

FLX™ Self-Regulating  
Winterization/Freeze Protection  
INSTALLATION PROCEDURES



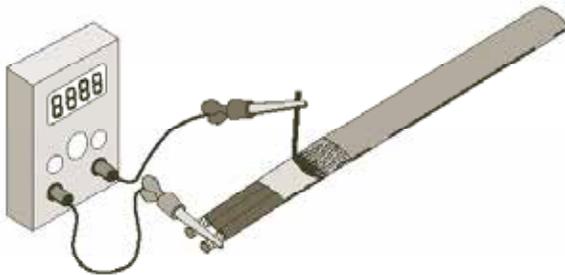
**The Heat Tracing Specialists'**

# FLX™ Self-Regulating

Refer to the “FLX Cable Testing Report” for required recording of test data and circuit information.

## Upon Receiving Cable . . .

1. Upon receiving heating cable, check to make sure the proper type and output have been received. All cables are printed on the outer jacket with part number, voltage rating and watt output.
2. Visually inspect cable for any damage incurred during shipment. The heating cable should be tested to ensure electrical integrity with at least a 500 Vdc megohmmeter (megger) between the heating cable bus wires and the heating cable metallic braid. IEEE 515.1 recommends that the test voltage for polymer insulated heating cables be 2500 Vdc. Minimum resistance should be 20 megohms. (Record 1 on Cable Testing Report.)



Connect the positive lead of the megger to the cable bus wires and the negative lead to the metallic braid.



**CAUTION: DO NOT** connect power to heating cable while it is on reel or in shipping carton.

## Before Installing Cable . . .

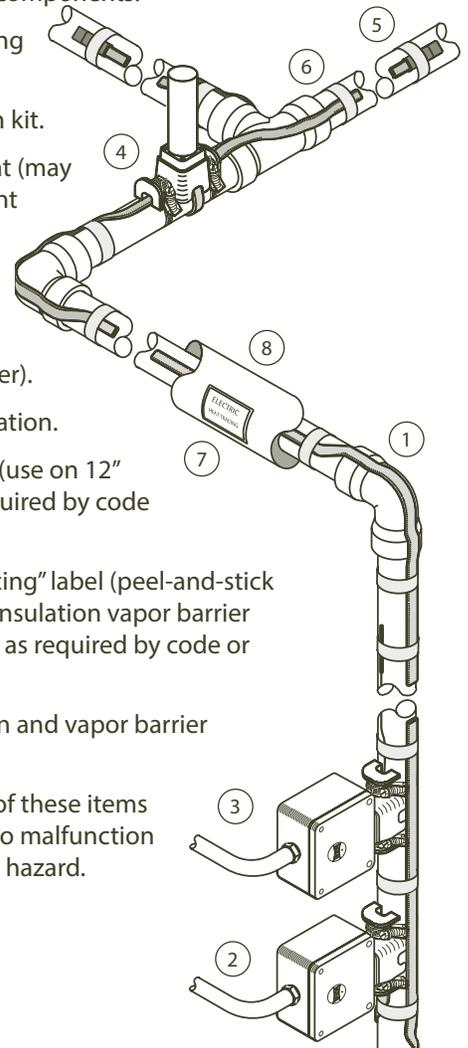
1. Be sure all piping and equipment to be traced is completely installed and pressure tested.
2. Surface areas where heat tracing is to be installed must be reasonably clean. Remove dirt, rust and scale with a wire brush and oil and grease films with a suitable solvent.

## Typical Heat Tracing Installation . . .

A complete electric heat tracing system will typically include the following components:

1. Electric heat tracing cable.
2. Power connection kit.
3. Control thermostat (may be remote ambient sensing control.)
4. In-line/T-splice kit (permits two or three cables to be spliced together).
5. Cable end termination.
6. Attachment tape (use on 12” intervals or as required by code or specification).
7. “Electric Heat Tracing” label (peel-and-stick label attaches to insulation vapor barrier on 10’ intervals or as required by code or specification).
8. Thermal insulation and vapor barrier (by others).

The absence of any of these items can cause a system to malfunction or represent a safety hazard.



The National Electric Code and Canadian Electrical Code require ground-fault protection be provided for all electric heat tracing.



