

# GENERAL INSTALLATION

AND INSTRUCTIONS FOR USE OF ALL FLEXELEC PRODUCTS



## BASIC RULES

Persons involved in the installation and testing of electrical trace heating systems shall be suitably trained in all special techniques required. Installations are intended to be carried out under the supervision of a qualified person. Your temperature maintenance system will give trouble-free operation provided it is fitted in accordance with good engineering practice. You should fit and connect up the cables and flexible heating elements as indicated below. Read the instructions carefully: it will be more costly to have to carry out repair work afterwards than to "waste" time reading these instructions to the end and installing your system in keeping with the recommendations given. It is prohibited to use the system in any way that does not respect the precautions for use. Before beginning to fit the heating element, make sure that thermal insulation is fitted immediately afterwards: our products could be damaged by tools or solder, etc. falling on them if too much time elapses between these two operations.

### Warning :

In no event should the heating element be held in the air or enclosed within insulating material while it is operating.  
Do not energise the heating element before fitting it.  
Do not immerse the heating element.  
Do not fit the heating element if it is damaged.  
Do not touch the heating element when it is energised.

Assembly and commissioning are subject to standards (BS 6351 Part3), safety instructions and accident prevention rules in force in each country. **It is prohibited to modify the devices in any way.**

Clean and wipe the outside of the part to be heated. Also check that no sharp parts such as welds, welding flash, metal parts, etc. could damage the heating element.

The whole of the heating element must be in contact with the part to be heated.

In no circumstances should the heating element cross over or overlap itself. Cover the whole of the heating element and the part to be heated with thermal insulation of recommended thickness.

Stick the warning label on the thermal insulation .

The heating element should be energised only when fitting operations are finished.

Connect up to a suitable, properly protected electric power supply.

The electrical protection systems (fuses, circuit-breakers, etc.) must be provided on the site as per the applicable standards in force.

## SPECIAL INSTRUCTIONS

Ensure that the flexible heating element chosen is fully appropriate for the requirements of the installation. For this purpose, consult the FLEXELEC technical documents.

Check whether the project requires straight or spiral heat tracing and if extra lengths need to be provided for valves, flanges, pumps, etc.

Heat loss calculations for flanges, valves, piping supports or other elements may turn out to be complex because of difficulty in measuring the exact heat transfer surfaces. Many accessories such as flanges and valves are manufactured according to standards, while others, such as filters or pumps differ from one manufacturer or application to another.

To determine heat losses, follow the recommendations below:

Type	Diameter	Equivalent cable length
Flanges	≤ DN 200	0.3 m
	> DN 200	1.0 m
Valves	≤ DN 200	1.0 m
	> DN 200	3.0 m

**Notes :** The extra length of cable calculated in these 4 cases may not be used in full for practical reasons. All constant poPower cables or self-regulating heating tapes have maximum circuit lengths depending on their power rating and voltage. Consult the FLEXELEC technical documentation.

When fitting heating elements, do not:

- allow them to come into contact with sharp edges,
- apply excessive pulling force to them,
- allow them to be crushed in any way.

The cables must be terminated as soon as possible after fitting to prevent damp entering by non-sealed ends.

• Inspect the heating elements and accessories as soon as you receive them to check that they have not been damaged during transit. It is recommended to carry out measurement of insulation resistance at this stage.

• For constant poPower cables, check that sufficient length has been provided to allow for the incorporated cold tails.

• Allow an extra 0.5 m of self-regulating heating cable to connect to another cable or for a branch joint.

• Always begin heat tracing at the power supply end.

In the case of an installation in an explosive atmosphere, please read carefully paragraph "INSTALLATION IN ATEX OR EXPLOSIVE ATMOSPHERE AREA".

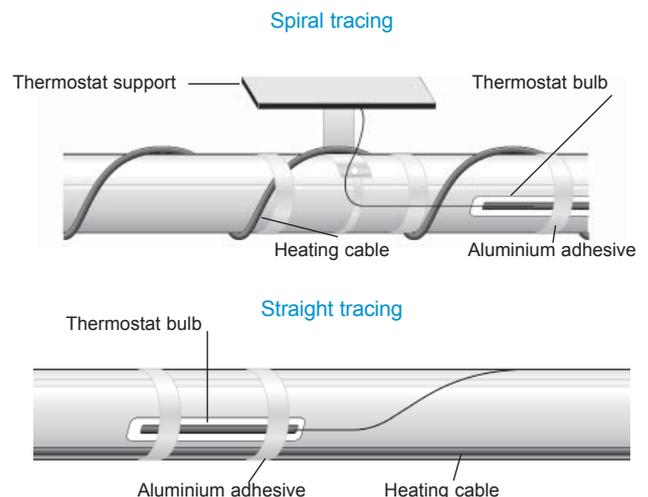
## FITTING THERMOSTATS AND JUNCTION BOXES

To protect against freezing, air thermostats are generally used. These must be fitted in the area most exposed to freezing and can be fixed to the piping or any other support. If they are fitted to piping the heating cable can be connected directly into the thermostat. Self-regulating heating cables can be connected directly to a junction box (a thermostat is not strictly necessary, but strongly recommended). Supports exist for fixing the junction box or thermostat onto the piping.

