

Operator's Manual



McElroy Manufacturing, Inc.

The Leader by Design



Split Heater

Manual: 1243801 Revision: 8/99



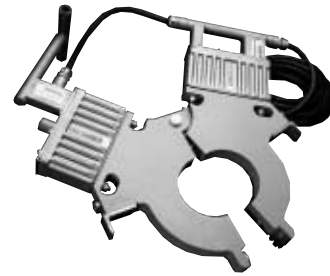
Split Heater Operation for Dual Containment Piping



Description

Split heaters are used for fusing the outer pipe of a dual containment system. Split heaters open enough to go around the inner pipe so that an outer pipe can be heated and fused. The heater has a durable anti-stick coating.

TX01606-12-8-98



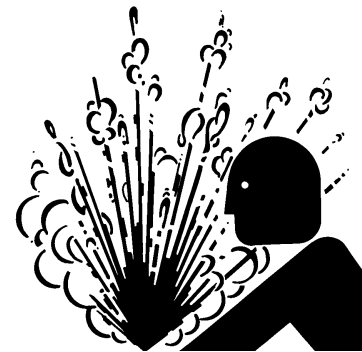
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Heater Is Not Explosion Proof

⚠ DANGER This heater is not explosion proof. Operation of heater in a hazardous environment without necessary safety precautions will result in explosion and death.

If operating in a hazardous environment, the heater should be brought up to temperature in a safe environment, then unplugged before entering the hazardous atmosphere for fusion.

TX00100-9-16-94



WR00034-9-16-94

Heater Temperature

The heater is thermostatically controlled and the temperature has been set at the factory.

The heater's surface should be checked with a pyrometer for correct surface temperature. The thermometers provided on each half of the heater are for reference only and do not reflect the correct surface temperature. If temperature adjustment is required, proceed as follows:

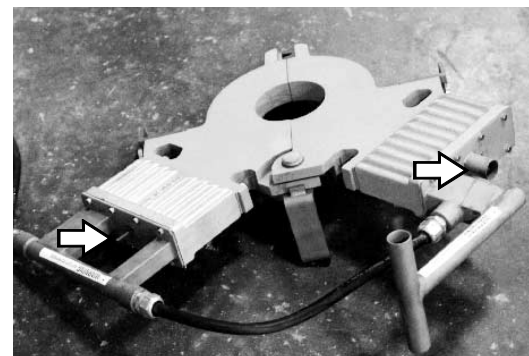
⚠ WARNING Unplug the heater from the power source to avoid electrical shock while making adjustments.

Most heater thermostatic adjustment shafts protrude through the heater handle bases. The 2" x 4" heater adjustment shafts are located under the small side cover plates. Remove one of the screws from the cover plate and loosen the second screw. Rotate the cover plate to expose the shaft.

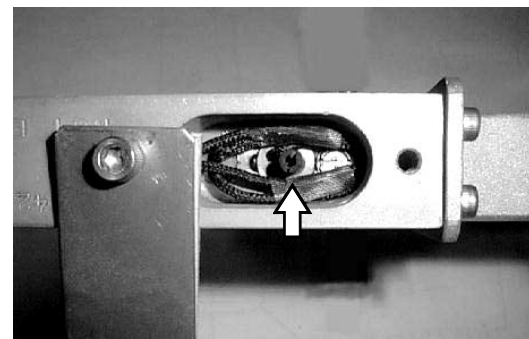
Turn the adjustment shafts clockwise to lower the temperature or counterclockwise to raise the temperature. One full turn equals approximately 100 degrees. Allow the heater to stabilize at the new temperature (5 to 10 minutes) after each adjustment. Both halves of the heater are independently controlled and must be adjusted with the same procedure.

The heater should always be stored in the heater stand or sling for protection of the operator and to minimize heat loss and surface damage.

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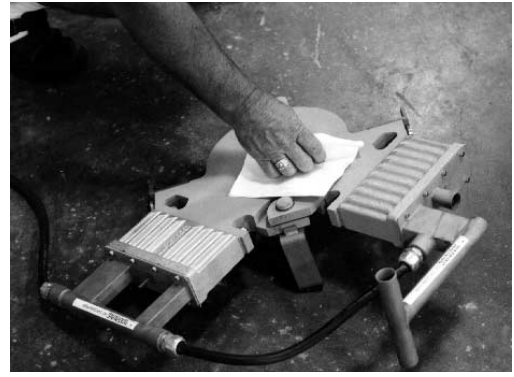


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Clean Heater

To prevent a build-up of residue from the plastic pipe accumulating on the heater (loss of temperature and pipe sticking may result), the heater surface must be cleaned with a clean, non-synthetic cloth before and after every fusion joint.

