



DUO-THERM "505" CARRIER INSULATION AND CASING INSTRUCTIONS

FKII
14.901

DUO-THERM "505" CARRIER INSULATION AND CASING INSTRUCTIONS

1.30.2026

ONLY LABORERS TRAINED AND CERTIFIED BY THERMACOR ARE ALLOWED TO PERFORM THIS INSTALLATION. A Site foreman or inspector is required to inspect and log each joint on attached form. **Failure to provide this documentation will void Thermacor's warranty.**

MATERIALS:

1. Carrier Pipe Insulation
2. (2) Stainless Steel Bands (for insulation)
3. Split Conduit Sleeve

EQUIPMENT PROVIDED BY THERMACOR (To Be Returned)

1. Therma-Fuse Welding Machine
2. SocketFuse Welding Machine
3. SocketFusion Plug Tool
4. (4ea) 4" Wide Rubber Bands
5. (2ea) 3" Wide x 12" Rubber Bands
6. (4ea) Metal Buckles
7. (2ea) Ratchet Straps
8. Air Test Gauge
9. 1" Bit with Stop

EQUIPMENT PROVIDED BY CONTRACTOR:

1. Hand Air Pump or Compressor
2. Clean Rags
3. Duct Tape
4. Hole Saw, 1" Hole Cutter
5. 5/8" Side Grinder
6. Safety Equipment as Prescribed by local Regulations
7. Tape Measure
8. Soap & Water Bottle
9. Propane Torch
10. Crimpers- Greenlee Recommended
11. Power Supply (Dedicated or Generator)
12. 80 Grit Emery Cloth
13. Isopropyl Alcohol



Place the Pre-Insulated Pipe in the ditch in the proper orientation. Carefully cut and remove shipping bars from the carrier pipe and conduit. Thermacor's recommendation is to use a grinder. **DO NOT CUT OR GOUGE PIPE WHEN REMOVING BARS**



Weld Pipe and Hydro-Test Per Specification.
NOTE: Hydro-Test records are required for warranty.



Insulate the exposed joint using carrier pipe insulation. Secure with (2) stainless steel bands and clips. Gaps should be less than 1/8" to prevent excess heat loss.



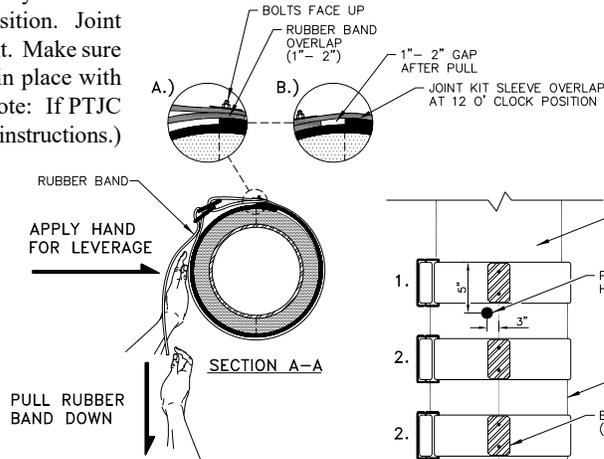
Place supplied split conduit sleeve over the joint and weld it in place. Pressure Test conduit per specification.
NOTE: Conduit Pressure Test records are required for warranty.

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

Wrap the Pressure Testable Joint Closure (PTJC) Sleeve tightly over the insulated joint with the longitudinal seam at 12 O'Clock position. Joint should overlap 2 to 4 inches and shall be centered over the joint. Make sure the ends are square to each other at the overlap area. Hold in place with a 1" ratchet strap in the middle of the joint (**not shown**). (Note: If PTJC overlap is greater than 4" or less than 2", contact Thermacor for instructions.)

Tighten 1" ratchet strap to sleeve to ensure even pressure is maintained on fusion surfaces. No gaps should be visible. Stretch 2 of the 4" Rubber Bands, provided by Thermacor flush with the edge of the sleeve. Rubber Bands need to be at the edge of the sleeve. Position the Rubber Bands such that the Rubber Band Overlap is approximately 1" past the Joint Overlap (A). BOLTS MUST BE FACING UP to avoid damaging the joint. The loose end of the rubber band is threaded from under to over through the buckle and the rubber band will be pulled tight in the same direction as the sleeve overlap.



