



# HDPE PRESSURE TESTABLE JOINT CLOSURE INSTRUCTIONS

FKII  
14.401

THERMACOR HT- 406

1.02.18

**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:

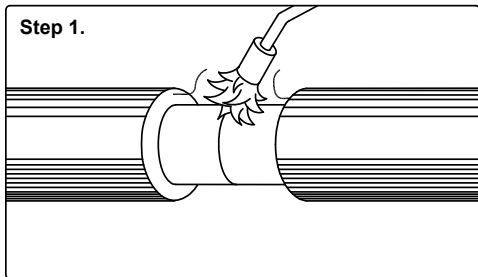
1. Thermacor Pressure Testable Joint Closure Sleeve
2. 3 Wooden Tongue Depressors (Per Kit)
3. 1 Frictional Weld Plugs (Per Kit)
4. ERM Crimp (Per Kit)
5. High Temperature Sectional Foam
6. 1 H.S Sleeve & Patch

### EQUIPMENT PROVIDED BY THERMACOR ON 30 DAY LOAN:

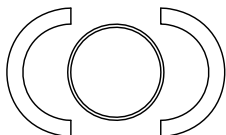
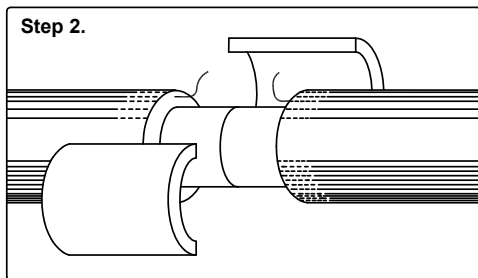
1. 110V Electric Power Control Unit
2. 3 Rubber Bands, each 4" Wide (per power unit requested)
3. Air Gauge Test Assembly
4. Ratchet Strap Tools
5. 1 Frictional Welding Drill Bit (per power unit requested)
6. Analog Ohmmeter

### 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

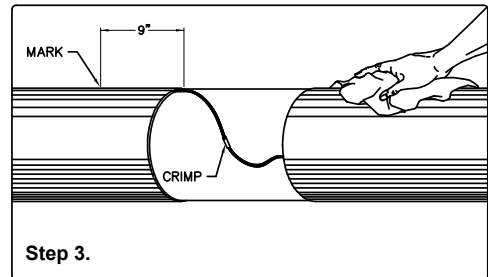


Use a propane torch with a light billowy flame to dry the area out, regardless whether or not the area appears dry. Residual moisture may be present that is not readily seen.



Sectional Foam Orientation

Insulate the joint using high temperature sectional foam. Measure distance between factory ends and cut insulation to fit, making sure the insulation fits between factory insulation tightly, without gaps. Tape into place. See illustration for orientation of sectional foam.



Following the ERM leak detection instructions, test the continuity and isolation of the pipe. Visually inspect the wire near the waterstop to ensure contact will not occur after the joint is complete. Connect the insulated wire and crimp. Complete the connection to the second wire and crimp. Test the connection by following the ERM instructions. Make sure that the ERM wire is NOT centered on the top of the joint, but placed to one side to prevent damaging the wire when drilling the air test hole. On both sides of the joint, make a visible mark 9" from the cut insulation onto the factory jacket. Center the sleeve over the weld joint using the marks as a guide.

Clean HDPE jacket and wrap around sleeve with rag to remove any dust or dirt. Using 80 grain emery cloth, roughen the entire fusion surface. Clean the surface after roughening using ethanol/ alcohol and a lint free cloth. Center the sleeve over the weld joint using the marks as a guide.

### **ALL FIELD MODIFICATIONS MUST BE APPROVED IN WRITING!**

In the event that a field modification is required and the diffusion barrier needs to be trimmed back, use a putty knife to trim the protective HDPE and Aluminum diffusion barrier back so that normal fusion can occur on the base HDPE layer. Take care not to cut into the base HDPE layer. **DO NOT ATTEMPT TO FUSE (OR HEAT SHRINK) THE JOINT CLOSURE TO THE PROTECTIVE HDPE.** Trim the protective HDPE approximately 6" back from the end of insulation and perform the normal joint kit insulation.

