

Mechanical Tubing Bundle Bender

Installation Procedures for use with Thermon
TubeTrace[®], ThermoTube[®], & SafeTrace[®] Products



The Heat Tracing Specialists[®]

Mechanical Tubing Bundle Bender

Receiving, Storing and Handling . . .

1. Inspect materials for damage incurred during shipping. Report damages to carrier for settlement.
2. Identify correct tubing bender for the tubing bundle being installed. See Table 1 for bend radius details.
3. Determine lengths and number of fittings prior to uncoiling Thermon tubing bundle since repeated uncoiling and re-coiling may "work harden" the tubing or damage the bundle.
4. Position reel such that tubing bundle may be pulled from the reel allowing installation to begin at an end-point working back toward the reel.
5. To uncoil and straighten tubing bundles, anchor the loose end of the tubing on a flat surface and roll the hand coil or shipping reel. If additional straightening is needed, apply moderate tension to the tubing bundles.
6. Wooden reels or spools of Thermon tubing bundles can be placed on a pay-off tray as shown in Illustration A. To "pay-off" tubing bundles, place the reel containing the tubing bundle on one tray allowing the tubing to freely unspool from the bottom of the reel.
7. Straighten tubing bundle by utilizing a counterspool located in front of the reel containing the tubing (see Illustration A). The counterspool should be located at a distance of 2-1/2 times the diameter of the tubing bundle's shipping reel. Include a vertical offset of 8" to 10" (200 to 250mm) between the reel elevations.



Bending Procedure . . .

Thermon tubing bundles should be installed so there is no strain on any fittings after the installation is complete. The cross-sectional area of the tubing bundle should not be flattened, kinked or wrinkled. Refer to Table 1 for the minimum acceptable bend radius for each type of Thermon tubing bundle. Use a properly sized Thermon mechanical tubing bender to assure constant radius bends where possible. For bend radius greater than 10 inch, use wooden reel or spool as shown below.

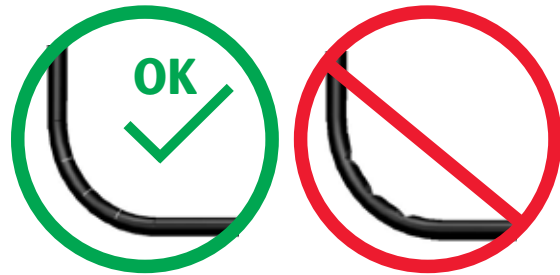
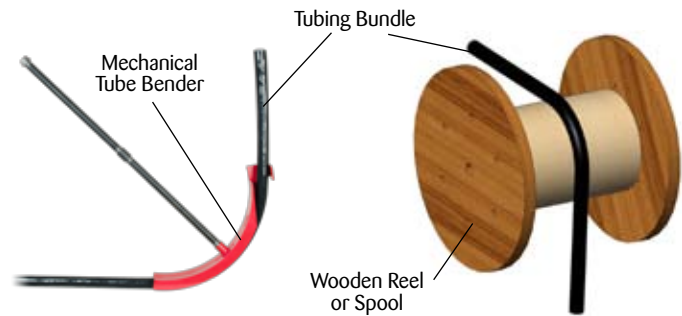
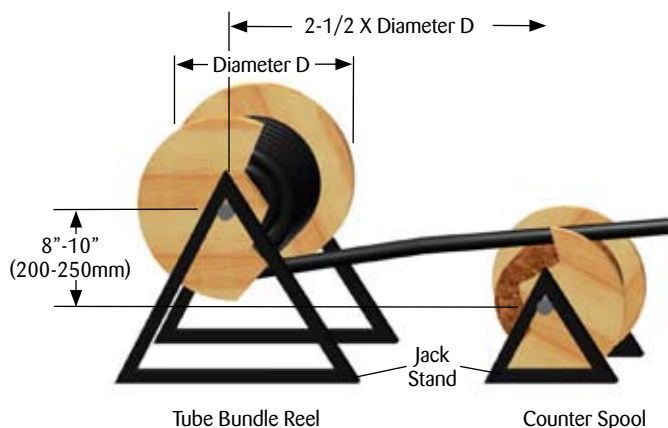


Table 1: Bend Radius

Nominal Bundle O.D. inch (mm)	Minimum Bend Radius inch (mm)
1.3 (33)	6 (152)
1.4 (36)	7 (178)
1.5 (38)	7 (178)
1.7 (43)	8 (203)
1.8 (46)	9 (228)
1.9 (48)	10 (254)
2.1 (53)	11 (279)
2.2 (56)	12 (305)
2.3 (58)	12 (305)
3.0 (76)	16 (406)
3.5 (89)	20 (508)
3.1 (79)	16 (406)

Illustration A: Tubing Payout



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Specifications and information are subject to change without notice. Form 50270-0710

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