

Rovanco® Piping Systems

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Joliet, IL 60431
(815) 741-6700

INS-CTMA

Above Ground Steel Containment with Quick Fit Covers Installation Instructions

Revised 05/21/24

This instruction manual will give you all the information needed in terms of techniques, tools, and accessories required to install ROVANCO Above Ground Steel Containment. If you follow the instructions carefully, the end result will be a high quality, pressure testable containment piping system. Thank you for showing your confidence in ROVANCO by purchasing its products. We sincerely appreciate your business and we will provide you with quality products with a fair price and “great” service to deserve your future business. Please consult your local ROVANCO Manufacturer’s Representative for information about all of the products provided by ROVANCO.

INSPECTION

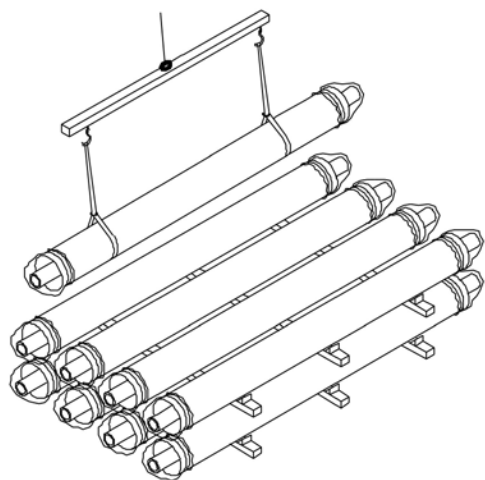
Inspect all shipments on receipt. Examine all pipe and accessories as they are unloaded. Check to insure that every item on the packing list is received. Check the contents of the cartons to insure that the materials have arrived safely. Do not throw the cartons from the vehicle. Handle all materials carefully. Have the freight carrier make out a damage or short receipt if any discrepancies are found. Keep a signed copy of this receipt and notify ROVANCO immediately. All spool pieces shipped have individual part numbers labeled on each end. Refer to your packing list to be sure you have all spool pieces shown. With your paperwork, you will receive two copies of the installation drawings. These drawings will show the location of each piece of ROVANCO Above Ground Steel Containment.

UNLOADING

ROVANCO piping systems are manufactured to withstand normal field handling but, like any piping material, damage can occur from careless handling. The spool pieces should be unloaded from the truck using a cherry picker or other suitable equipment. Lift the pieces with nylon slings and spreader bars so as not to damage the piping, insulation, jacket, conduit or coating. Do not use chains or chokers in direct contact with the piping. **Do not drop spool pieces because this can damage the the piping, insulation, jacket, conduit or coating.**

STORAGE

Use dunnage material under the pipe and between successive layers to protect the casing from foreign objects. Do not stack more than four layers high to avoid excessive weight on the bottom layer. Prior to installation cover the pipe ends with a white tarp or white visqueen to keep out water, excessive dust and debris. If the pipe will be stockpiled in direct sunlight or at temperatures exceeding 90°F, cover the entire system with a white tarp or white visqueen. Do not use opaque, clear or any other color other than white. If these steps are not taken, warranty will be void. There should be a layer of wood dunnage between the pipe and visqueen. Cartons of material (i.e. glue,



foam kits, fiberglass adhesives, etc.) should be stored in a dry area at 60° to 80°F. Liquid foam has a shelf life of 6 months after delivery. Freezing or high temperatures may affect the product’s ability to perform their functions. IF these steps are not taken, warranty will be void.

TESTING

All carrier pipe must be hydro tested prior to insulating, pouring thrust blocks or backfilling the system. Failure to comply with testing procedures will void warranty.

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Testing

All carrier pipes must be hydro-tested and containment must be air tested per the specifications prior to pouring thrust blocks or backfilling the system. Failure to comply with these procedures voids warranty.

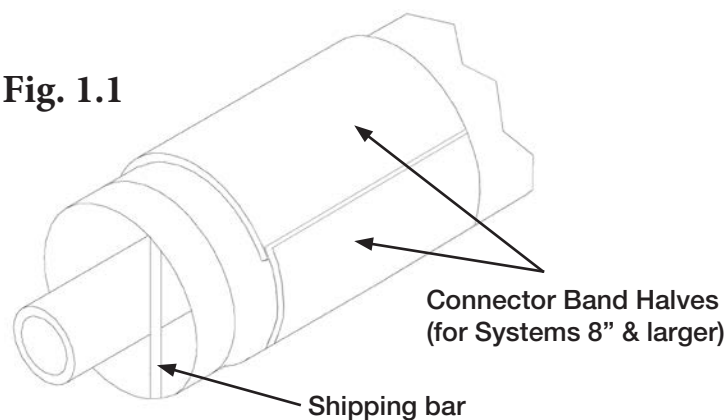
ROVANCO's products and processes are covered under various US patents, including, but not limited to 4,084,842 - 4,484,386 - 4,221,405 - 3,793,411.

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For Leak Detection Installation Instructions, contact Rovanco for INS-RAT

Section 1: Installation of Spool Pieces

Fig. 1.1

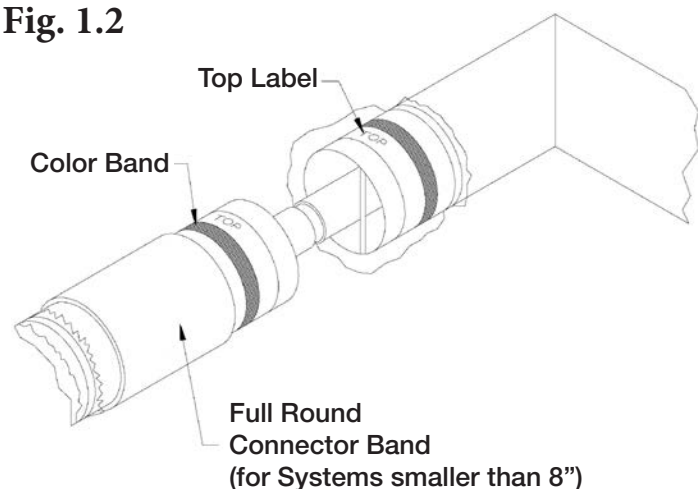


* Note: Shipping bar needs to be removed prior to installation

After the ditch has been opened, the spool pieces should be installed in accordance with the installation drawings bearing the latest revision number. Each spool piece has its own part number which will match the drawing showing its approximate length. There should be a full round connector band (if less than 8" system) over one end of each spool. If not, the connector bands halves (8" and larger system) will come in a crate. It is important that if full round connector bands included that one be on the containment at each joint before welding carrier pipes together. **See Figure 1.1**

If the containment is not going to be installed immediately, leave the plastic bag over the end of the pipe. Plastic garbage bags with the bottoms cut out or plastic sheeting can be taped over the connector band to help prevent water from entering the system should the trench flood. Test cans can be used at the open ends of the systems to prevent water from entering the system. It is very important that the insulation is kept dry during installation!

Fig. 1.2



ROVANCO suggests that you dig bell holes for field welding before lowering the pieces in the ditch. Lower the containment into the trench, using a spreader bar and nylon slings. As pieces are lowered into the ditch, make sure that the trench bottom is free of sharp objects or rocks. If no bedding is specified, ROVANCO recommends 6" of sand or other clean granular material 1/4" or smaller. At no time is wood allowed to be buried as a pipe stand in the ditch. That is a potential failure point on all containment systems. Bags of sand should be used.

Fig. 1.3



Notice that there are colored bands located on the end of some spool pieces. This band is to match an identical colored band of the adjacent piece at the field joint location. **See Figure 1.2**

Fig. 1.4

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-- THE LEADER IN PRE-INSULATED PIPING SYSTEMS --

SHOP ORDER NUMBER:		INSPECTED BY:
PART NUMBER:		
MATCH THIS END TO PART NUMBER:		

This is to ensure that expansion pipe supports are located in the proper areas. Also note that straight lengths coming off an expansion loop or elbow have a ROVANCO label marked TOP on the containment end. This designates that these spool pieces have a top. This must be at the 12 o'clock position before the pipe is welded. This insures that the service pipe can move laterally within this special support. **See Figure 1.3**

See Figures 1.4 for example labels.