Step 5.

Place one hand on the rubber band below the buckle as shown and pull the loose end of the rubber band to apply pressure to the seam of the PTJC sleeve. Continue pulling until a 1"- 2" gap appears between the Rubber Band Overlap and the Joint Overlap (B).

Follow the same procedure for the 2nd Rubber Band on the opposite end of the sleeve. REMOVE the ratchet strap and secure the 3rd & 4th Rubber Band following the same procedure..

Once all 4 Rubber Bands have been installed, mark the location for the pressure test hole approximately 5" from the end of sleeve and 3" from overlap as shown. Drill a 1" hole using the customer supplied 1" hole saw for the pressure test.

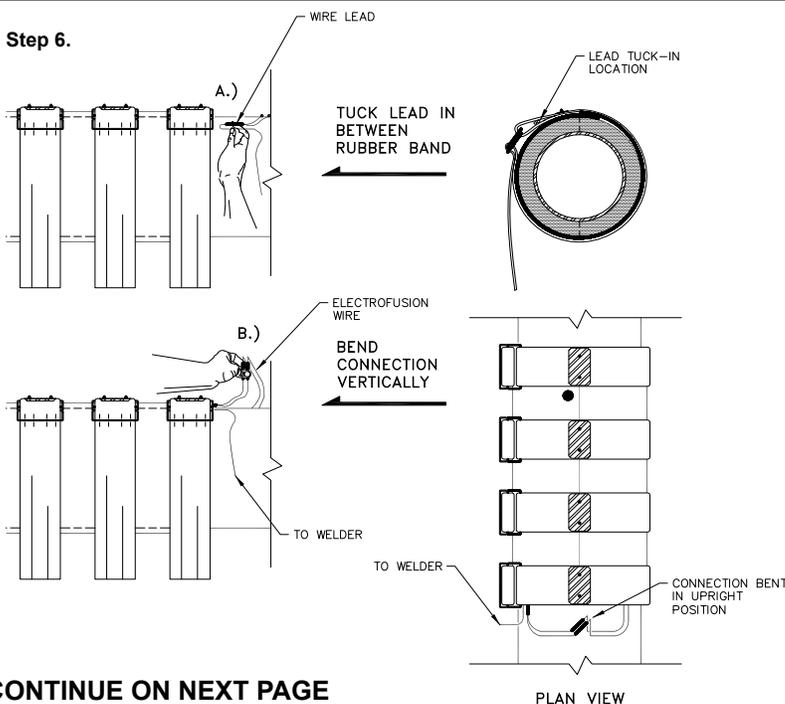
NOTE: 1" pressure test hole MUST be drilled prior to fusion to avoid pressure building inside the joint.

Connect 110V single phase welding machine to a **DEDICATED POWER SOURCE**. Attach power cables extending from a 110V single phase welding machine to the Electro-Fusion wire. (Note: It does not matter which color power cable is connected to the Electro-Fusion wire). 2 white on one side, 2 black on the other side.

Bend and tuck the lower power connection cable between the rubber band overlap (6A), bend the power connection cable upwards as shown in Figure 6B. This will prevent contact between the Electro-Fusion wires and the outer jacket of the pipe.

Apply 12 +/-0.1 Amps electro-fusion wires attached to the sleeve. Maintain 12 Amps throughout the heating cycle. Check the Amp reading after 5 minutes of heating to ensure that the reading remains at 12 Amps. Do not exceed 12 Amps. See power chart for heating times. Heating times will vary. **NOTE: JOINT IS NOT COMPLETE UNTIL MELT IS VISIBLE EXTRUDING FROM ALL CIRCUMFERENTIAL SEAMS AND WIRE INDENTION IS SEEN IN CLOSURE.** Allow power connection cables to cool for 5 minutes before disconnecting. Remove power cables. Allow to cool for a minimum of 20 minutes or until the weld zone is the same temperature as the adjacent jacket. **Do not remove the rubber bands until the joint has cooled!**

Step 6.