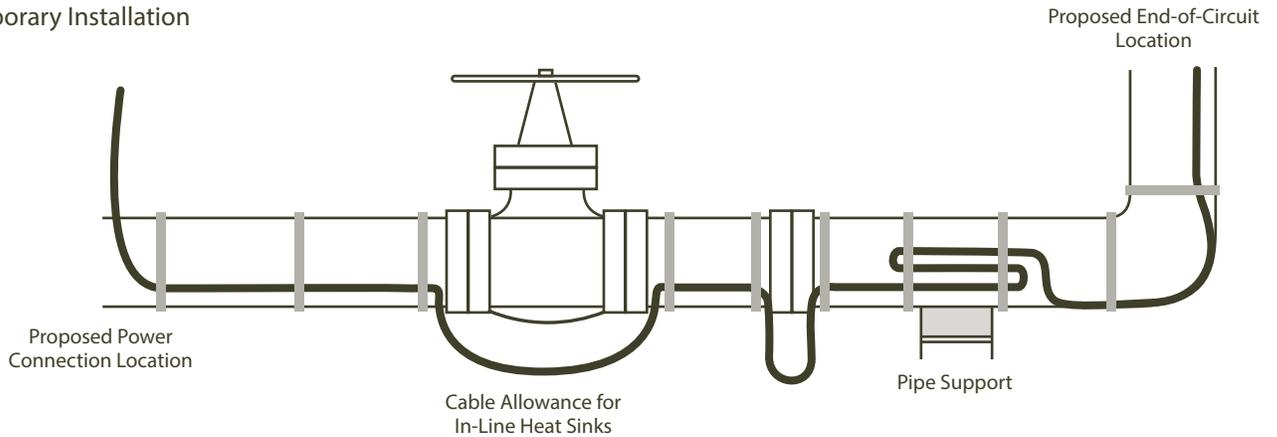
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# INSTALLATION PROCEDURES

## Initial Installation . . .

1. Begin temporary installation at the proposed end-of-circuit location and lay out heating circuit on the pipe, allowing extra cable for the power connection and for any splice locations. Refer to illustration below for temporary installation.
2. Make heating cable allowances for valves, flanges, elbows and supports as per the applicable drawings and table on pages 2 and 3 of these installation procedures. See product specifications sheet for heating cable minimum bend radius.

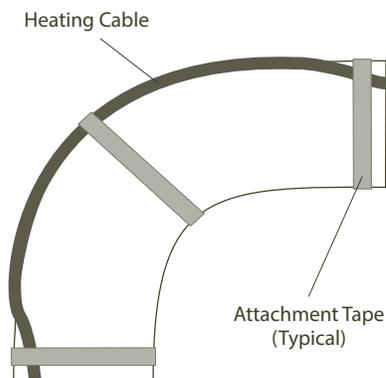
### Temporary Installation



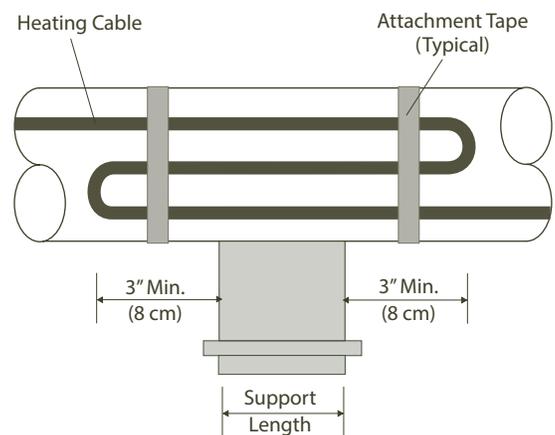
## Installation on Fittings and Equipment . . .

1. Install heating cable in accordance with illustrations below. Secure heating cable to piping using attachment tape.
2. Elbows: Locate the cable on the outside radius of an elbow to provide sufficient heat to compensate for the added piping material. Secure the cable to the pipe on each side of the elbow with attachment tape.
3. Pipe Supports: Insulated pipe supports require no additional heating cable. For uninsulated supports, allow two times the length of the pipe support plus an additional 15" (40 cm) of heating cable.