Section 2: Pull Rope Instructions

Fig. 2.1



Fig. 2.2

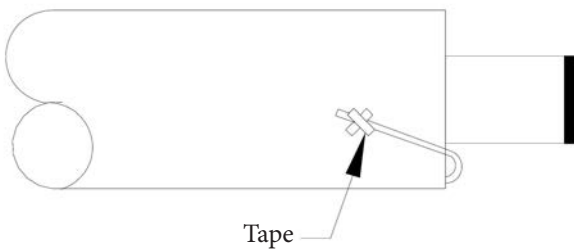


Fig. 2.3

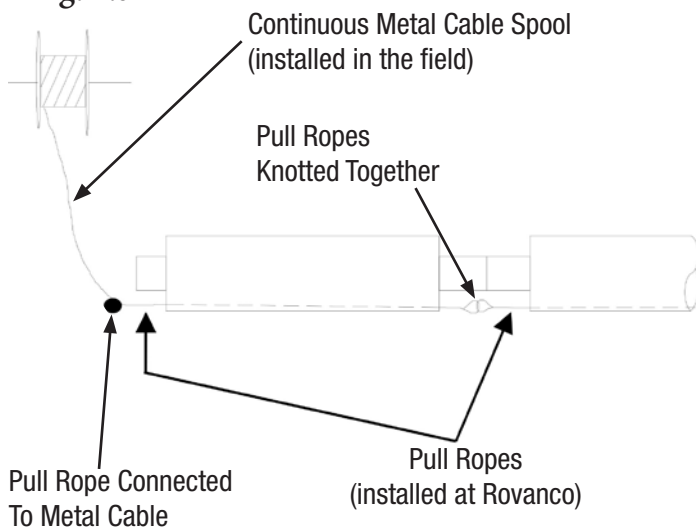
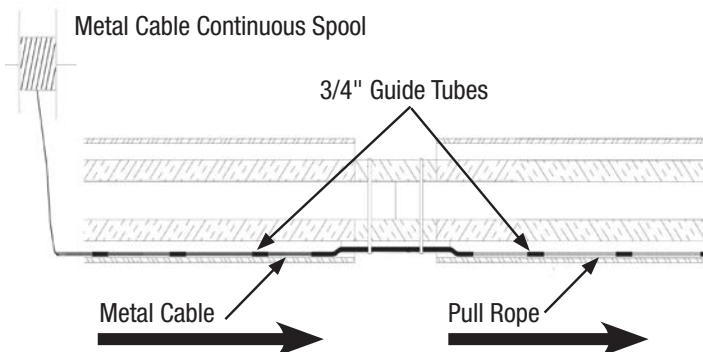


Fig. 2.4



Preparation – Before Carrier Pipe Welding

1. Each piece of pipe will be supplied with its own pull rope which has been threaded through a series of semi-flexible 3/4" guide tubes that are positioned at intervals inside the length of pipe. The end of the rope is taped to the carrier pipe at both ends. Do not cut the rope loose until the pipe is in the trench and carrier pipe is ready to be joined.

See Figure 2.1

2. Once the pipe is in the trench and carrier is ready to be joined, carefully cut the tape loose and tape the rope back to the jacket so the rope does not get burned when welding and free of glue, epoxy or resin on PVC or fiberglass systems. **See Figure 2.2**

Proceed with joining the carrier pipe. If the joints are to be exposed overnight or for any period of time, use a white tarp or white visqueen to seal the joints.

Preparation – Before Pulling Metal Cable

3. Once all of the carrier pipe joints are welded and tested, you are ready to connect the pull rope from one pipe length to the pull rope of another. Use a loop or slip knot to connect pull ropes. Use electrical tape to flatten down any loose ends and to secure knot so the two rope do not pull apart during pulling process.
4. Set up the spool of metal cable at one end of the system. Then connect the pull rope end to the cable. **See Figure 2.3**

The pipe has centering supports with sections of 3/4" containment guides for the pull ropes and metal cable to run through. Make sure the pull rope/metal cable connection does not get bound up in these guides, **it is strongly recommended to tie the pull rope end to the continuous metal cable using the procedure shown on page 5.** This method will minimize issues during the pulling process.

5. Once rope and cable are connected at one end, pull the opposite, loose end of the rope so the continuous metal cable is pulled the full length of the pipe section and follows the rope through the 3/4" guide tubes. The continuous metal cable needs to be pulled enough to move the rope out of the joint area prior to welding containment connector bands. **See Figure 2.4**

TT-Aircraft to TT-PR (Pull Rope) Connection Installation Instructions



Wrap approximately 4 inch end of TT-PR with electrical tape forming a point.



Open up hollow braid approximately 12-14 inches from end to insert taped point into the braiding.



Insert entire taped portion of pull rope end into the braiding.



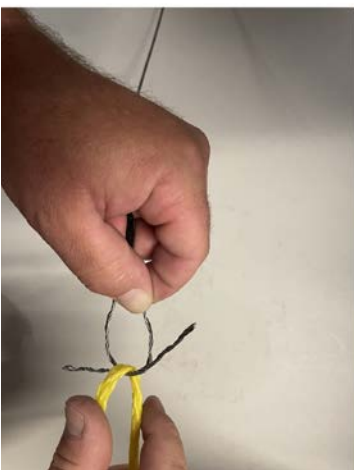
Loop should look like this.



Use Scotch 33+ electrical tape to wrap section where point was inserted into the braid tightly.



Uncoil steel aircraft cable into 2 halves approximately 5 inches long and tape at base of this "V" with electrical tape ("V" hidden under top thumb in this photo). Insert braided loop between these sections.



Loop steel cable around braided cable from each end in opposite directions twisting steel cable end around itself at least 2 times on each side forming a steel cable loop.



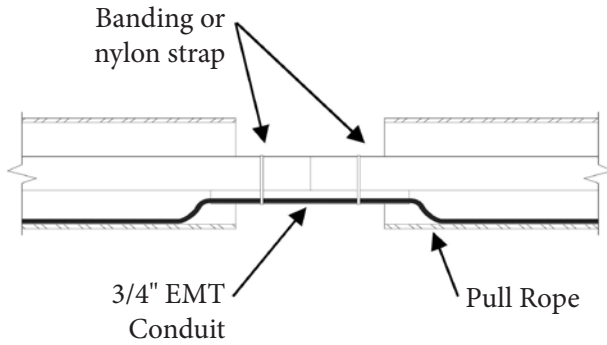
Use pliers to pinch steel cable loop.



Stretch both cables and apply electrical tape from one end to the other, then back to starting point. Note: While wrapping electrical tape, pull to make this tight in order to lower the profile of the section for ease of pulling.

NOTE: Steel aircraft cable to be pulled prior to welding 10 gauge. After 10 gauge has been welded and tested per spec, then the leak detection cable can be pulled.

Fig. 2.5

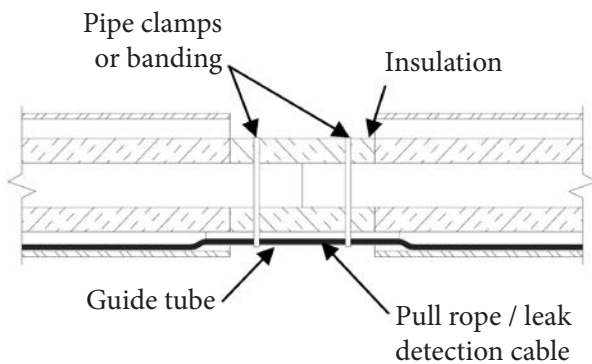


6. The center 15" of the guide tube is flexible. Use banding or nylon strap to position that portion of the guide tube system away from the edges of where the connector bands will be welded. **See Figure 2.5**

Make sure the cable is not stuck or bound up by pulling it in each direction at least 20-ft. If the cable does not move freely check all guide tubes to see if you can find where the issue is and make necessary adjustments.

