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ThermTrace Regular (TTR) Installation instructions

conditions such as exceeding the maximum operating temperature, in power "on" condition, declared by the manufacturer.



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Safety Instructions

The assembly of all heat trace connections must be completed carefully according to the manufacturer's installation manual supplied with the connection sets. Connections and terminations for installation with this trace heating cable shall be certified according to the requirements of the applicable standards for their types of protection for potential explosive gas and combustible dust atmospheres, as well as the requirements of EN 62086-1 and IEC 60079-30-1 as integral parts of this trace heating system.

For the connection of the HTS ThermTrace Regular series trace heating cables to power certified glands, enclosures and terminals shall be used that are suitable for the application and are correctly installed. The cable glands shall be mounted in an enclosure in such a way that the ingress protection rating IP64 according to EN-IEC 60529 is ensured.

The minimum circuit protection requirements for trace heating systems for use in hazardous areas are as follows:

1. A means of isolating line conductors from the supply;
2. Over-current protection provided for each branch circuit;
3. A means of protecting against earth faults which depend on the type of system earthing (see IEC 60364-3 for definitions). The copper braid must be used as a ground wire, especially as the electrical resistance is less than 18.2 Ω /km.
4. For TT and TN systems: a residual-current protective device for each branch circuit having a rated residual operating current not greater than 300 mA. The device shall have a break time not exceeding 150 ms at five times the rated residual operating current. Values of 30 mA and 30 ms are preferred unless there is evidence that this will result in a marked increase in nuisance tripping.
5. For IT systems: an electrical monitoring device shall be installed to disconnect the supply whenever the electrical resistance is not greater than 50 Ω /V of rated voltage.

Installation regulations:

When installing on locations where explosive atmospheres may be present, regulations of IEC / EN 60079-14 are applicable.

Furthermore in most countries where the product is installed, national regulations may be applicable. Those regulations are mostly obligatory.

In Germany VDE 0100, VDE 0721 Part 1 and Part 2A3 must be observed. Thermal safety class 0 based on VDE 0721 Part 2A3, paragraph E10 is achieved through the construction character of the heating cable.

General rules on handling heating cables

Storage: The heating tapes must be stored in dry and clean places. The storage temperature should be between -55 °C and +65 °C. Keep ends of trace heaters dry before and during installation.

Handling: Avoid excessive pulling or bending of the tape when winding and unwinding during transport and assembly. To avoid damaging the insulation, exercise care if there are any sharp corners and edges, such as for example on flanges or holding devices.

Bending: Never bend the high edge of the tape and never exceed a bending radius of 25 mm.

Installation Instructions

Before installation:

- The surface of the pipe must be dry and clean.
- Check the voltage in the power supply. A deviation from the nominal operating voltage will change the heating power.



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- The size of the protective equipment may not be larger than the heating tape specifications and must agree with the length of tape to be installed. Circuit breakers of type C in conformance with the EN 60898 standard are recommended.
- Only carry out the installation at temperature above the specified minimum installation temperature.
- Before installing any connection to the cable, check the electrical resistance between the bus wires and the braid. It must be at least 10 MΩ for a minimum supply voltage of 500 Vdc. The use of 2500 Vdc megohmmeter is recommended.

De-energise all power circuits before installation or servicing.

Only use connection systems that protect the electrical connection and the cable ends against the penetration of water or moisture.

The metal sheath/braid of this trace heater must be connected to a suitable earthing terminal.

Do not splice the bus wires. This would result in a short circuit.

The presence of the trace heaters shall be made evident by the posting of caution signs or markings at appropriate locations and/or at frequent intervals along the circuit.

- This trace heating cable shall be installed by an electrician trained for installation of trace heating.
- Unwind the heating cable from the spool in a straight manner and cut to size. Do not exceed the maximum installation circuit lengths.
- Improper installation or the use of improper components must be avoided to prevent moisture migration which can lead to electrical arcing.
- Every defective cable or component must be replaced as soon as possible.
- All gaskets used for the heat trace connections must be replaced after every disassembly.