### Pipe Elbow



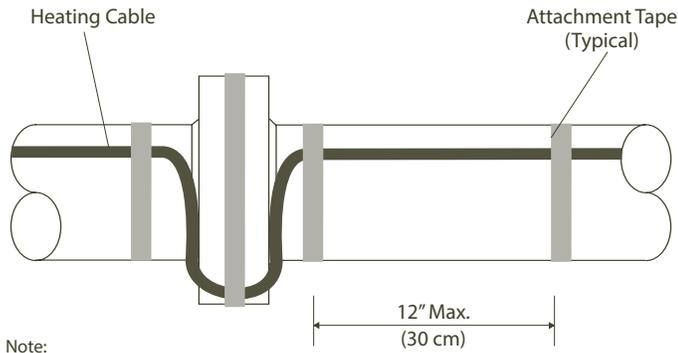
### Pipe Support



# FLX™ Self-Regulating

4. Flanges: Allow cable to be looped around pipe on each side of and adjacent to the flange. Heating cable must maintain contact with flange when bending around pipe flanges to compensate for additional heat loss.

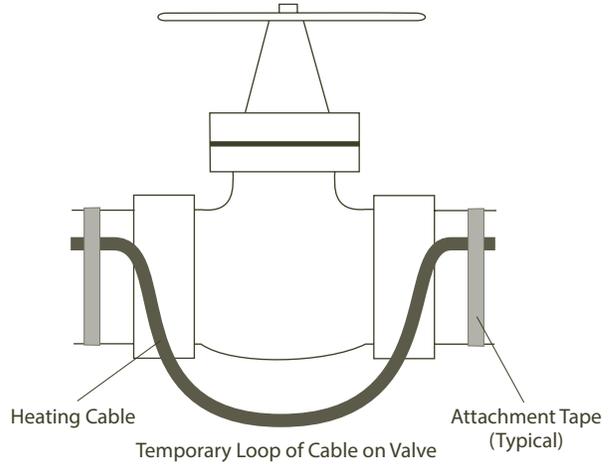
Typical Flange Detail



Note:  
Flange allowance will vary based on method of insulating flange and adjacent piping.

6. Install heating cable on valves and pumps utilizing a looping technique (this allows the valve or pump to be removed if required).

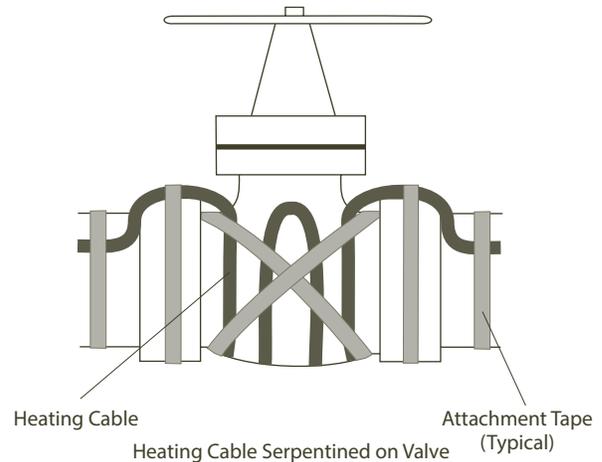
Typical Valve Details



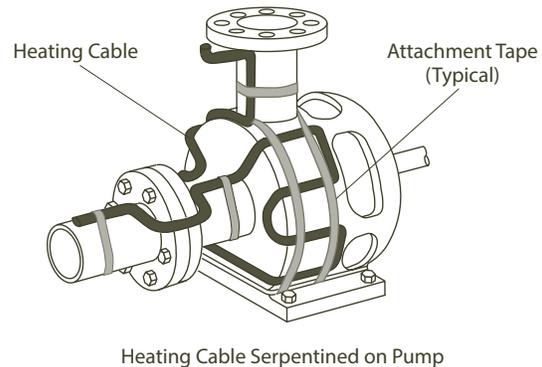
5. Additional cable is required to provide extra heat at valves, pumps and miscellaneous equipment to offset the increased heat loss associated with these items. Refer to Table 1 for estimated cable requirements for installation on typical valves and pumps.