NOTE: Do not pull the actual Leak Detection Cable through until the connector band welding is complete and system has been tested. This is to prevent the possibility of damage or contamination to the leak detection cable.
Preparation – Before Pulling Leak Detection Cable

Fig. 2.6



7. After the continuous cable is pulled and properly positioned in the joint area, begin the containment connector bands process. **See Figure 2.6**

NOTE: Refer to the pipe installation instruction section for details associated with that procedure. Any other procedures such as fitting, end seal and outer jacket insulating & coupling are covered in their respective sections in the instructions.

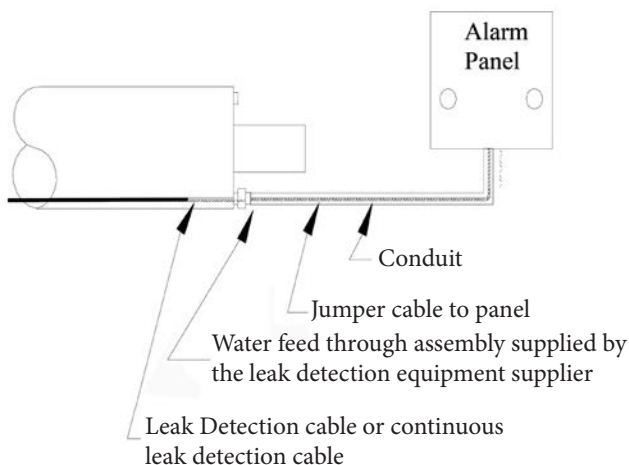
8. After containment connector bands are fully welded and tested, move cable back & forth again to be sure it is still free. Then connect end of metal cable to leak detection cable. You can utilize the same connection process suggested for connecting pull rope to metal cable on **page 5**.

Pull metal cable, now attached to leak detection cable, through the system. This is to be done before insulating and making the outer jacketing joints.

It will depend on the pipe run as to whether you pull leak detection the entire length of a straight pipe run or to a pull port. See specs for details.

It is extremely important to pull the Leak Detection cable and test it prior to backfilling! See Figure 2.7

Fig. 2.7

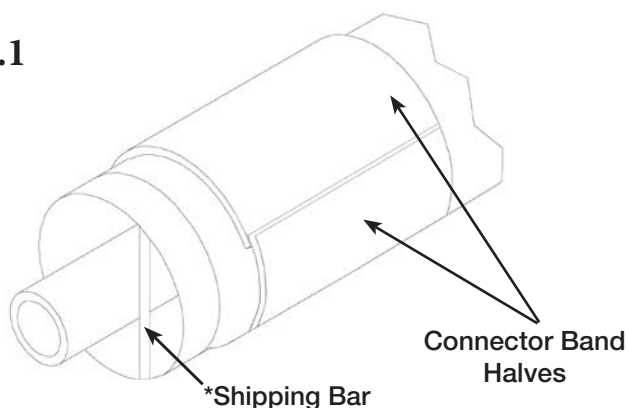


Section 3: Field Alteration of Spool Pieces

Although the ROVANCO spool pieces have been fabricated in accordance with contractor field measurements, sometimes obstructions or errors can require field alteration. Prior to making any field alterations, contact ROVANCO's Customer Service Department in Joliet, Illinois (815) 741-6700, so that we can instruct you in this process and insure that the resulting layout will function properly. This prior notification will also maintain the ROVANCO warranty.

Section 4: Welding of Carrier Pipe

Fig. 4.1



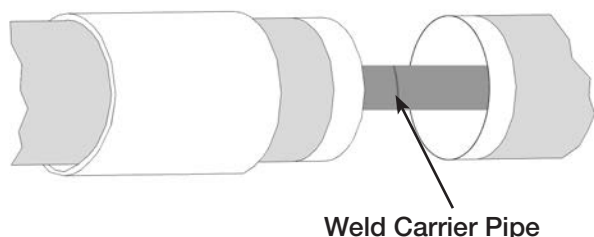
* Note: Shipping bar needs to be removed prior to installation

NOTE: Prior to any carrier field welds, pipe ends must be prepped in the field by contractor.

NOTE: During the welding process do NOT use anti-splatter or any type of lubricant IF your system has leak detection. These materials can cause the leak detection to fail.

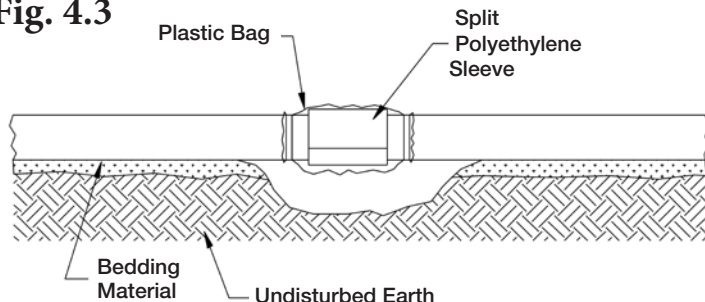
Prior to the welding of the carrier pipe, remove the shipping bar attached between the carrier pipe and outer containment and clean up any remaining weld debris on it. **The shipping bars have been put there to keep the pipe from sliding out of the containment during transit, unloading, and lowering into the trench. These bars must be removed to allow the service pipe to expand during operation. See Figure 4.1.**

Fig. 4.2



After removing the shipping bar, you will find it easier to align the inner pipe. Align and weld the carrier pipe. **See Figure 4.2**

Fig. 4.3



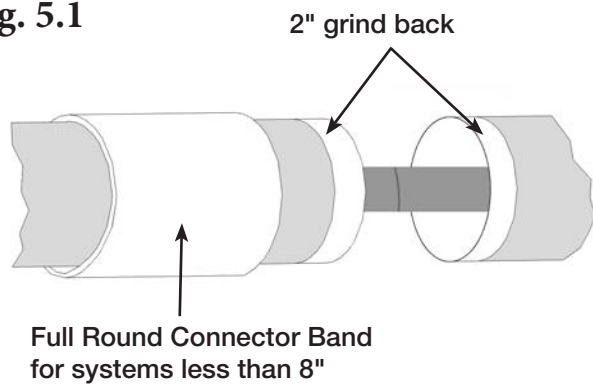
If the carrier pipe is not welded immediately, slide the connector band(s) over the joint, and cover the entire joint with a plastic bag or sheeting as described in Section 1. **See Figure 4.3**

If a hydrostatic test of the carrier pipe is not specified in the contract, ROVANCO recommends that a hydrostatic test be run on the internal pipe at 1½ times the job working pressure. This test should be done prior to insulating the field joints and welding the connector bands closed, to allow inspection and repair of welds if necessary.

If the installing contractor or owner does not want to conduct a hydrostatic pressure test then Rovanco will not be responsible for the cost to excavate and repair any carrier pipe leaks in the system regardless of who made the weld (Rovanco or the installing contractor).

Section 5: Welding and Air Testing of Connector Bands

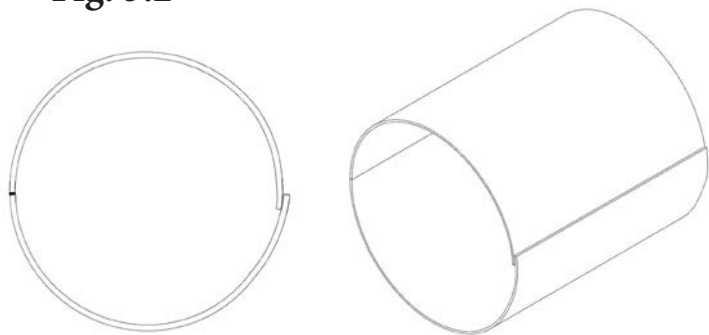
Fig. 5.1



NOTE: During the welding process do **NOT** use anti-splatter or any type of lubricant **IF** your system has leak detection. These materials can cause the leak detection to fail.

NOTE: It is the responsibility of the contractor to grind back both ends of the joint by 2" before installing the connector bands.