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



# HDPE PRESSURE TESTABLE JOINT CLOSURE INSTRUCTIONS

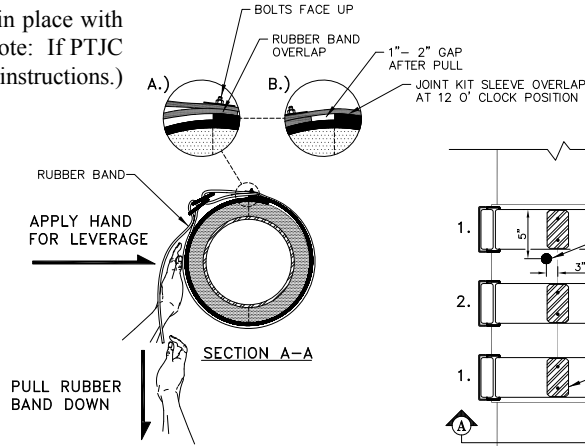
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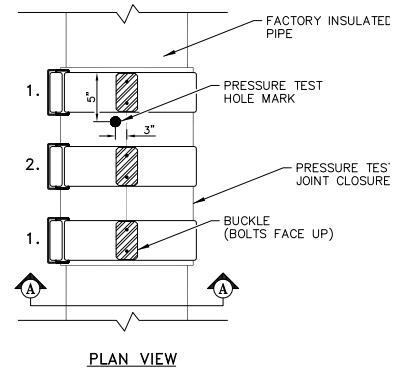
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Wrap the Pressure Testable Joint Closure (PTJC) Sleeve tightly over the insulated joint with the longitudinal seam at 12 O'Clock position. Joint should overlap 2 to 4 inches and shall be centered over the joint. Make sure the ends are square to each 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 4.



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 Rubber Band following the same procedure..

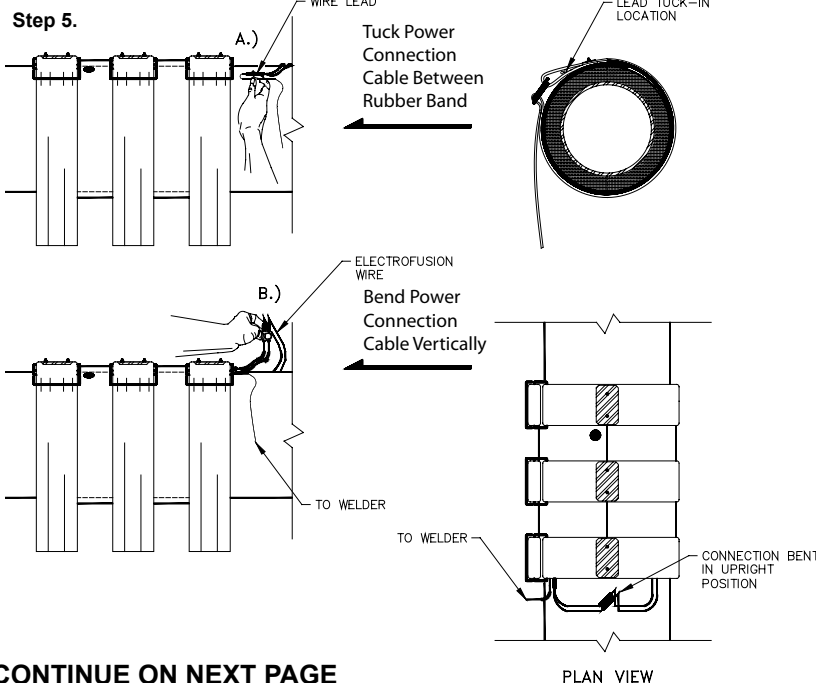
Once all 3 Rubber Bands have been installed, mark the location for the pressure test hole approximately 5" from the end of sleeve and 3" from overlap as shown. Drill a 1" hole using the customer supplied 1" hole saw for the pressure test.

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 (5A), bend the power connection cable upwards as shown in Figure 5B. 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!**



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

NOTE: Power requirement is 12 amps ± 0.1

\*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).

