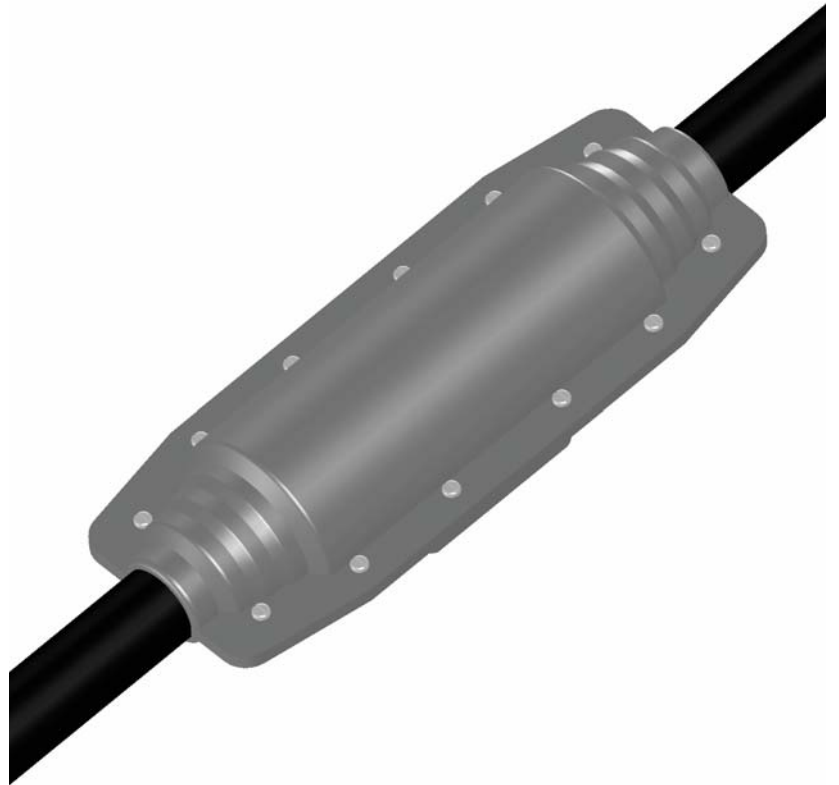


**FAK-4 and FAK-4L Kit for In-Line Splice of  
Tubing Bundles**  
**INSTALLATION PROCEDURES**



**The Heat Tracing Specialists®**

# FAK-4 and FAK-4L: In-Line Splice INSTALLATION PROCEDURES

The FAK-4 and FAK-4L: In-Line Splice Kit is designed to make a waterproof seal over the end of TubeTrace or ThermoTube at the splice connections. Review FAK-4 and FAK-4L Instructions prior to installation. Kit will make one splice connection. (Tube fittings not included. See separate instructions for details on splicing heating cables.)

### Receiving, Storing and Handling . . .

1. Inspect materials for damage incurred during shipping.
2. Report damages to the carrier for settlement.
3. Identify parts against the packing list to ensure the proper type and quantity has been received.
4. Store in dry location.

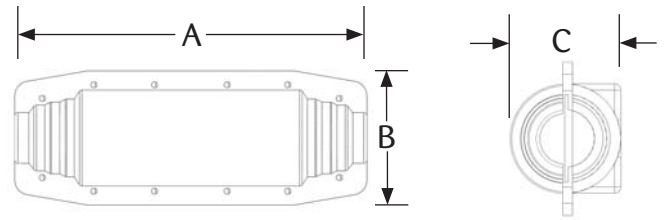
### FAK-4 and FAK-4L: In-Line Splice Kit . . .



### FAK-4 and FAK-4L: In-Line Splice Kit Contents . . .

Item	Quantity	Description
1	1	In-Line Splice Cover (Top)
2	1	In-Line Splice Cover (Bottom)
3	8/12	Pan-Head S.S. Screws, #10-32 x .75
4	8/12	KEPT S.S. Nuts, #10-32
5	1	Heat Reflective Tape
6	1	Glass Fiber Tape
7	2	RTV Sealant Tube

### Dimensions . . .



	A inch (mm)	B inch (mm)	C inch (mm)
FAK-4	11-1/4" (286 mm)	4-5/8" (117 mm)	3-1/4" (83 mm)
FAK-4L	14-5/8" (372 mm)	5-5/8" (143 mm)	4-1/2" (114 mm)