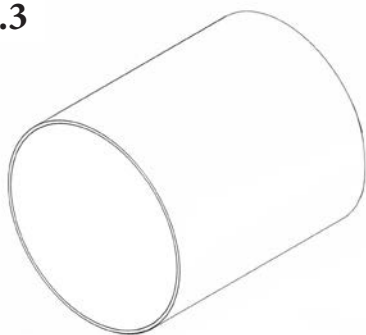
Fig. 5.2



Ends should be ground to clean, bare metal that is free of any coatings to allow the welding of the connector bands. **It is suggested the grinding of the ends be done BEFORE lowering pipe into trench. See Figure 5.1**

NOTE: Connector bands **DO NOT** come coated. They are sent bare unless otherwise stated in specifications.

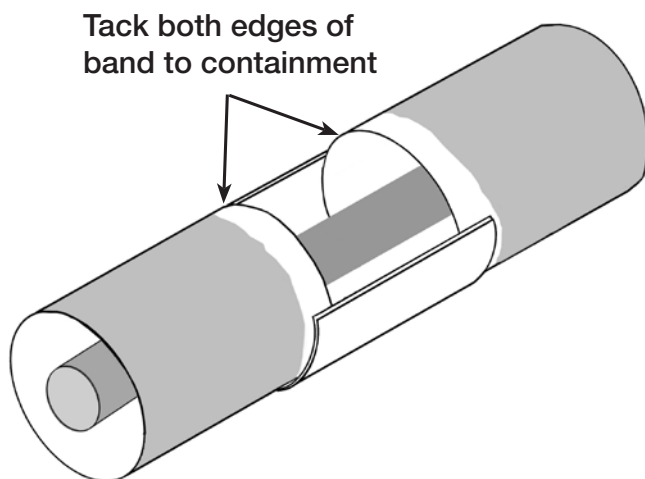
Fig. 5.3



The length of each connector band is 15" to allow an overlap on your 12" joint area. The connector band is supplied in 2 equal length halves so there is no top or bottom half. Once the two bands are in place, centered over the joint, please note that one seam will be a butt fit and the other seam will be an overlap fit. This is the intended fit of the connector band. **See Figure 5.2**

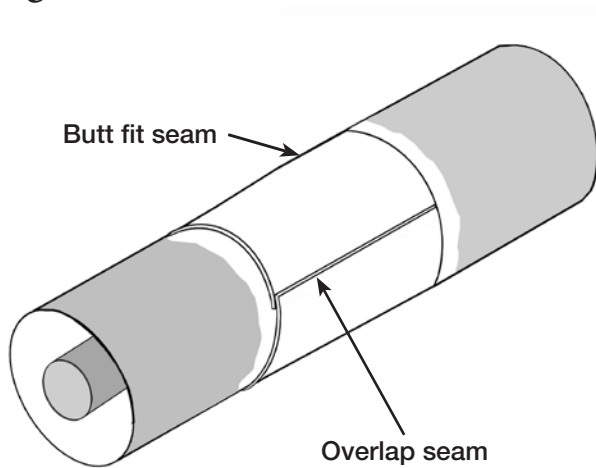
NOTE: If the system is 4" or 6" containment, you will receive full round connector bands that will arrive banded to spools. **See Figure 5.3**

Fig. 5.4



To start (on 8" & larger systems), center one half over the bottom of the joint area. Tack that half in place with a couple quick tacks on each side of the connector band half along the same edge so it is semi-secured to the containment. **See Figure 5.4**

Fig. 5.5

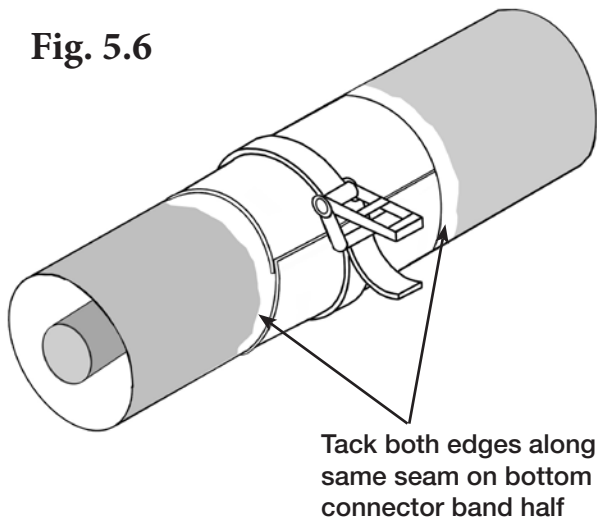


Place the other half of the connector band on top. Remember, one seam will butt fit and the other will overlap. The top half should fit inside the bottom half on the side that overlaps as shown. **See Figure 5.5**

Apply a ratchet tool or chain grips and tighten both halves of the connector band at once until they are pulled tight against the outer containment. Tack top half in place with welds until the whole connector band is secure and will not move. **See Figure 5.6**

Now fully weld the butt fit and overlap seams on the connector band as well as the full perimeter on both ends of the connector band where it meets the containment. When done welding, joint should be air tight. **See Figure 5.7**

Fig. 5.6

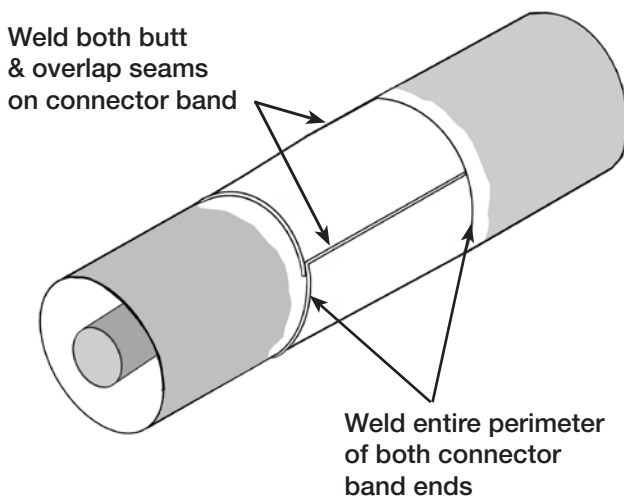


If it is a 4" or 6" system with full round connector band, slid band so centered over joint, apply ratchet tool or chain grips to secure and tack weld in several spots so band will not move. Then weld the full perimeter on both ends of the connector band. There will be no seams to weld.

NOTE: Connector bands DO NOT come coated. They are sent bare unless otherwise stated in specifications. If system is coated, use Rovanco supplied material to coat connector bands after fully welding them.

After all connector bands are fully welded, a 15 psi air test should be put on the inner casing prior to pouring thrust blocks or backfilling the system. Each connector band, gland seal, and testing apparatus should be checked for leaks with a soap and water test. If bubbles appear, a leak exists.

Fig. 5.7



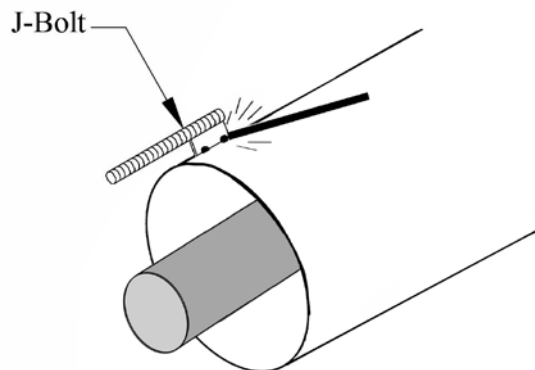
NOTE: Depressurize prior to repairing leak. If you try to repair with the pressure still on the system, you are subject to blowing a larger hole at the leak area. After leak is repaired, retest that area by re-soaping the repaired joint to ensure the leak has been fixed.

If possible, air test system as you install. ROVANCO can provide test cans in case you need to do an air test on only part of the system or on a watershed.

NOTE: After passing the pressure test, if specifications call for the field coating of connector bands, apply coating supplied by Rovanco in accordance to the instructions accompanying the coating.

Section 6: Test Can Applications

Fig. 6.1



After Rovanco receives a release to manufacture, Rovanco's customer service will email test can purchase form to customer. Test cans need to be ordered before the first truck ships so they can ship with the job to save money on freight.

