

1"-42" Heat Collar Instructions

For use on bonded Green Thread™ HP, Red Thread™ HP, Red Thread IIA, Silver Streak™, Dualoy™, Bondstrand™ epoxy piping and Centricast™ RB nd Z-Core™ products. Refer to the appropriate installation manuals for bonding and heat cure requirements.



Selecting the Heat Collar

The Fiber Glass Systems heat collars are available for 1"-42" pipe sizes. Be sure you have the correct collar(s) for your size pipe.

Heat Collar Selection and Power Requirements

Pipe Size ⁽¹⁾		Part Number	Power Requirements ⁽²⁾	
in			watts	
1-2	-	005990-520-0	140	-
3-4	-	005990-522-0	210	-
6-8	-	005990-523-0	700	-
10-12	-	005990-524-0	980	-
14-16	-	005990-525-0	1,210	-
18-20	30-36	005990-526-0	2,420	4,840
22-24	42	005990-527-0	3,400	6,800

⁽¹⁾ 30-42 inch require two heat collars linked together

⁽²⁾ Voltage 110-120 AC



Recommended Handling, Maintenance and Safety Practices

- Always store heat collars flat or gently rolled up.
- Heat collars should not be folded or creased. Doing so may damage the heating elements and shorten the life of the heat collar.
- Never place heavy objects on top of a heat collar or throw a heat collar into the bed of a pickup truck.
- Never pull or lift a heat collar by the power cord.
- Never use a heat collar while standing in water or on wet surfaces.
- Inspect the electrical power cord for damage before using.
- Check that the entire surface of the heating area warms up before using.

Installation Instructions

After assembling and bonding the joint according to the product instruction manuals, the heat collar may be applied as follows:

1. Remove excessive adhesive from the surface of the pipe joint to prevent adhesive buildup on heat collar which could damage it.
2. Obtain the proper heat collar for the pipe joint size being bonded. Failure to do so could result in an under cured joint or damaged heat collar.
3. The heat collar must be cool to the touch before handling to prevent personal injury.
4. The heat collar should be positioned around the joint with the thermostat located at the top. The thermostat(s) is built in near the end where the electric cord is attached.



5. The heat collar should overlap the fitting or pipe joint by approximately 1". The bulk of the heat collar should be wrapped around the fitting or pipe joint.
6. The heat collar should be wrapped tightly around the fitting to obtain a snug fit. Air spaces between the fitting and the heat collar reduce heat transfer significantly. The Velcro straps should be connected to hold the heat collar in place.
7. The outside diameter of fittings may vary by fitting types. Thus, the heat collar lengths may be longer than necessary. For 1" – 4" sizes wrap the heat collar around the joint overlapping itself if necessary. For 6" and larger position any excess heat collar length over the built-in silicone riser blocks to prevent overheating of the elements.
8. Connect the electrical power to the heat collars and leave on for the recommended time for the joint type and size. The correct voltage and circuit size should match the requirements marked on the heat collar. As an aid to the installer, the heat collar start time should be marked on the pipe beside the heat collar with a permanent marker.
9. The heat collar temperature should be monitored during use to ensure consistent performance. It is recommended that a heat collar's performance be measured with a thermocouple unit daily.

10. Disconnect power at the end of the curing cycle and allow the heat collars to cool down before removing. Caution should be used when removing the heat collars for residual heat in the joint may cause personal injury. Always check product temperature before removing the heat collars.



11. Heat collars should be stored so that they are not folded or creased.



For flanges use the smallest available heat collar that will fit inside the ID of the flange joint. Position the Velcro strap outside the flange joint and roll the heat collar up with the inner collar surface against the pipe ID.

Ambient Cure Time

Ambient temperature cure times are provided in the instructions included with the adhesive kit. Heat curing bonded joints when temperature is below 70°F (21°C) yields the shortest cure times and joint performance improvements.

Heat Collar Cure Time

The time required to cure a joint using a heat collar is dependent on the piping product and adhesive. Refer to the instructions included in each adhesive kit for recommended cure times.

Insulation

DO NOT use insulating jackets or coverings such as aluminum foil over the heat collars. Heat collars are designed to perform under typical cold weather scenarios. If extreme conditions exist contact NOV Fiber Glass Systems Field Service representative for recommendations.

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