Table 1: Valve and Pump Allowances

Pipe Size	Valve Type			Pump Type	
	Screwed	Flanged	Welded	Screwed	Flanged
½"	6"	1'	0	1'	2'
¾"	9"	1'-6"	0	1'-6"	3'
1"	1'	2'	1'	2'	4'
1¼"	1'-6"	2'	1'	3'	4'-6"
1½"	1'-6"	2'-6"	1'-6"	3'	5'
2"	2'	2'-6"	2'	4'	5'-6"
3"	2'-6"	3'-6"	2'-6"	5'	7'
4"	4'	5'	3'	8'	10'
6"	7'	8'	3'-6"	14'	16'
8"	9'-6"	11'	4'	19'	22'
10"	12'-6"	14'	4'	25'	28'
12"	15'	16'-6"	5'	30'	33'
14"	18'	19'-6"	5'-6"	36'	39'
16"	21'-6"	23'	6'	43'	46'
18"	25'-6"	27'	6'-6"	51'	54'
20"	28'-6"	30'	7'	57'	60'
24"	34'	36'	8'	68'	72'
30"	40'	42'	10'	80'	84'



Typical Pump Detail



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# INSTALLATION PROCEDURES

## Completing the Installation . . .

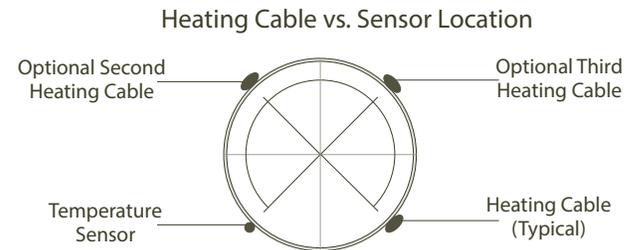
1. Begin final cable attachment by securing the end-of-circuit termination kit and working back toward the power supply.
  - Flexible heating cables are to be installed using attachment tape. Circumferential bands of tape should be installed at 12" (30 cm) intervals to keep the cable in proper contact with the pipe. Refer to Table 2 below to calculate the number of rolls of attachment tape required based on the pipe diameter<sup>1</sup>.
  - If applicable, refer to installation details provided with the project drawings or contact Thermon for additional information regarding installation.
2. In addition to the circumferential tape requirements, a continuous covering of aluminum foil tape may be required when:
  - Spray or foam urethane<sup>2</sup> thermal insulation is applied.
  - Heat tracing nonmetallic piping.
  - Design requirements dictate the use of aluminum tape to improve heat transfer.
3. Complete splice connections (if required) in accordance with the installation instructions provided with the splice kit.
4. Install power connection kit in accordance to the detailed installation instructions provided with the kit.
5. Before making power connections, repeat the megger test with at least a 500 Vdc megohmmeter (megger) between the heating cable bus wires and the heating cable metallic braid. IEEE 515.1 recommends that the test voltage for polymer insulated heating cables be 2500 Vdc. The minimum acceptable level for the megger reading for any polymer-insulated heat tracing cable is 20 megohms. (Record 2 on Cable Testing Report)

Notes . . .

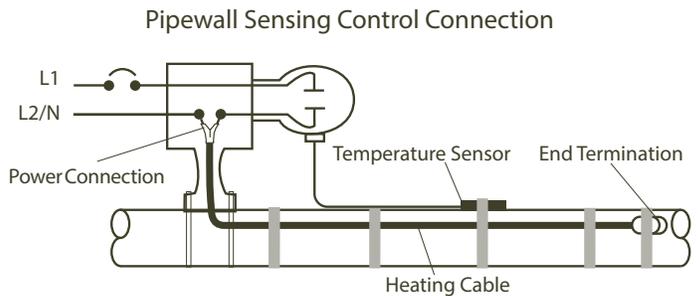
1. Table 2 assumes circumferential bands every 12" (30 cm) along the length of the piping.
2. Verify exposure temperature of heating cable versus curing temperature of insulation.

## Temperature Control . . .

1. When a line sensing controller is specified, the sensor should be placed at least 90° around the circumference from the heating cable, or at least 2" (5 cm) from the cable.



2. For pipewall sensing thermostatic control, the heating circuit is to be connected in series with the control contacts as shown in illustration below. The pipewall sensing thermostat may require more than one support point.



3. When using an ambient sensing temperature controller, the mounting location should be representative of the coldest region, and the sensing element should not be exposed to direct sunlight or any additional heat source.