Bulb and capillary or temperature probe thermostats are normally used for production lines to control the surface temperature and must be fitted immediately adjacent to the power point. Supports exist for fixing the thermostat onto the piping.

First fix the thermostats and junction boxes in the planned locations. For bulb

thermostats, the bulb must always be fixed as shown below:



# INSTRUCTIONS



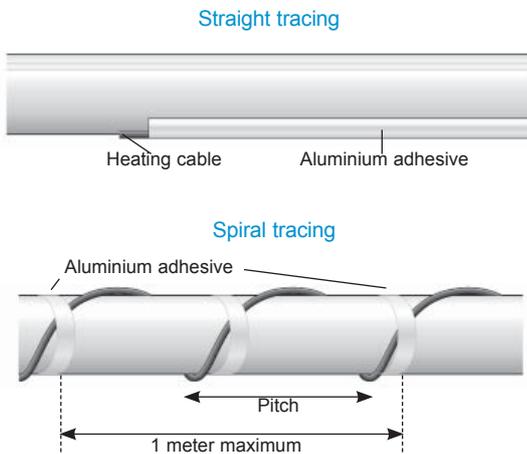
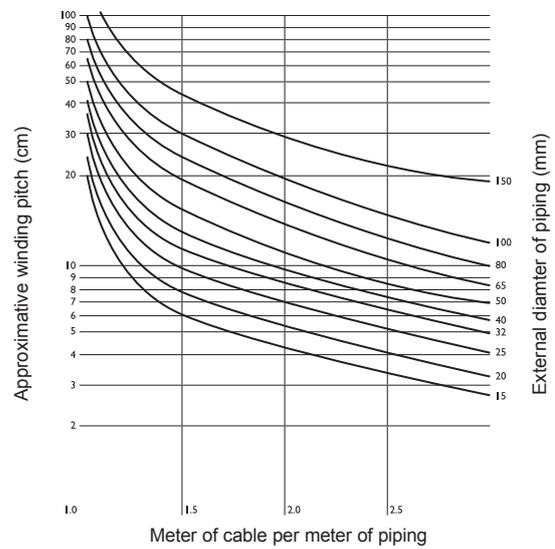
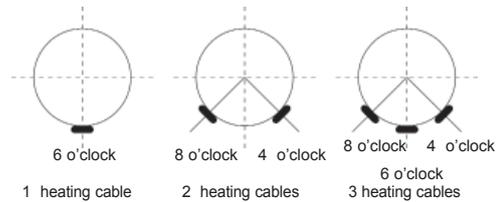
## FITTING HEATING CABLES

(the term "cables" also refers to other flexible heating elements).

The first rule is never to cross heating cables or lay one on top of another.

It is not essential to completely cover the heating element with aluminium adhesive, but this is recommended for the following reasons:

- The heating cable will not be trapped in the thermal insulation.
- Thermal efficiency will be improved through better contact between the heating cable and the piping.
- This eliminates the risk of hot spots on the heating cable.
- This type of fitting is strongly recommended on flanges, valves, taps, etc.



## TRACING PIPING EQUIPMENT: ELBOWS, FLANGES, VALVES AND PIPING SUPPORTS

- Notes :**
- Inverting the screw pitch either side of the equipment makes it easier to remove.
  - Ensure that the heating cable is properly in contact with the equipment.
  - Smooth over any sharp edges as necessary (with an aluminium tape, for example).

Type	Straight tracing	Spiral tracing
Elbows	Trace on the outside of the elbow	Regular pitch, adjacent turns must not touch on the inside
Flanges		
Small diameter valves		
Large diameter valves		

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## PIPING SUPPORTS

Type	Straight tracing	Spiral tracing
Screwed collars		
Welded flat iron bars		
Welded columns		

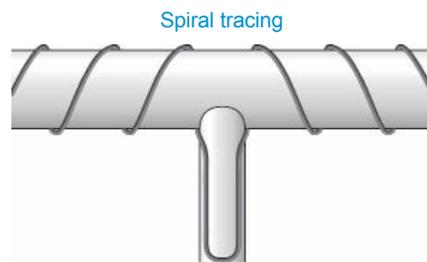
## TRACING A BRANCH JOINT

Branch joints or nozzles are often of a smaller diameter than the main pipe. Return tracing must therefore be avoided on long nozzles as these would increase the installed power to the point of multiplying it by two (straight tracing) and causing local overheating.

Short nozzles: 1.5 m maximum.

Long nozzles: greater than 1.5 m.

For long nozzles, break the circuit and fit a junction box to allow the heating circuit to branch off.

