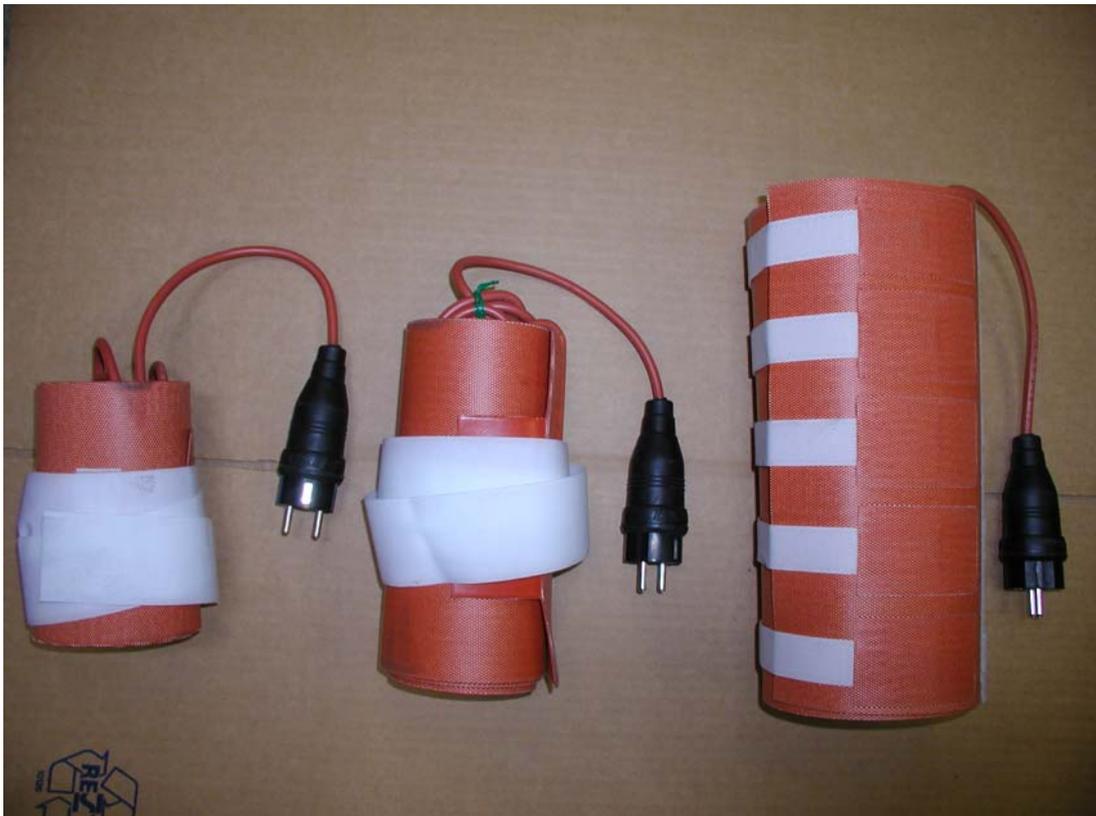


Fiberdur® Heating blankets



Fiberdur® Heating blankets

Hot curing respectively Post-curing

The chemical and mechanical properties depend on the degree of curing of the bondings. The complete sustainability of the bonding is obtained by hot curing, so that every bonding has to be hot-cured. This is the reason why it is necessary to temper the bonding connection with a temperature of 100°C. Fiberdur® heating blankets meet these conditions and by means of temperature regulation their power is adapted to the curing temperatures. The following table shows the recommended temperature and duration of a hot-curing respectively post-curing. The heat can be supplied by an electrical radiant heater or hot-air blower. It should be installed in an adequate distance to the bonding in order to avoid overheating.



Instruction for using flat elements heating blankets

Fiberdur® electrical flat element heating blankets are used in order to guarantee the bondings with EP 220-1 more quickly and optimally.

Please observe the following advice before use:

1. Adhesive residuals on the surface of the pipe and accessory have to be removed mostly.
2. Wrap a separating foil around the bonding area (e.g. Aluminium or copper foil respectively cellophane stripes)
3. Selection of the correct heating blanket size and heating times

Heating blanket sizes

Diameter	Type	Power	Voltage
25 to 80	B	135 W	230 V
100 to 200	C	400 W	230 V
250 to 350	D	760 W	230 V

Heating times

Adhesive	Curing temperature	Curing period Hot curing+Post curing
EP 220-1	100°C	60 min + 60 min

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Application of flat element heating blankets

Wrap the flat element heating blanket around the part of the pipe which has to be cured, by installing the thermostate side of the heating blanket at first (with the thermocouple showing to the outside). The rest of the heating blanket has to be wrapped carefully around the pipe piece which has to be cured, so that the thermostatic element is completely covered.

Afterwards the heating blanket is fixed by the Velcor Blanket or a metal tape in its position.

When bonding collars and fixed flanges the flat element heating blanket can be rolled together and pushed into the pipe end for heating.

It has to be observed that when rolling it has to be started with the end of the blanket opposite to the thermocouple.

For smaller pipe diameters the heating blanket fixes itself, for bigger diameters or in case that it is too soft we recommend to insert a support section (for example a GRP pipe piece of a smaller diameter).

The heating times mentioned in the table above consider the heating phase of the cold pipe connection. Low radiation losses have to be avoided by a heating insulation of the heating blanket winding (e.g. corrugated board)

Attention!

- The flat element heating blankets may not be folded nor in cold nor in warm condition
- It is not allowed to use any solvents, fats or similar for cleaning as they attack the silicone rubber coat
- Please do not tear or rip the connection cable in order to not damage the thermocouple
- A wrong heating blanket size or an inappropriate use can lead to a damage of the heating blanket respectively overheating of the connection piece
- A use is not allowed in case of humid conditions (e.g. rain) respectively if there are cracks or holes in the heating blanket