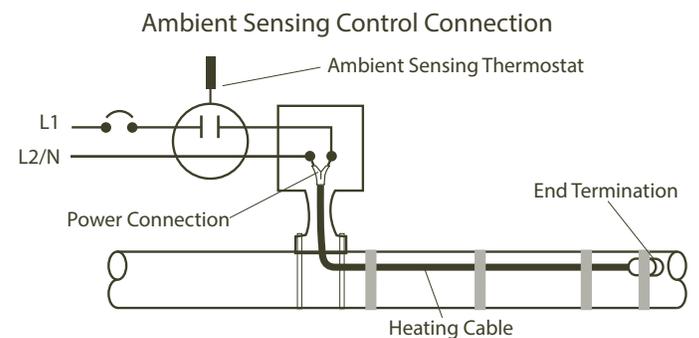


Table 2: Attachment Tape (Value Represents Approximate Linear Pipe Length Allowance Per Roll)

Tape Length	Pipe Diameter in Inches															
	½"-1"	1¼"	1½"	2"	3"	4"	6"	8"	10"	12"	14"	16"	18"	20"	24"	30"
36 yd	130'	115'	110'	95'	75'	65'	50'	40'	35'	30'	26'	23'	21'	19'	16'	13'
60 yd	215'	195'	180'	160'	125'	105'	80'	65'	55'	50'	43'	38'	35'	31'	27'	22'

# FLX™ Self-Regulating

## Thermal Insulation . . .

1. The need for properly installed and well-maintained thermal insulation cannot be overemphasized. Without insulation, heat losses are generally too high to be offset by a conventional heat tracing system.
2. In addition to piping and in-line equipment such as pumps and valves, all heat sinks must be properly insulated. This includes pipe supports, hangers, flanges and, in most cases, valve bonnets.
3. Regardless of the type or thickness of insulation used, a protective barrier should be installed. This protects the insulation from moisture intrusion, physical damage and helps ensure the proper performance of the heat tracing system. Seal around all penetrations through the thermal insulation.
4. After the installation of the thermal insulation and weather barrier but **BEFORE ENERGIZING THE HEATING CIRCUIT**, the megohmmeter test should be repeated. This should call attention to any damage to the heating cable that may have occurred during the insulation installation. (Record 3 on Cable Testing Report)
5. Apply caution labels to insulation weather barrier at required intervals along pipe

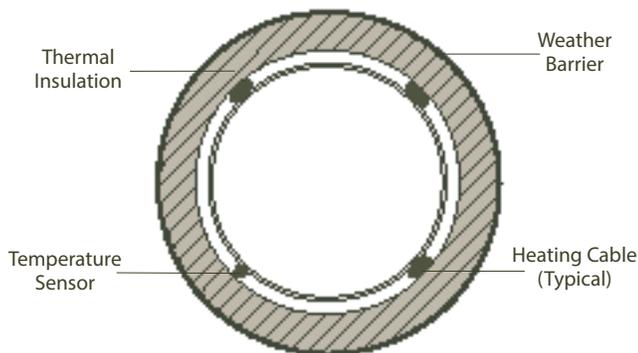
## Final Inspection and Documentation . . .

1. It is recommended that the circuit be temporarily energized so that the volts, amps, pipe temperature and ambient temperature may be recorded. This information may be of value for future reference and should be maintained for the historical operating data log (Record 4 on Cable Testing Report).
2. Once power is connected but before putting the system into operation, verify all heating cable testing and documentation have been completed for each heat tracing circuit. This will ensure that the system has been installed per the manufacturers recommendations.



The National Electric Code and Canadian Electrical Code require ground-fault protection be provided for branch circuits supplying electric heat tracing on fixed outdoor electric de-icing and snow-melting equipment.