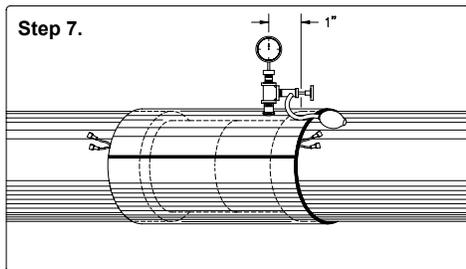
| POWER CHART | | |
|-------------|------|----------|
| JACKET SIZE | AMPS | *MINUTES |
| 5" TO 14" | 12 | 20 - 30 |
| 16" TO 24" | 12 | 25 - 35 |
| 26" TO 30" | 12 | 30 - 40 |
| 30" AND UP | 12 | 40 - 50 |

*Heating times increase with cold weather. Insulation blanket may be required around PTC during severe cold. Fusion complete when HDPE melt is seen oozing from all seams and wire indentation is seen (see pictures from submittal package).

NOTE: Power requirement is 12 amps ± 0.1

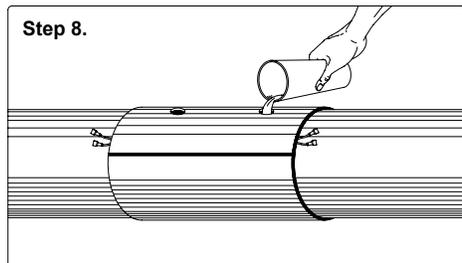
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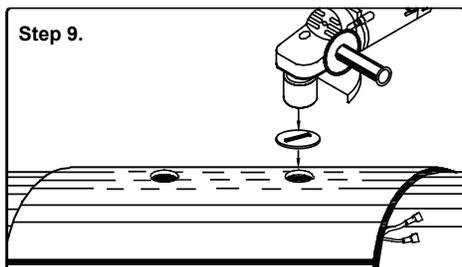
Step 7.

Push the Pressure Gauge and Valve Test Device into the hole. Using hand pump or other air supply obtain 5 psi pressure. Disconnect air supply and soap joint for "pin hole" leaks. Hold air pressure for 5 minutes. (Note: In rare cases air will escape down the interface between the foam and the jacket. This can be confirmed by soaping the end of the jacket interface).



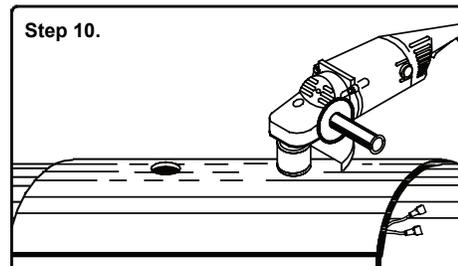
Step 8.

Remove test apparatus. Drill a second 1" hole 10" from the 9" mark at 12 O' Clock. Mix required foam per Foam Kit Instructions and pour into 1" hole. Allow foam and gas (Air) to escape through holes, cover the holes with duct tape when the foam comes out of the holes. See Foam Kit Instructions for quantities, etc.



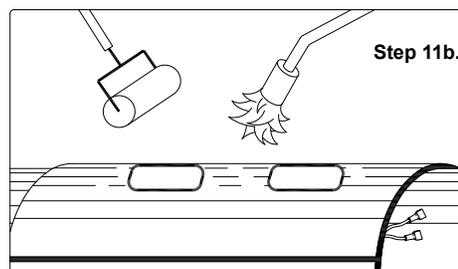
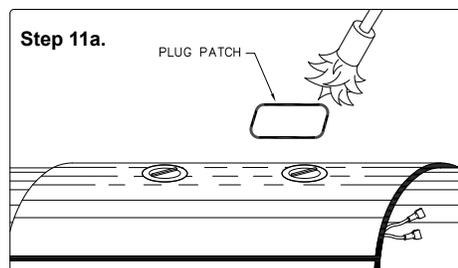
Step 9.