Remove any burrs on containment ends that may have been caused by removing the shipping bar to ensure a proper seal. J bolts are then welded to the outer edge of the containment. **See Figure 6.1**

The test can butts up to an open end unit, is sealed with a gasket, and tightened down with bolts. **It is helpful if a little contact cement or repositionable adhesive is applied to the gasket to help it stay in position on the test can.** Attach a safety chain around the test can and to other end of containment. **See Figures 6.2 and 6.3**

CAUTION: No one in the area is to step in front of the test can during pressurization.

After testing is complete, remove the test can and gasket and cut the J bolts off of containment and grind or file down any burrs.

Fig. 6.2

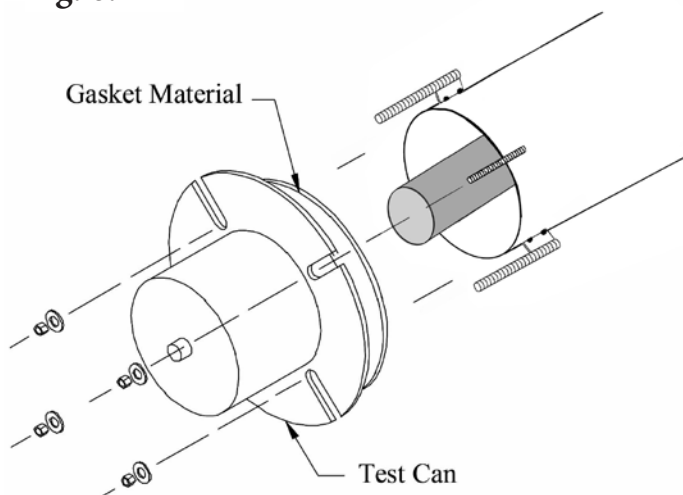
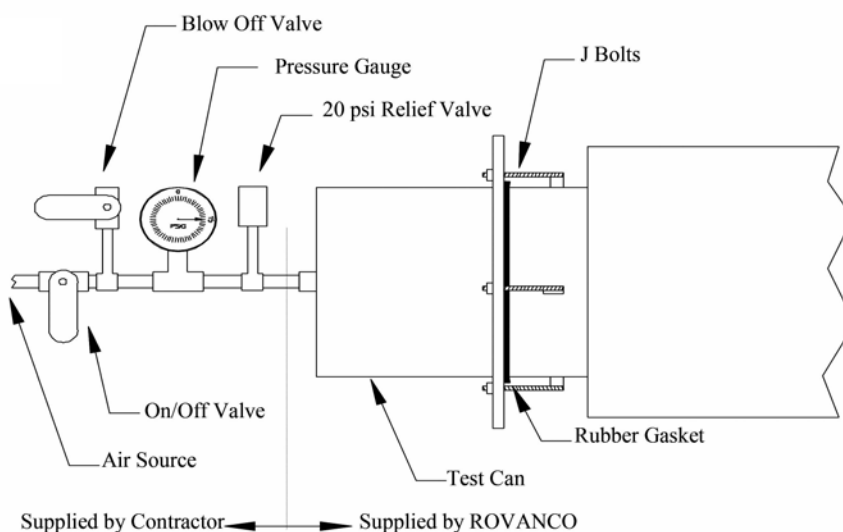


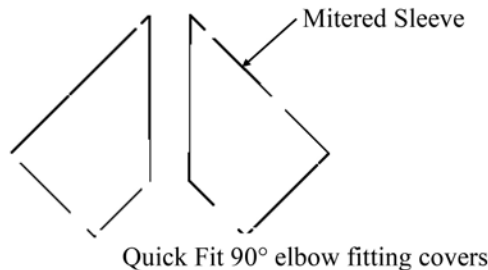
Fig. 6.3



Section 7: Quick Fit 90° & 45° Elbow Instructions – **Smaller Than 8" System**

NOTE: Connector bands & Quick Fit fittings will be bare. For **ABOVE Ground systems**, connector bands and Quick Fit Fittings will need to be field coated with the specified coating. Weld areas, fittings & cuts, scrapes or gauges in the coating should be touched up as well.

Fig. 7A.1

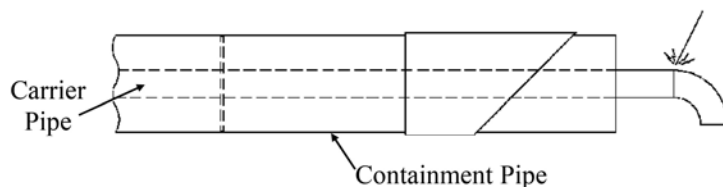


NOTE: Prior to any carrier field welds, pipe ends must be prepped in the field by contractor.

NOTE: During the welding process do NOT use anti-splatter or any type of lubricant IF your system has leak detection. These materials can cause the leak detection to fail. You will receive a Rovanco "Quick Fit" fitting cover kit consisting of two mitered sleeves.

See Figure 7A.1

Fig. 7A.2



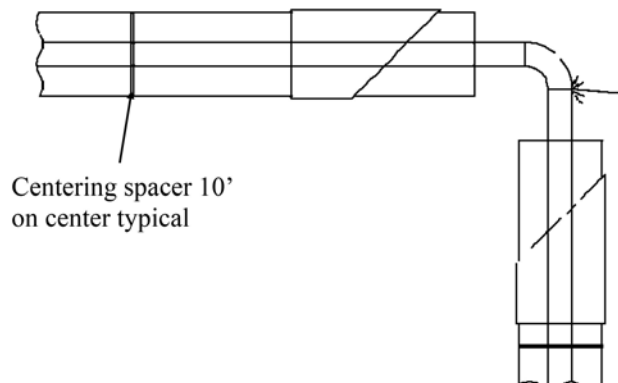
Prior to joining the carrier pipes to the fitting, slide the mitered sleeves onto the containment pipe outer jacket. Weld one side of the carrier pipe fitting into place. **See Figure 7A.2**

Slide the second mitered sleeve over the containment pipe. **See Figure 7A.3**

Fit up the next length of pipe and weld the other side of the fitting.

Test the carrier pipe per specifications.

Fig. 7A.3



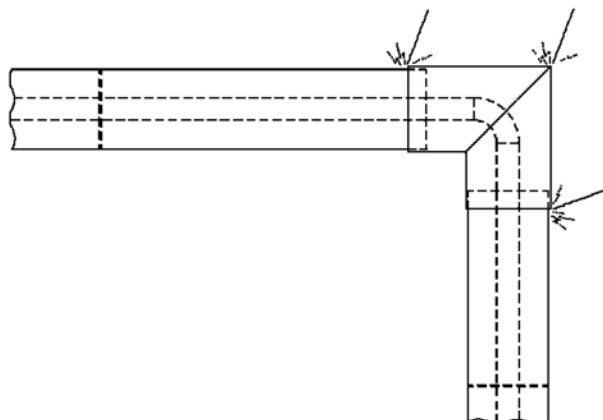
Slide the mitered sleeves into position. Weld all circumferential seams. **See Figure 7A.4**

Unless otherwise specified, Rovanco recommends a 15 psi air test on the conduit jacket. Clean welds and apply a soap and water test to the welds. If bubbles appear, a leak exists.

NOTE: Depressurize prior to repairing leak. If you try to repair with the pressure still on the system, you are subject to blowing a larger hole at the leak area. After leak is repaired, retest that area by re-soaping the repaired joint to ensure the leak has been fixed. If possible, air test system as you install.