### Installation Precautions . . .

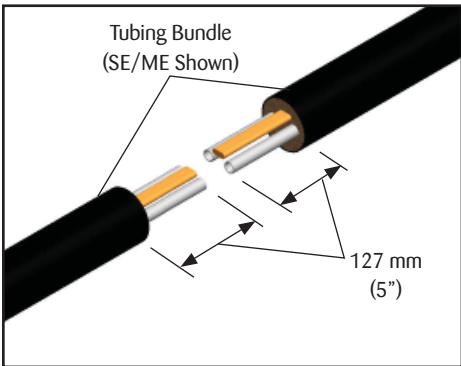
- To minimize the potential for arcing and ground-fault protection. The National Electrical Code (NEC) and Canadian Electrical Code (CEC) require ground-fault protection of equipment for each branch circuit supplying electric heat tracing.
- Installation must comply with Thermon requirements and be installed in accordance with the NEC, CEC, or any other applicable national and local codes.
- Component approvals and performance ratings are based on the use of Thermon specified parts only. User supplied power connection fittings must be listed or certified for intended use.
- De-energize all power sources before opening enclosure.
- Keep ends of heating cable and kit components dry before and during installation.
- Individuals installing these products are responsible for complying with all applicable safety and health guidelines. Proper personal protective equipment, or PPE, should be utilized during installation. Contact Thermon if you have any additional questions.

### Tools Required . . .



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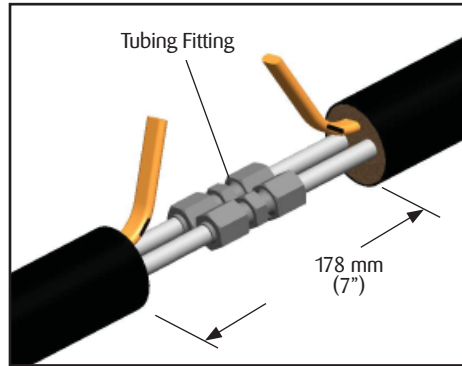
# FAK-4 and FAK-4L: In-Line Splice INSTALLATION PROCEDURES



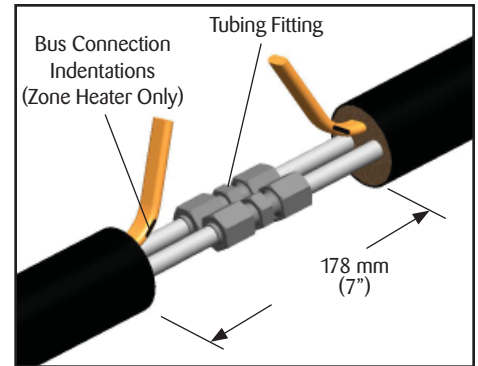
**1.** Remove outer jacket and insulation from tubing bundle approximately 127 mm (5") from end of the tubing bundle. Where required ensure sufficient heat trace is available for electrical splice. See instructions included with heat trace kit.



Do not cut or damage the heat trace.  
(Found on TubeTrace SE/ME bundles)

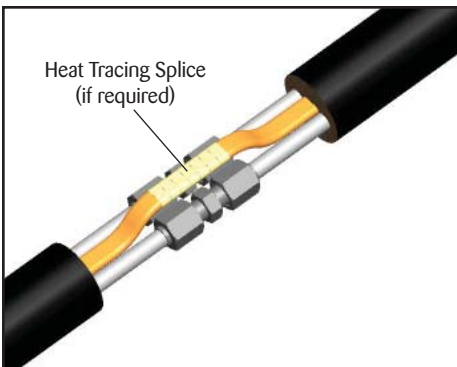


**2.** Cut 38mm (1.5") off the end of the tubing and make tube fitting connections with appropriate fittings, provided by others. If no electrical heat trace is present, go to Step 5.

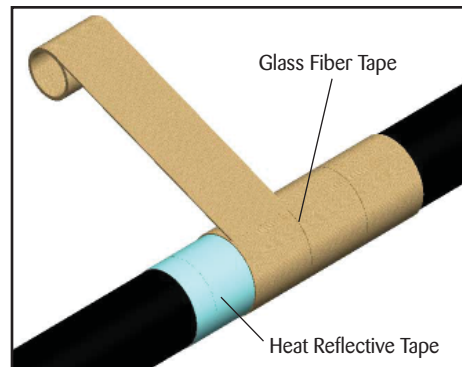


**2a. Zone Type Heat Tracing Only:**

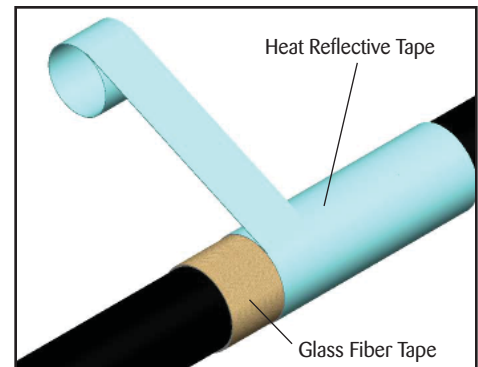
If bus connection indentation is less than 38mm (1.5") from end of the heat tracing, proceed stripping the bundle insulation to the next indentation.