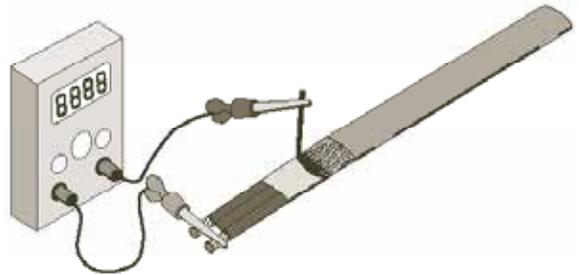
Thermal Insulation with Weather Barrier



The Heat Tracing Specialists'

# FLX™ Cable Testing Report

1. Refer to Thermon FLX Installation Procedures, FORM CPD1018, for general installation procedures, requirements and guidelines.
2. Upon receiving heating cable, check the cable to make sure the proper type and output have been received. All cables are printed on the outer jacket with part number, voltage rating and watt output.
3. Visually inspect cable for any damage incurred during shipment.  
The heating cable should be tested to ensure electrical integrity with at least a 500 Vdc megohmmeter (megger) between the heating cable bus wires and the heating cable metallic braid. IEEE 515.1 recommends that the test voltage for polymer insulated heating cables be 2500 Vdc. Minimum resistance should be 20 megohms. (Record 1 on Cable Testing Report.)
  - A. Connect the positive lead of the megger to the cable bus wires.
  - B. Connect the negative lead of the megger to the metallic braid.
  - C. Energize the megger and record the reading. Readings between 20 megohms and infinity are acceptable. Readings below 20 megohms may mean the electrical insulation has been damaged. Recheck the heating cable for physical damage between the braid and the heating element; small cuts or scuffmarks on the outer jacket will not affect the megger reading unless there was actual penetration through the braid and dielectric insulation jacket.
4. Once the installation is complete, but prior to installation of thermal insulation, recheck the heating cable with at least a 500 Vdc megohmmeter (megger) between the heating cable bus wires and the heating cable metallic braid. IEEE 515.1 recommends that the test voltage for polymer insulated heating cables be 2500 Vdc. Minimum resistance should be 20 megohms. (Record 2 on Cable Testing Report.)
5. After the thermal insulation is installed, the megohmmeter test should be repeated. Minimum resistance should be 20 megohms. (Record 3 on Cable Testing Report.)
6. After the thermal insulation is installed and power supply is completed, record the panel and circuit breaker information. Ensure all junction boxes, temperature controllers, cable glands, etc. are properly secured. Set the temperature controller



**NOTE:** To ensure the heating cable warranty is maintained through installation, the testing outlined on this sheet must be completed on the installed heating cables, and the test results recorded and mailed/faxed to:  
Thermon Customer Service  
100 Thermon Drive  
San Marcos, Texas 78666  
Fax: 512-754-2420

# FLX™ Cable Testing Report

Customer: \_\_\_\_\_

Contractor: \_\_\_\_\_

Address: \_\_\_\_\_

Address: \_\_\_\_\_

Phone No: \_\_\_\_\_

Phone No. \_\_\_\_\_

Project Reference: \_\_\_\_\_

## Record 1: Prior to Installation

Cable Type: \_\_\_\_\_

Heater Length: \_\_\_\_\_

Heater Number: \_\_\_\_\_

Insulation Resistance M Ohms: \_\_\_\_\_

Tested By: \_\_\_\_\_

Date: \_\_\_\_\_

Witnessed By: \_\_\_\_\_

Date: \_\_\_\_\_

## Record 2: After Installation

Insulation Resistance M Ohms: \_\_\_\_\_

Tested By: \_\_\_\_\_

Date: \_\_\_\_\_

Witnessed By: \_\_\_\_\_

Date: \_\_\_\_\_

## Record 3: After Thermal Insulation is Installed

Insulation Resistance M Ohms: \_\_\_\_\_

Tested By: \_\_\_\_\_

Date: \_\_\_\_\_

Witnessed By: \_\_\_\_\_

Date: \_\_\_\_\_

## Record 4: Final Commissioning

Panel Number: \_\_\_\_\_

Breaker Number: \_\_\_\_\_

Volts: \_\_\_\_\_

Ambient Temperature (deg. F): \_\_\_\_\_

Recorded Amps: \_\_\_\_\_

Tested By: \_\_\_\_\_

Date: \_\_\_\_\_

Witnessed By: \_\_\_\_\_

Date: \_\_\_\_\_

## Other Products . . .

Thermon offers additional cut-to-length cables or complete turn-key systems for the following applications:

- Hot Water Temperature Maintenance
- Freezer Floor Frost Heave Prevention
- Tank and Hopper Heating
- Instrument Tubing Bundles
- Control and Monitoring Systems



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