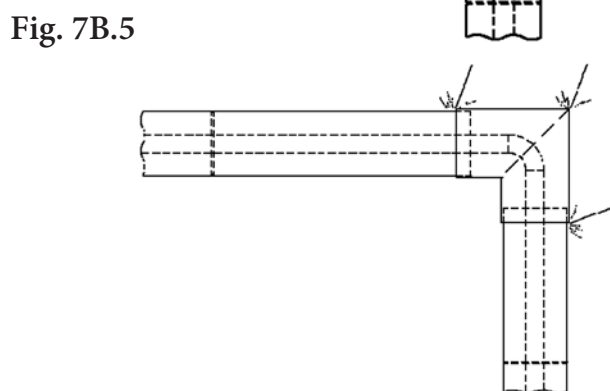
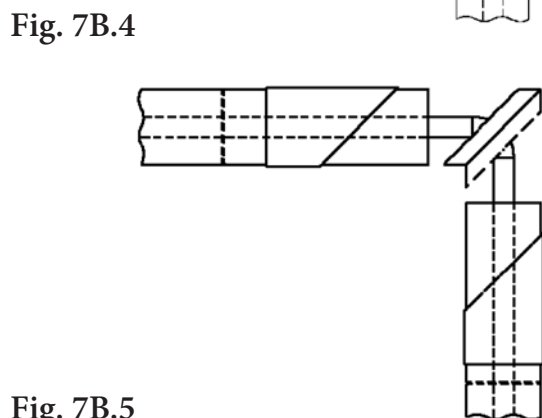
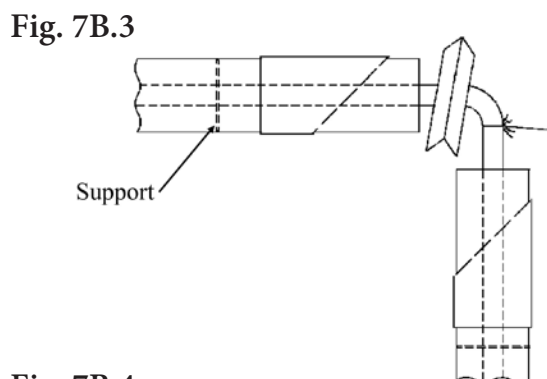
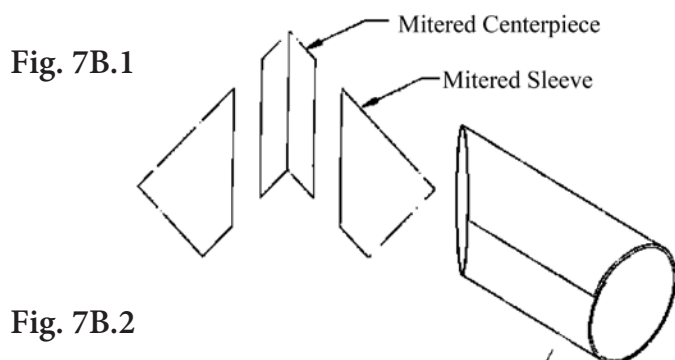
Clean weld areas and coat with Red Mill primer for **above ground systems** or the same coating on the system.

Fig. 7A.4



Section 7B: Quick Fit 90° & 45° Elbow Instructions – 8" and Larger System

NOTE: Connector bands & Quick Fit fittings will be bare. For **ABOVE Ground systems**, connector bands and Quick Fit Fittings will need to be field coated with the specified coating. Weld areas, fittings & cuts, scrapes or gauges in the coating should be touched up as well.



NOTE: Prior to any carrier field welds, pipe ends must be prepped in the field by contractor.

NOTE: During the welding process do **NOT** use anti-splatter or any type of lubricant IF your system has leak detection. These materials can cause the leak detection to fail.

You will receive a Rovanco "Quick Fit" fitting cover kit consisting of two mitered sleeves and a mitered center piece. **See Figure 7B.1**

Prior to joining the first carrier pipe to the fitting, slide one of the mitered sleeves onto the containment jacket. Weld one side of the carrier pipe fitting into place. **See Figure 7B.2**

Fit up the second carrier pipe and weld the other side of the fitting. Be sure that the mitered sleeve has been slid over the containment jacket prior to welding the second pipe to the fitting. **See Figure 7B.3**

Test the carrier pipe per specifications.

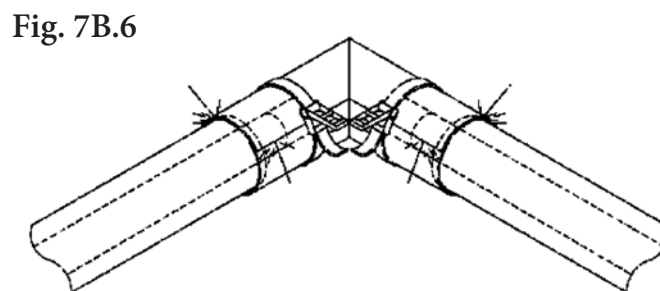
Slide the mitered sleeves into position. The mitered sleeve for 10" and larger sizes have an overlap seam at the bottom. **See Figure 7B.4 and 7B.5**

Tack the tops of the mitered sleeves to the containment jacket and the mitered center piece, then using a ratchet strap pull the mitered sleeve down tight to the containment jacket and weld all seams. **See Figure 7B.6**

Unless otherwise specified, Rovanco recommends a 15 psi air test on the conduit jacket. Clean welds and apply a soap and water test to the welds. If bubbles appear, a leak exists.

NOTE: Depressurize prior to repairing leak. If you try to repair with the pressure still on the system, you are subject to blowing a larger hole at the leak area. After leak is repaired, retest that area by re-soaping the repaired joint to ensure the leak has been fixed. If possible, air test system as you install.

Clean weld areas and coat with Red Mill primer for above ground systems or the same coating on the system.



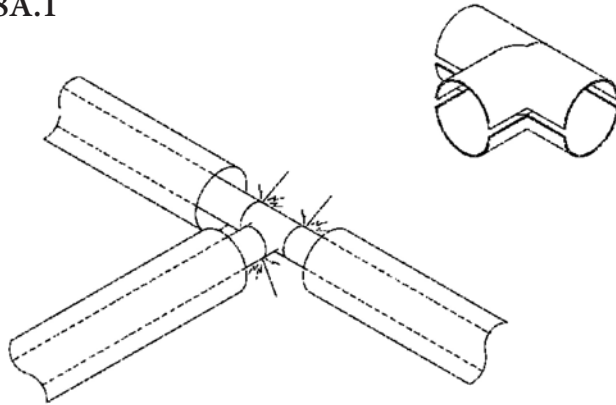
Section 8A: Split Half Shell Tees & Reducing Tees

NOTE: Connector bands & Quick Fit fittings will be bare. For **ABOVE Ground systems**, connector bands and Quick Fit Fittings will need to be field coated with the specified coating. Weld areas, fittings & cuts, scrapes or gauges in the coating should be touched up as well.

Note: Rovanco supplies tees in two different forms: **Split Half Shell** and **3-Piece Mitered**.

See **Section 3A** for Split Half Shell Tees and **Section 3B** for 3-Piece Mitered Tees.

Fig. 8A.1



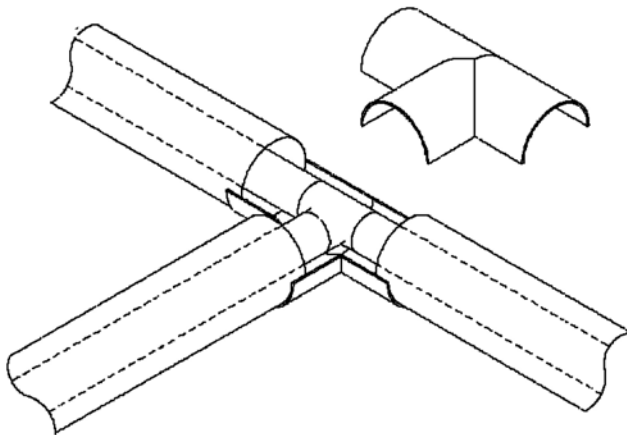
NOTE: *Prior to any carrier field welds, pipe ends must be prepped in the field by contractor.*

NOTE: *During the welding process do NOT use anti-splatter or any type of lubricant IF your system has leak detection. These materials can cause the leak detection to fail.*

You will receive a Rovanco “Quick Fit” fitting cover kit consisting of two half shells. Weld the carrier pipe fitting into place. **See Figure 8A.1**

Test the carrier pipe per specifications.

