

1"-42" Heating Collar Operating Instructions

Hoop wrap style for Red Thread® II, Green Thread®, Silver Streak® and Z-Core® Piping Systems

ELECTRICAL SPECIFICATIONS

NOV Fiber Glass Systems' heating collars are available for North America (120V) and International (240V) service. International electrical outlet styles vary; therefore, the international heating collars are shipped without a power plug. The 1"-20" heating collars have a single heating grid and power cord whereas the larger 24"-42" have two heating grids requiring two power cords. The 16"-42" heating collars require one 20 amp circuit per power cord (heating grid). **Do not bend or fold electric heating collars as this may result in broken wires and shortened heat collar life.**

Pipe & Fittings



1. One through 16 inch electric heating collars are supplied with a high temperature foam backing to help prevent heat loss when used in cold weather and/or windy conditions. Eighteen through 36 inch electric heating collars do not have the foam backing. When used outdoors or the ambient temperature is below 50°F (10°C), the use of a wool blanket or other insulating material with an R value of 7 or greater is recommended on 18"-42" collars.



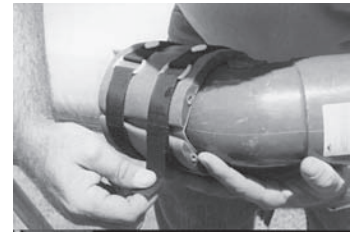
2. The heating collar size should match the pipe size. Using a heating collar that is designed for a larger pipe may shorten the life of the collar. Flanges are cured from the inside and require smaller heat collars.



3. The heating collar should be snugly wrapped around the joint. The un-insulated section of the collar should be placed on bottom.

CAUTION: The uninsulated sections are extremely hot when powered. **DO NOT TOUCH** with bare hands! Heating collars should be cool to the touch so they can be handled safely.

4. Tighten the straps until the heating collar is snug against the joint. Failure to do so will degrade the performance of the collar.



Flanges



1. For 3"-16" flange joints, use a heating collar that is one pipe size smaller than the pipe. For 18"-42" flange joints, use the same size collar. The straps are unnecessary and should be removed from the heating collar.



2. Carefully turn the collar inside out to allow the heated surface to face the interior of the pipe. The heating collar should be cool to the touch so it can be handled safely.



3. Place the heating collar against the inside of the pipe.



4. Use a split ring of pipe to hold the collar in place.



5. For 1", 1½" and 2" flanges, use an industrial heat gun to cure the joint. Hold the heat gun at least 6" from the opening of the flange.

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NOV Fiber Glass Systems

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Saddles

To heat cure a saddle, wrap heating collar over the saddle outlet and snug against saddle. During cool weather, a wind shield is recommended to keep heat on the joint. Saddles require a two-hour heat cure.

If a heating collar is not available, an alternate option is to create a mini-oven around the saddle using aluminum foil and a sufficient heat source for the size of pipe. Maintain oven temperature between 250°F (121°C) and 400°F (204°C) for two hours to ensure complete cure.

Heat Curing

Heat cure times for NOV Fiber Glass Systems piping products and sizes are in the table below. The electric heating collars are designed to fit the fittings and overlap on pipe integral bells and coupling joints. Exceeding the recommended cure time may shorten the life of the heating collar and/or damage the pipe. This is especially a concern on pipe joints where the heating collar overlaps. The use of insulation is recommended below 50°F (10°C) to prevent heat loss. Allow the joint to cool to ambient temperature before placing any load on the bonded joint.

Adhesive Cure Times for Electric Heating Collars

Piping System	Diameter Inches	Cure Time (Minutes)		
		Pipe ⁽¹⁾	Fitting	Flange
Red Thread® II Green Thread® Silver Streak® Adhesive Series 2000 or 8000	1-6	12	20	15 ⁽²⁾
	8	20	20	20
	10	27	27	35
	12	30	30	30
	14	34	34	34
	16	38	38	38
	18-24 30-42	90 120	90 120	90 90
Green Thread 175/250 3033 Adhesive	1-6	30	30	30
	8-12	60	60	60
Green Thread 175/250 8000 Adhesive	14-16	60	60	60 ⁽²⁾
	18-24	90	90	90
Red Thread IIA 7000/8000 Adhesive	2-6	10	20	15

⁽¹⁾ Includes sleeve couplings.

⁽²⁾ For 1" - 2" flanges, cure with an industrial heat gun maintaining the air temperature inside the flange between 250°F (121°C) and 400°F (204°C). Consumer hair dryers are not recommended.

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