Maximum Circuit Length (m) based on Circuit Breaker Size (Equipment Protection Type C)

	Start-up Temp. (°C)	Operating Voltage ≤ 254 Vac		
		16 A	20 A	32 A
10TTR	+10	205	205	205
	-15	139	186	195
	-30	120	150	195
13TTR	+10	169	179	179
	-15	111	149	174
	-30	94	124	174
15TTR	+10	145	162	162
	-15	93	125	160
	-30	77	106	160
20TTR	+10	116	140	140
	-15	72	93	140
	-30	55	77	110
25TTR	+10	88	117	126
	-15	58	75	117
	-30	45	64	100
33TTR	+10	70	90	108
	-15	49	64	95
	-30	43	52	82



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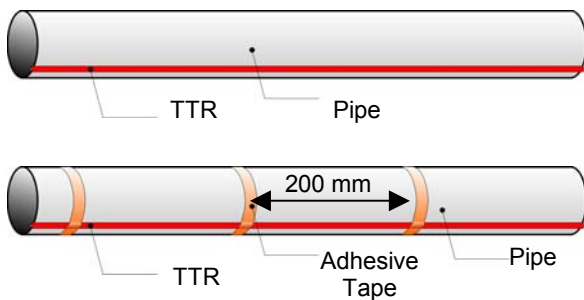
Typical Installation Methods

- As applicable, the heating cable may be wound as a spiral around the heated object or longitudinal to the object. Where possible, to ensure a better heat conduction the heating cable shall be applied longitudinal to the pipe and attached along its flat side.
- The heating cable must be attached to the pipe at max. every 200 mm with temperature resistant adhesive tape.

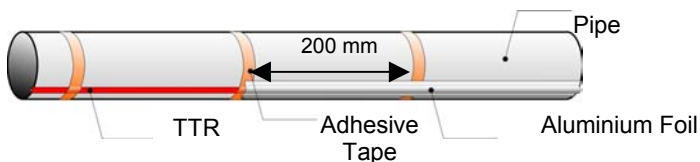
!! Never use adhesive tapes that contain plasticizers or made of PVC. Never use cable ties made of metal or nylon !!

- The thermal conductivity of plastic pipes is much lower than the conductivity of metallic pipes. Therefore it is recommended to put aluminium foil under and over the heating cable to enhance heat distribution and prevent local heat accumulation. Simultaneously the lowered heat transfer due to the lower thermal conductivity of the plastic pipe and the lower heat output of the cable is partially compensated. Check that the installed cables are located where heat is required.

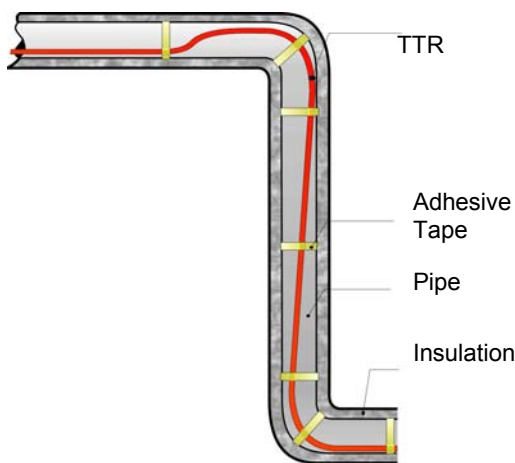
• **On a Pipe**



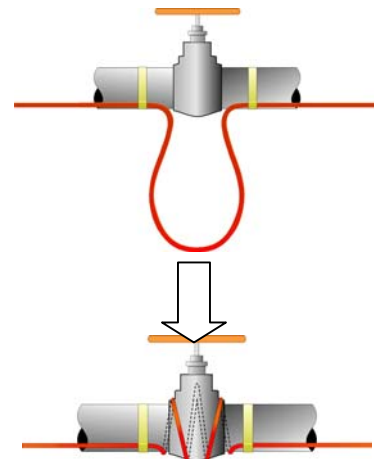
• **On a Plastic Pipe only**



• **On an Elbow**



• **On a Valve**



• **On a Flange**