Fig. 8A.2

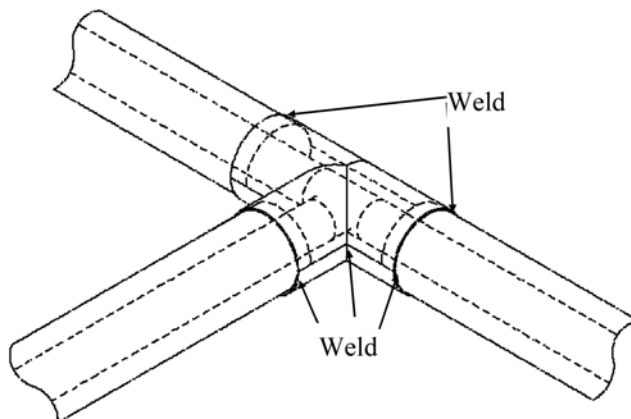


Test fit the cover prior to welding either piece in place. Fit up the bottom half of the fitting cover in place and tack weld it. **See Figure 8A.2**

Next fit the top half in place and tack weld it. Continuously weld all circumferential seams and the longitudinal seams to completely seal the fitting cover. **See figure 8A.3**

Unless otherwise specified, Rovanco recommends a 15 psi air test on the conduit jacket. Clean welds and apply a soap and water test to the welds. If bubbles appear, a leak exists.

Fig. 8A.3

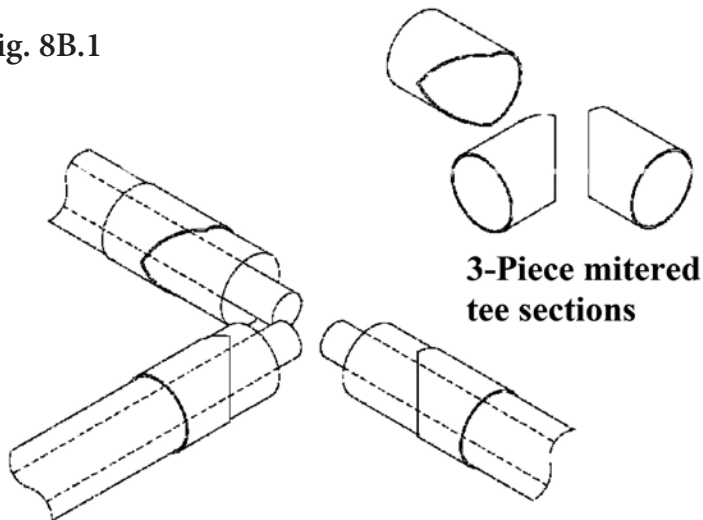


NOTE: *Depressurize prior to repairing leak. If you try to repair with the pressure still on the system, you are subject to blowing a larger hole at the leak area.* After leak is repaired, retest that area by re-soaping the repaired joint to ensure the leak has been fixed. If possible, air test system as you install.

Clean weld areas and coat with Red Mill primer for **above ground systems** or the same coating on the system.

Section 8B: 3-Piece Mitered Tees & Reducing Tees

Fig. 8B.1

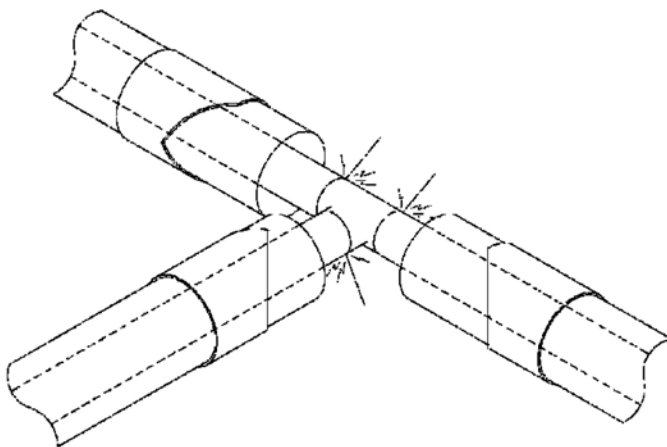


NOTE: Prior to any carrier field welds, pipe ends must be prepped in the field by contractor.

NOTE: During the welding process do NOT use anti-splatter or any type of lubricant IF your system has leak detection. These materials can cause the leak detection to fail.

You will receive a Rovanco “Quick Fit” fitting cover kit consisting of three mitered sections. Prior to welding the carrier pipe fitting into place, you will need to slip the mitered sections over the containment jacket. **See Figure 8B.1**

Fig. 8B.2



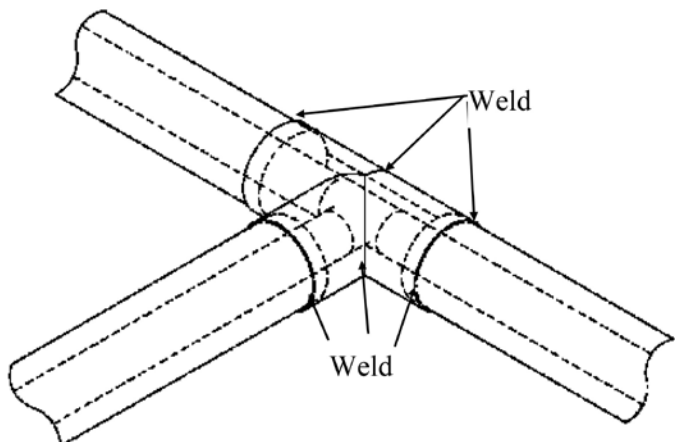
Weld the carrier pipe fitting. **See Figure 8B.2**

Test the carrier pipe per specifications.

Test fit the mitered section prior to welding them in place. Fit up the three sections to each other and tack weld them in place. Continuously weld all circumferential seams and the mitered seams to completely seal the fitting cover. **See figure 8B.3**

Unless otherwise specified, Rovanco recommends a 15 psi air test on the conduit jacket. Clean welds and apply a soap and water test to the welds. If bubbles appear, a leak exists.

Fig. 8B.3



NOTE: Depressurize prior to repairing leak. If you try to repair with the pressure still on the system, you are subject to blowing a larger hole at the leak area. After leak is repaired, retest that area by re-soaping the repaired joint to ensure the leak has been fixed. If possible, air test system as you install.

Clean weld areas and coat with Red Mill primer for **above ground systems** or the same coating on the system.

Section 9: Field Applied End Seal

Fig. 9.1

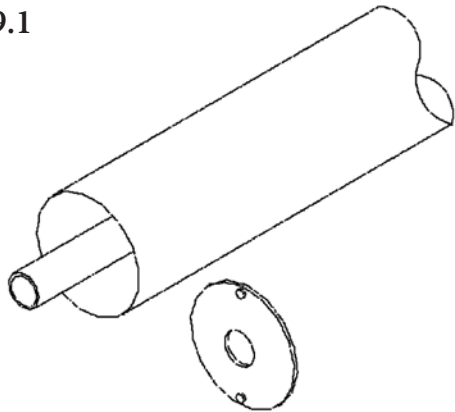
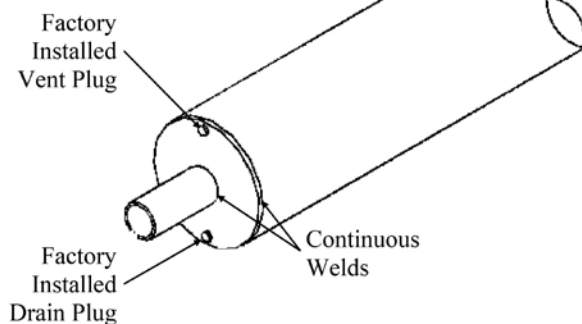


Fig. 9.2



NOTE: During the welding process do NOT use anti-splatter or any type of lubricant IF your system has leak detection. These materials can cause the leak detection to fail.

If the job requires a field applied end seal, you will receive a precut end seal plate with your shipment.

See Figure 9.1

Take the plate and slide it over the open end of pipe where it is required. Make sure to align the vent and drain plugs at the 6 o'clock and 12 o'clock positions. Continuously weld the plate to the carrier pipe and outer containment jacket. **See Figure 9.2**

Unless otherwise specified, Rovanco recommends a 15 psi air test on the containment jacket. Apply a soap and water test to the welds.

