



INSTALLATION OF HTM-750 & HTM-1250 HEAT TRANSFER MASTIC ON TRACING SYSTEMS

Preparation:

Clean the contact areas on the process pipes and tracer tubing with a wire brush or rag to remove excess rust, dirt and paint scale. A solvent with rag may be used to remove grease and oil residue. If the mastic is to be installed on aluminum surfaces, it is recommended to use a dielectric primer on the surfaces prior to installation.

HTM-750 and HTM-1250 are slightly alkaline and should be kept away from eyes. Wearing gloves and safety goggles is suggested. Waterless soap along with soap and water can be used to clean hands, etc.

Pipe Installation:

If installing pipe line tracers, apply HTM with a pointed or blunt nose trowel. Push the HTM firmly between the tracer tube and the process pipes. HTM should fill the air void between the pipes and extend, in a fillet fashion, to have a contact area on the on the process pipe of approximately 2 times the diameter of the tracer tube. See the installation drawing for details. Installation tools can be occasionally dipped in water to prevent the HTM from sticking to the tools and speed application rates.

Vessel Installation:

If installing on vessel heating/cooling coils, trowel the mastic evenly over the contact surface areas of the heating coils. The mastic will fill-in the irregular surface areas of the coil and vessel wall and provide conductive heat transfer between the coil and vessel wall.

Valve and Pump Installation:

When installing on valves and pump bodies and the thickness of the mastic is greater than 1 inch you may want to install the mastic in 1 inch layers with air drying time of approximately 24 hours between layers. This will prevent sagging and reduce curing times.

Suggestion: If you desire to reduce the viscosity and ease the installation of the mastics, a small amount of water can be added to the container and mixed in with a trowel or drill mixer blade. Add water slowly, since a small addition has a significant effect.

Weather Protection:

Cover the installed HTM with pipe insulation or place a temporary cover of polyethylene (plastic) film over the installation to prevent rain from saturating the mastic. The HTM is water-soluble.

Curing:

The HTM will air cure with time or when heat is applied to the system. It is recommended that if heat is applied, the heating source be kept at approximately 200°F or less to prevent the moisture contained in the wet mastic from boiling and producing air pockets in the HTM. Cure times vary depending on the ambient conditions, but generally curing with heat will require from 12-24 hours. Special curing is not required when using HTM Channels or when the mastic is used with plate type heating/cooling coils or otherwise encased in a metal shroud.

Cleanup:

Cleanup tools with water. Hands and clothing can be cleaned with soap and water or waterless type hand cleaners.

Cured HTM can be removed by soaking or spraying the HTM with water, allowing the water to soften the HTM. Water soaked rags can also be wrapped around the areas to be cleaned. Once the HTM softens, use putty knives and/or pneumatic scrapers and wire brushes to remove the mastic.

Hardened cement can also be mechanically removed by striking with a mallet, hammer or pneumatic chisel. Complete cleaning is **not** required to install new HTM. It will bond well to the earlier HTM substrate.

Storage of Unused Mastic:

When storing the unused HTM, pour a thin layer of water over the top of the mastic remaining in the container. Do not mix this water seal into the HTM. When the time comes to use the HTM, simply pour off the excess water, stir the remaining material with a trowel and apply. As long as the material is not hardened, it is usable. Normal storage of unopened cans ranges from 1 to 3 years, depending on ambient storage conditions.

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