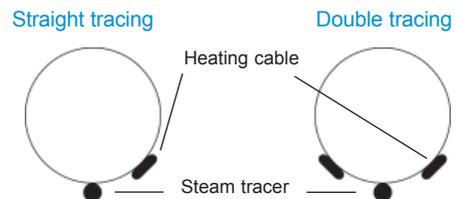


## FITTING A HEATING CABLE TO PIPING WITH A STEAM TRACER

Check that the cable sheath will withstand the temperature of the steam.

Never use spiral tracing, which would cause the cable to come into contact with the steam tracer.

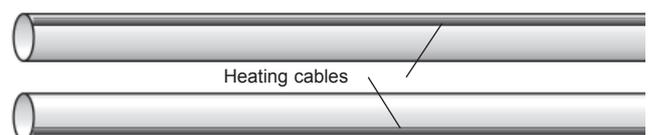
Use single or double straight tracing.



## TRACING TWO PIPES SIDE BY SIDE

Never spiral the heating cable over the piping.

Use double straight tracing.



# INSTRUCTIONS



## INSPECTION

Before fitting the thermal insulation, perform the following inspections:

- Throughout the cable installation process.
- As soon as possible once the installation is finished and before connecting up to the electric power supply.
- If applicable, check that the metal sheath, braid, screen or equivalent electrically conductive covering of the trace heater is connected to an earth terminal.

### Installation inspection

The following inspections must be made:

- The heating cables and temperature probes (if any) are in close contact with the piping; there is no air gap between these devices and the piping.
- No cable loops are hanging in mid air.
- No heating cable is trapped under piping supports, thermostat supports or junction boxes, etc.
- No heating cable is crossed over or laid on top of another, or twisted about itself.
- All the heating cables are fixed to the piping with appropriate fixing materials.

### Circuit continuity and insulation resistance inspection

The following procedure is designed to check that the various heating cables are operating properly.

- Constant poPower cables

- 1 Check the resistance and continuity of the circuits using a multimeter.
- 2 Check the insulation resistance between the conductors and the earth using a 2500 V DC (500V DC min) megohmmeter.

Whatever the length of the cable, the minimum insulation resistance must be 10 megohms.

- 3 The results of the above tests must be recorded and stored.

- Self-regulating heating cables

Check the insulation resistance using a 2500 V DC (500V DC min) megohmmeter. Whatever the length of the cable, the minimum insulation resistance must be 10 megohms. (in case of ATEX area the minimum value should be 20 megohms)

- 1 Between conductors and piping if the cable is not braided.
- 2 Between conductors and braid if any.
- 3 For cables with braid and sheath, perform 2 tests:
  - Test 1: between conductor and braid,
  - Test 2: between braid and metal piping
- 4 As before, record and store the test results.

## MAINTENANCE

### Visual inspection

Visually inspect the piping with tracers to check that neither the insulation nor the cable have been damaged.

### Tracer inspection

The following inspection procedures must be carried out at least once a year (before winter) for installations protecting against freezing or twice a year for production installations.

### Thermal insulation

- The heating cables must always be protected by thermal insulation..
- During inspection operations, be very careful not to damage the heating cables.
- The thermal insulation must always have the same temperature limit as the heating cables.
- The heating cables must never be trapped within the thermal insulation.
- The thermal insulation must be appropriate for the environmental conditions prevailing.
- Apply labels warning that electrical heat tracing is in use on the outside of the thermal insulation at intervals which make it possible for them to be seen clearly, wherever the person working on the piping may be. Do not forget to place them on both sides of the thermal insulation.

### Repair / Modification / Trouble shooting / Others issues

In case you do not find the appropriate information, please contact the technical service on [www.flexelec.com](http://www.flexelec.com).

### Before any inspection work, switch off the electric power supply

- Remove the lid from junction boxes and thermostats. • Disconnect the heating cable from the electric power supply.
- Check, as described above, the insulation resistance rating and, for constant power cables, the resistance rating. Make a note of these figures and store them.
- Compare these figures with those from the previous inspection. If they are the same, reconnect the heating cable and replace the junction box lids.
- With the thermostat still electrically insulated, carry out the inspection as above. Check that the power cables are properly connected to the right terminal block. Using a multimeter, check that the thermostat cuts off power to the heating cables by lowering and raising the temperature setpoint to minimum and then to maximum.
- If the thermostat operates, do not forget to put the setpoint back to the initial temperature.
- Replace the thermostat lid.
- Visually inspect the installation in order to detect any damage to piping or insulation.

## INSTALLATION IN ATEX OR EXPLOSIVE ATMOSPHERE AREA

In case of installation of ATEX products, the following conditions are imperative:

- The personnel involved in the installation and controls must have the appropriate qualification.
- Use the products and accessories in line with the installation requirement.
- The equipment must be certified and suitable for the installation area.
- Documents must be kept for the entire life of the product.