

Heat Blankets

for heat-curing adhesive joints in Bondstrand® & Dualoy® pipe and fittings.

General

Heating blankets are specially designed to heat-cure adhesive joints in Bondstrand and Dualoy pipe and fittings. Available for 120-volt or 220-volt alternating current, the blankets are quickly and easily applied. They provide thermostatically controlled heat, helping to assure maximum joint strength and reliability.

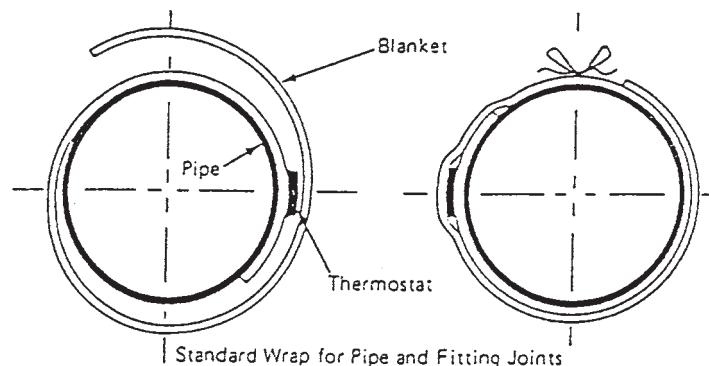
Blankets are available in five sizes and two voltages as follow:

Sizes and Voltages for Bondstrand & Dualoy Heat Blankets							
For Pipe Sizes		Volts	Width		Length		Commodity Code
(mm)	(in)	(ac)	(mm)	(in)	(mm)	(in)	
25-50	1-2	120	50	2*	305	12	12180400
50-100	2-4	120	102	4	508	20	24410400
75-100	3-4	120	50	2*	508	20	34180400
150-200	6-8	120	124	4 ⁷ / ₈	813	32	68180400
250-300	10-12	120	149	5 ⁷ / ₈	1270	50	AB180400
350-400	14-16	120	175	6 ⁷ / ₈	1651	65	CD180400
450-500	18-20	120	254	10	2083	82	EF180400
50-100	2-4	220	102	4	508	20	24420400
150-200	6-8	220	124	4 ⁷ / ₈	813	32	68190400
250-300	10-12	220	149	5 ⁷ / ₈	1270	50	AB190400
350-400	14-16	220	175	6 ⁷ / ₈	1651	65	CD190400
450-500	18-20	220	254	10	2083	82	EF190400

*For use with Dualoy 3000/L or 3000/LCX only

Using the Blanket

Place the thermostat end of the heating blanket against the assembled joint with the thermostat facing out from the joint. Wrap the remainder of the blanket around the joint so that overlap, if any, will cover the thermostat. Tie the blanket in place with any temperature resistant tie or velcro strap. Use caution when removing to avoid burns.

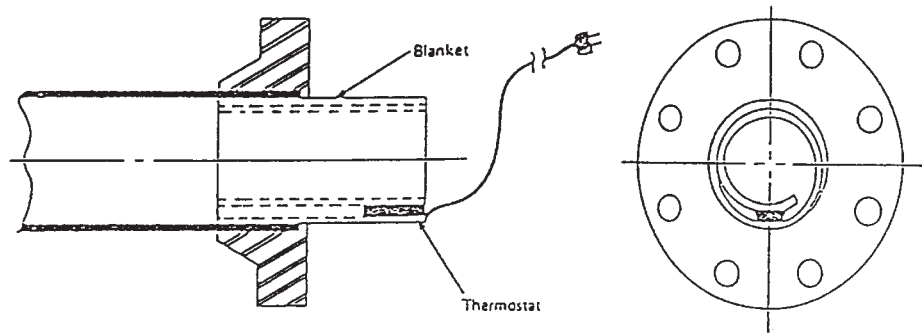


Insulation

It is always a good idea to insulate around the heating blanket and to close the pipe ends. This is essential when it is windy or when air temperature is below 40° F. Fiberglass insulation backed with aluminum foil generally works well. Insulation should overwrap the blanket sides about 4 inches (100 mm) each way and be tied down near the edges to trap the heat. **Caution:** *Joint must not be moved, vibrated or otherwise distributed during cure of adhesive.*

Flange Mounting

Flange mounting requires a special wrap. Lay the blanket flat with the thermostat down and, starting at the thermostat end, roll up the blanket. Insert the rolled blanket into the pipe end only to the depth of the fresh joint, leaving the cord and part of the blanket exposed as shown. Fill the space inside the rolled blanket with fiberglass insulation or some other heat-resistant material to ensure that the blanket remains snugly against the inside joint surface.



Special Wrap for Flange Mounting

Curing the Joint

Determine the required cure time from the Bondstrand assembly instructions found in the adhesive kit.

Warning: *Before applying power, inspect the blanket and cord for loose wire connections and bare wires. Do not plug cord into live power source when standing in water or on wet surfaces.*

Apply alternate current (ac) at the voltage marked on the heating blanket. Do not use direct current (dc) power supply. Mark the start-up and disconnect time on the pipe with a white grease pencil and you will have a record of cure for each joint in the system. Be sure all electrical connections are good and that the blanket actually heats up each time.

Important Notice

This literature and the information and recommendations it contains are based on data reasonably believed to be reliable. However, such factors as variations in environment, application or installation, changes in operating procedures, or extrapolation of data may cause different results. Ameron makes no representation or warranty, express or implied, including warranties of merchantability or fitness for purpose, as to the accuracy, adequacy or completeness of the recommendations or information contained herein. Ameron assumes no liability whatsoever in connection with this literature or the information or recommendations it contains. Product specifications are subject to change.



FIBERGLASS - COMPOSITE PIPE GROUP - HEADQUARTERS
P.O. Box 801148 • Houston, TX 77280 • Tel: (713) 690-7777 • Fax: (713) 690-2842 • <http://www.ameron.com>

Asia
Ameron (Pte) Ltd.
No. 7A, Tuas Avenue 3
Singapore 639407
Tel: 65 861 6118
Fax: 65 862 1302/861 7834

Europe
Ameron B.V.
J.F. Kennedylaan 7
4191 MZ Geldermalsen
The Netherlands
Tel: +31 345 587 587
Fax: +31 345 587 561

Americas
P.O. Box 878
Burkburnett, TX 76354
Tel: (940) 569-1471
Fax: (940) 569-2764

Centron International
P.O. Box 490
600 FM 1195 South
Mineral Wells, Texas 76068
Tel: (940) 325-1341
Fax: (940) 325-9681