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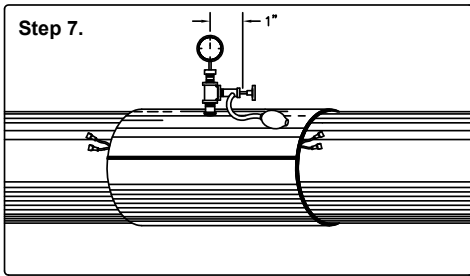


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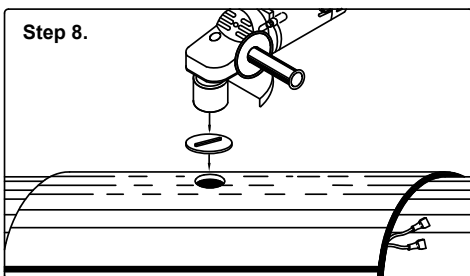
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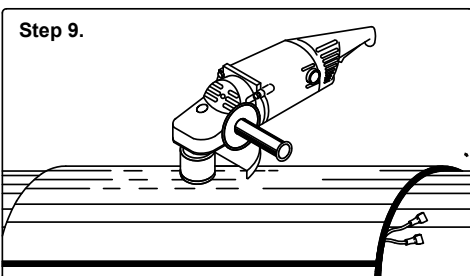
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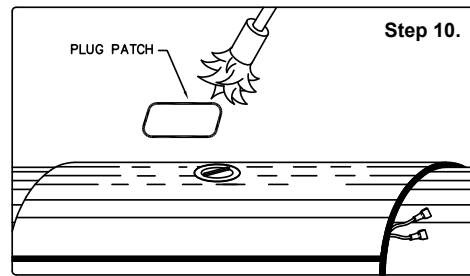
Step 7. Push the Pressure Gauge and Valve Test Device into the Pressure Test hole. Use a hand pump or other air supply to obtain 5 psi pressure. Disconnect air supply and soap joint for "pinhole" leaks. Hold air pressure for 5 minutes. (Note: In rare cases air will escape down the interface between the foam and the jacket. This can be confirmed by soaping the end of the foam and jacket interface). Using 80 grain emery cloth, roughen in a circle 1" larger in diameter than the plug hole and clean with ethanol/ alcohol using a lint free cloth. Clean the surface after roughening using ethanol/ alcohol and a lint free cloth.



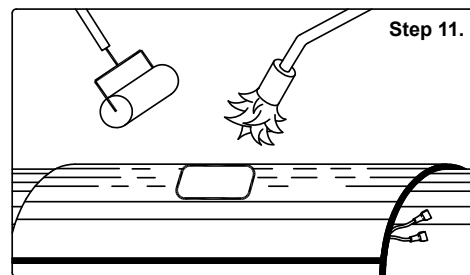
Step 8. Install the special plug drill bit provided by Thermacor into 5/8" side grinder. Fit the raised tongue of the white plug into the groove in the drill bit. Center the raised circle on the plug into the hole in the HDPE jacket.



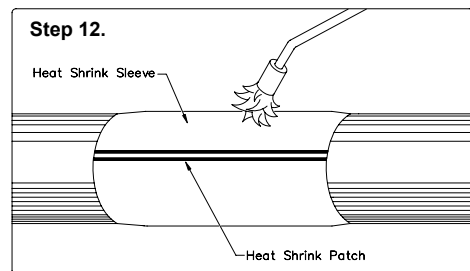
Step 9. Apply firm downward pressure on the plug, then spin the plug at full speed until outside of drill bit touches HDPE jacket (approx. 13 seconds). Stop spinning the plug, **but continue applying downward pressure**. Maintain the downward pressure for another 20 seconds. TAKE CAUTION NOT TO DRILL THROUGH THE ERM WIRE.



Step 10. 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.



Step 11. Visually inspect the installed patch for full contact with jacket, no loose edges, and no holes or cracks in the patch backing. A successful patch should have adhesive flow along the edges. After application, allow the repaired area to cool before backfilling. To prevent damage to the material, use selected backfill material (no sharp stones or large particles).



Step 12. Cut off the Electro-Fusion wires at the PTC sleeve and grind them flush. Install the heat shrink sleeve following the heat shrink sleeve instructions.

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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