TX01431-8-5-97



PH01229-8-5-97

Preparation

Plug the heater into the appropriate power supply.

Place the heater in the heater stand or sling and allow sufficient time for the heater to reach operating temperature.

Consult the pipe manufacturer's recommended procedure for fusing dual containment pipe.

Operate the fusion machine according to the operation instructions provided with the unit.

NOTICE: On some fusion machines it may be necessary to remove the facer while using the split heater for butt fusion. When applicable, a facer pivot spacer kit has been provided with the split heater to avoid removal of the facer. Always check for clearance of the heater and facer on the fusion machine before attempting a fusion joint.

TX01433-8-5-97



WR00052-12-1-92

Face Outer Pipe

The ends of the outer pipe must be faced off prior to fusing the inner pipe.

Pull the inner pipes back, out of the way, and face the outer pipe ends.

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PH01230-8-5-97

Face and Fuse Inner Pipe

Pull outer pipe back from inner jaws.

Install proper inserts in inner jaws and clamp the inner pipe ends in position for facing.

Face the inner pipe ends.

Use the standard heater for heating and fuse the pipe following standard procedures provided with the fusion machine.

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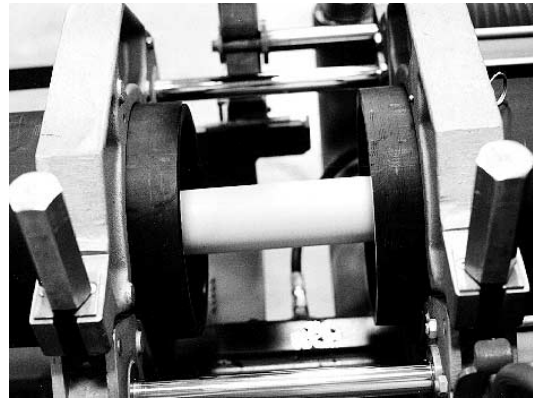
Change Inserts

Remove inserts from inner jaws and install inserts for outer pipe, if required.

Position the outer pipe in the inner jaws with the ends of the pipe protruding past the face of the jaws (this distance is 1" to 1-1/4" for No.28, no.412 and No.618 machines and about 3/4" for a No.14 machine). This distance must be maintained to ensure a proper fit of the heater in the fusion machine.

NOTICE: Failure to correctly set the distance the pipe protrudes from the jaws at the fusion area could result in a bad fusion joint or damage to the heater.

TX01436-8-5-97



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Check Alignment

Bring the ends of the pipe together and check for proper alignment. If there is a high-low misalignment, tighten the high side jaw to bring the ends into alignment.

Separate the pipe ends to allow for bringing the heater in.

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Heating and Fusing Pipe

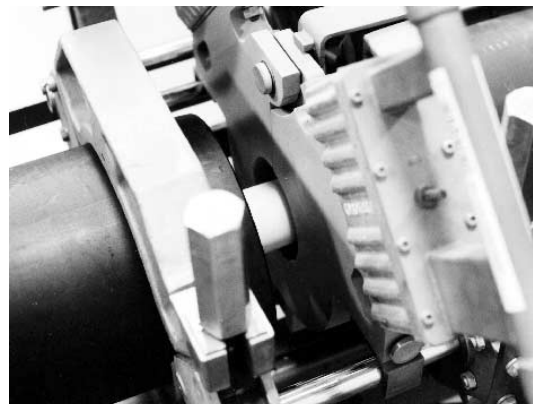
Open the heater to clear the inner pipe and insert the heater to rest on the guide rods between the pipe ends. The catch holding the heater ends together is magnetic. The heater will remain in the closed position during the heating cycle.

Follow the pipe manufacturer's heating procedure.

When heating time is complete, separate the jaws, open the heater and quickly remove it from the fusion machine being careful not to hit the inner pipe or the outer pipe ends.

Quickly bring the pipe ends back together under the pipe manufacturer's recommended pressure. Maintain this pressure until the joint has cooled according to the pipe manufacturer's recommendations.

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