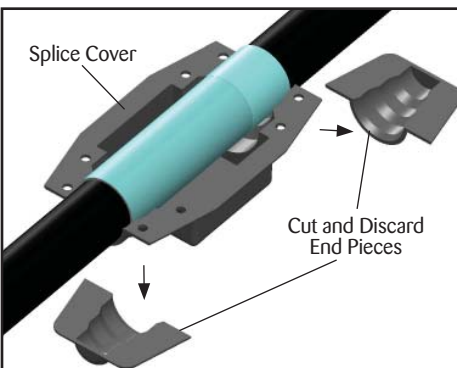
**3.** If bundle includes electric heat trace, make-up splice per instruction included with heat trace kit. This should be accomplished after fittings are leak tested.



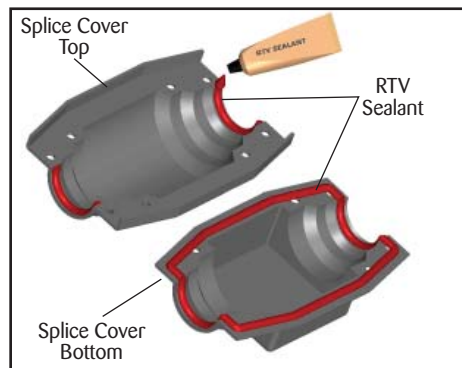
**4.** Wrap tube and heat trace with 1 pass of reflective tape (25% overlap), then wrap with 3 passes of glass fiber tape (50% overlap), or until fiber tape is equal to original bundle insulation thickness.



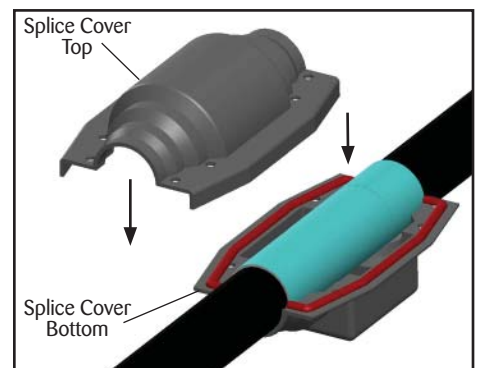
**5.** Complete with additional passes of heat reflective tape.



**6.** Cut top and bottom splice cover ends to match outside diameter of tubing bundle.

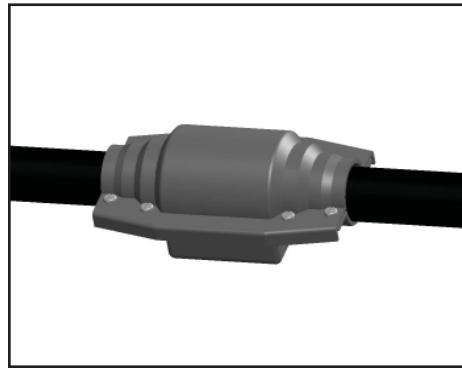
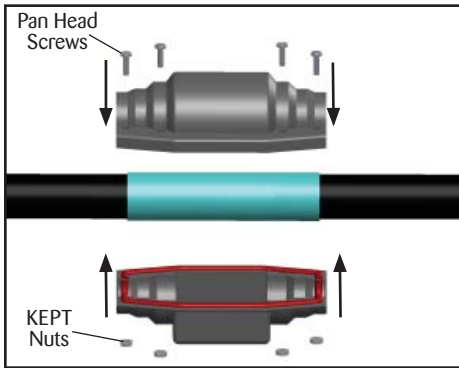


**7.** Form a gasket by applying RTV sealant to bottom half of splice cover and along radius of upper half.



**8.** Fit tubing bundle to bottom half of cover and install top half. Screw down firmly. Inspect ends of tubing splice cover for snug fit. Apply additional RTV sealant where needed.

# FAK-4 and FAK-4L: In-Line Splice      INSTALLATION PROCEDURES



**9.** Assemble FAK Top, tubing bundle, and FAK Base together as shown, using pan head screws, and KEPT nuts.

**10.** Completed FAK-4 or FAK-4L Kit.



**THERMON . . . The Heat Tracing Specialists\***  
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Specifications and information are subject to change without notice. Form PN50046-0612