipe insulation. Secure insulation to pipe using (2) stainless steel bands.

Step 2.



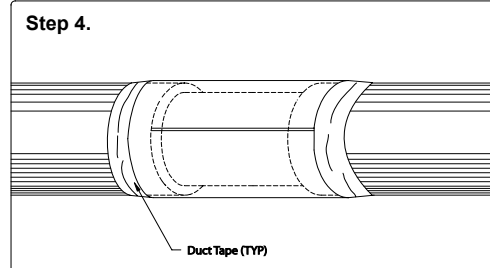
Place split conduit sleeve over joint and weld in place. After weld has cooled, pressure test conduit per specifications. Use a propane torch with a light, billowy flame to dry the joint even if the joint appears dry. Residual moisture may be present that is not readily seen.

Step 3.



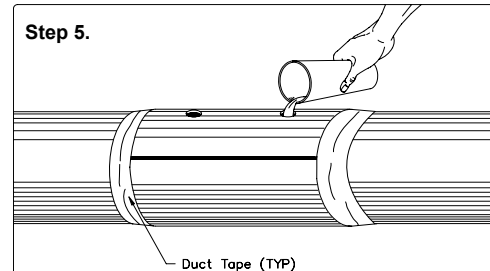
Clean both the HDPE jacket and HDPE sleeve with a rag to remove any dust or dirt. Center the sleeve over the weld joint. On top of the sleeve, make a mark 9" from the edge on each side to locate pour holes.

Step 4.



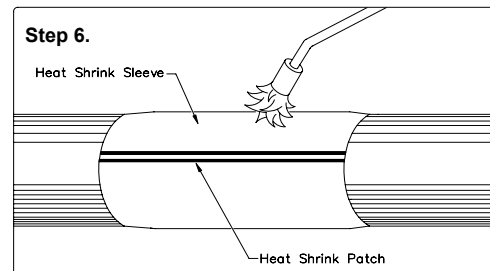
Wrap the HDPE sleeve tightly over insulated joint with longitudinal seam at 2 o'clock position. After the sleeve is wrapped around the joint, make sure the ends are square to each other at the overlap area. Seal ends with duct tape.

Step 5.



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 with a knife and remove the duct tape.

Step 6.



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.

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



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DUO-THERM POUR FOAM MIXING QUANTITIES

1.07.2020

Conduit (in)	HDPE Jacket (in)	Nom. Insul. Thickness (in)	"A" Component (fl. oz)	"B" Component (fl. oz)
4 1/2	7	1	6.0	6.0
	8	1 1/2	13.0	13.0
	9	2	16.0	16.0
6 5/8	9.0	1	8.0	8.0
	10.0	1 1/2	20.0	20.0
	11.0	2	24.0	24.0
8 5/8	11.0	1	9.0	9.0
	12.0	1 1/2	28.0	28.0
	13.0	2	33.0	33.0
10 3/4	13.2	1	12.0	12.0
	14.2	1 1/2	39.0	39.0
	15.2	2	44.0	44.0
12 3/4	15.2	1	14.0	14.0
	16.5	1 1/2	52.0	52.0
	17.5	2	59.0	59.0
14	16.5	1	15.0	15.0
	17.5	1 1/2	59.0	59.0
	18.5	2	66.0	66.0
16	18.5	1	17.0	17.0
	19.5	1 1/2	73.0	73.0
	20.5	2	80.0	80.0
18	20.5	1	19.0	19.0
	21.5	1 1/2	88.0	88.0
	22.5	2	97.0	97.0
20	22.5	1	21.0	21.0
	23.5	1 1/2	106.0	106.0
	24.5	2	115.0	115.0
22	24.5	1	23.0	23.0
	25.5	1 1/2	124.0	124.0
	26.5	2	134.0	134.0
24	26.5	1	25.0	25.0
	27.5	1 1/2	144.0	144.0
	28.5	2	155.0	155.0
26	28.5	1	26.0	26.0
	29.5	1 1/2	166.0	166.0
	30.5	2	177.0	177.0

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



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DUO-THERM POUR FOAM MIXING QUANTITIES

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Conduit (in)	HDPE Jacket (in)	Nom. Insul. Thickness (in)	"A" Component (fl. oz)	"B" Component (fl. oz)
28	30.5	1	28.0	28.0
	31.5	1 1/2	189.0	189.0
	32.5	2	201.0	201.0
30	32.5	1	30.0	30.0
	33.5	1 1/2	214.0	214.0
	34.5	2	227.0	227.0
32	34.5	1	32.0	32.0
	35.5	1 1/2	240.0	240.0
	36.5	2	254.0	254.0
34	36.5	1	34.0	34.0
	37.5	1 1/2	268.0	268.0
	38.5	2	282.0	282.0
36	38.5	1	36.0	36.0
	39.5	1 1/2	297.0	297.0
	40.5	2	312.0	312.0
38	40.5	1	38.0	38.0
	41.5	1 1/2	328.0	328.0
	42.5	2	344.0	344.0
40	42.5	1	40.0	40.0
	43.5	1 1/2	360.0	360.0
	44.5	2	377.0	377.0
42	44.5	1	42.0	42.0
	45.5	1 1/2	394.0	394.0
	46.5	2	412.0	412.0
44	46.5	1	44.0	44.0
	47.5	1 1/2	430.0	430.0
	48.5	2	448.0	448.0
48	50.5	1	47.0	47.0
	51.5	1 1/2	505.0	505.0
	52.5	2	525.0	525.0

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