Clean any excess foam off the HDPE jacket. Using a chisel or other device, remove the foam from each hole to below the lip of the HDPE. Rough up surface using 80-grit sandpaper for proper fusion. Install drill bit provided by Thermacor into 5/8" side grinder. Fit the raised tongue of the white plug into the groove in the drill bit. Center the raised circle on the plug into the hole in the HDPE jacket.



Step 10.

Apply firm downward pressure on the plug, then spin the plug at full speed until outside of drill bit touches HDPE jacket (approx. 13 seconds). Stop spinning the plug, but continue applying downward pressure for 20 seconds.



Step 11a.

Step 11b.

Visually inspect the plug after the fusing process. The edge of the clear plug should have turned black around the outer 1/2" if a good bond has been made. Install the HDPE adhesive patch over the fusion plug by pre-heating the adhesive side of the patch and installing applying even pressure. After removing the release liner from the patch, place the patch with the adhesive side up on a gloved hand, or on top of the pipe, and heat gently. Heat until the adhesive softens and the surface becomes glossy. Also, reheat the plug area to keep it warm. Apply the softened adhesive side of the patch to the plug and press down firmly. Heat the patch with a low intensity flame. Using a roller or a gloved hand, pat down and remove wrinkles. Roll to ensure a good bond.

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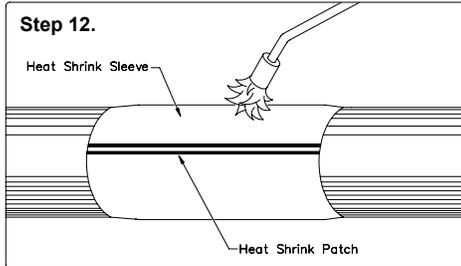


DUO-THERM "505" PRESSURE TESTABLE JOINT CLOSURE & ERM INSTRUCTIONS

FKII
14.904

DUO-THERM "505" PRESSURE TESTABLE JOINT CLOSURE W/ ERM

1.30.2026



Cut off the Electro-Fusion wires at the PTC sleeve and grind them flush. Remove the release paper from the back of the heat shrink sleeve and loosely wrap the heat shrink sleeve around the joint area, overlapping each end by 3". Remove the release film from the closure patch and heat the patch using a soft billowy flame with a smooth brushing motion until it becomes soft and shiny. Remove heat and press the patch to the heat shrink 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. Do not use a "rose bud" or acetylene torch. Use a short handed, brush burner with a billowy flame.

INSTALLER IS REQUIRED TO SIGN THEIR NAME AND DATE ON THE JOINT WITH A YELLOW PAINT PEN AND FILL OUT THE LOGS FOR ELECTRO-FUSION & ERM.

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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 12" | 10 | 10 |
| 8 5/8 | 11.0 | 1" | 30"W x 12" | 13 | 13 |
| 10 3/4 | 13.2 | 1" | 30"W x 14" | 16 | 16 |
| 12 3/4 | 15.2 | 1" | 30"W x 18" | 19 | 19 |
| 14 | 16.4 | 1" | 30"W x 18" | 20 | 20 |
| 16 | 18.5 | 1" | 30"W x 20" | 23 | 23 |
| 18 | 20.5 | 1" | 30"W x 22" | 26 | 26 |
| 20 | 22.5 | 1" | 30"W x 24" | 29 | 29 |
| 22 | 24.5 | 1" | 30"W x 26" | 31 | 31 |
| 24 | 26.5 | 1" | 30"W x 28" | 34 | 34 |
| 26 | 28.5 | 1" | 30"W x 30" | 37 | 37 |
| 28 | 30.5 | 1" | (2) 30"W x 32" | 39 | 39 |
| 30 | 32.5 | 1" | (2) 30"W x 34" | 42 | 42 |
| 32 | 34.5 | 1" | (2) 30"W x 36" | 44 | 44 |
| 34 | 36.5 | 1" | (2) 30"W x 38" | 47 | 47 |
| 36 | 38.5 | 1" | (2) 30"W x 40" | 50 | 50 |

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

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