Clean weld areas and coat with Red Mill primer for above ground systems or the same coating on the system.

Section 10: Field Applied Gland Seal

Fig. 10.1

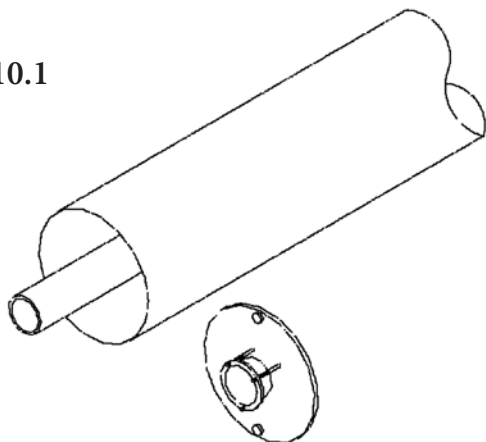
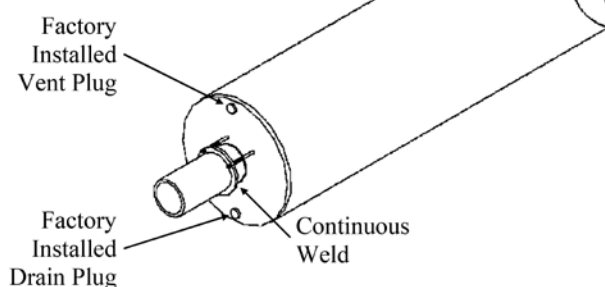


Fig. 10.2



NOTE: During the welding process do NOT use anti-splatter or any type of lubricant IF your system has leak detection. These materials can cause the leak detection to fail.

If the job requires a field applied gland seal, you will receive a pre-cut gland seal plate with a gasket and follower plate attached. **See Figure 10.1**

Remove the gasket and follower plate and slide the gland seal plate over the open end of pipe where it is required. Make sure to align the vent and drain plugs at the 6 o'clock and 12 o'clock positions. Continuously weld the plate to the jacket. Slide the gasket and follower plate into place and tighten it up so that the plate is centered and secure. **See figure 10.2**

Unless otherwise specified, Rovanco recommends a 15 psi air test on the containment jacket. Apply a soap and water test to the welds.

Clean weld areas and coat with Red Mill primer for above ground systems or the same coating on the system.

Section 11: Field Applied Anchor

Fig. 11.1

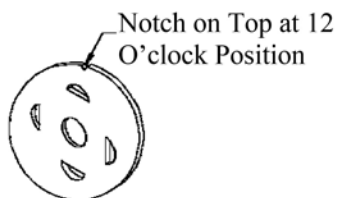


Fig. 11.2

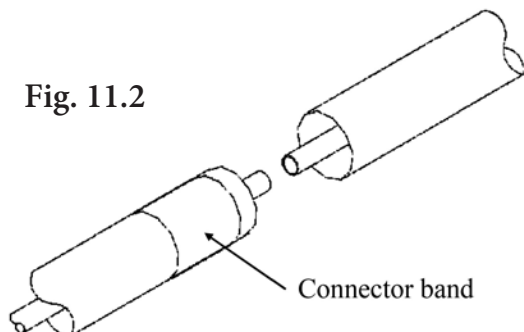


Fig. 11.3

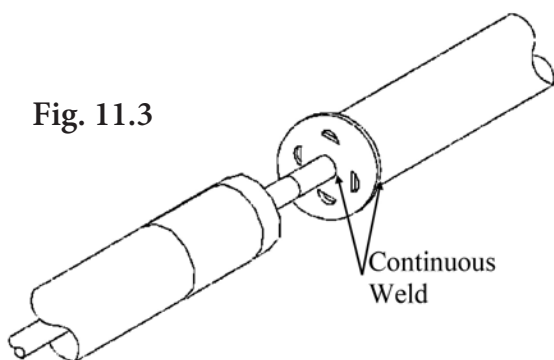


Fig. 11.4

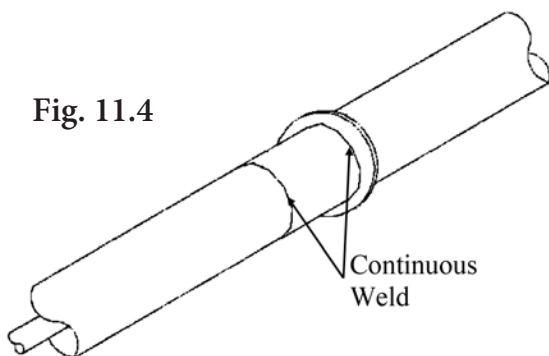
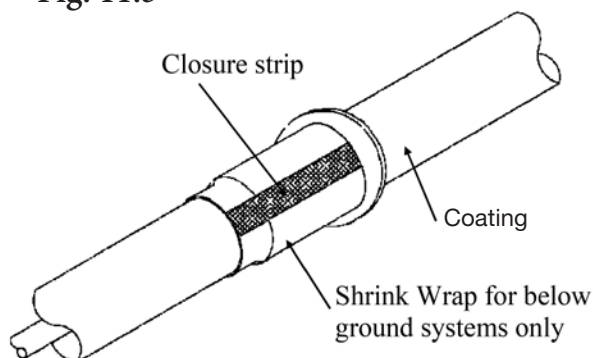


Fig. 11.5



NOTE: During the welding process do NOT use anti-splatter or any type of lubricant IF your system has leak detection. These materials can cause the leak detection to fail.

If the job requires a field applied anchor, you will receive a pre-cut anchor plate with your shipment. The anchor has pre-cut vent holes and a notch cut into the plate. The notch has to be installed at the 12 o'clock position.

See figure 11.1

There are two methods of installing field applied anchors, either at a field joint or by cutting into a length of pipe. To apply an anchor at a field joint, continue with the instructions on this page. For instruction on field cutting pipe and split anchor application, refer to **Section 12 on page 17.**

To apply the anchor plate at a field joint, first make sure that a connector band is slid onto one side of the pipe where the anchor is to be applied (opposite of the side that the anchor plate will be welded). **See figure 11.2**

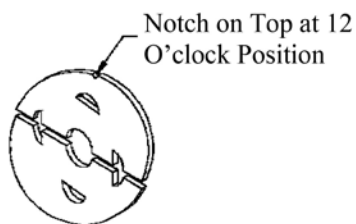
Slide the anchor plate up against the open end of the containment pipe jacket. Continuously weld the anchor plate to the containment jacket and on the opposite side of the anchor plate, continuously weld the anchor plate to the carrier pipe. **See figure 11.3**

Slide the connector band up to the anchor plate to verify the outer coating has been ground back far enough to weld. Grind outer coating off the weld area, if needed. Slide the connector band back against the anchor plate. Continuously weld the connector band to the anchor plate and the containment jacket. **See figure 11.4**

After air testing the outer jacket, clean the exposed metal surface thoroughly. Next, coat the anchor plate with epoxy or Red Mill primer to match the jacket and coat any exposed steel on the opposite side. **See figure 11.5**

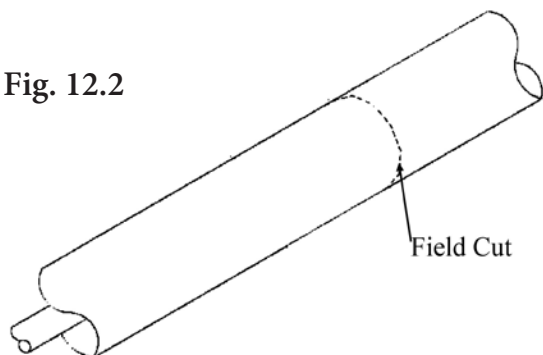
Section 12: Field Applied Split Anchor

Fig. 12.1



NOTE: During the welding process do NOT use anti-splatter or any type of lubricant IF your system has leak detection. These materials can cause the leak detection to fail.

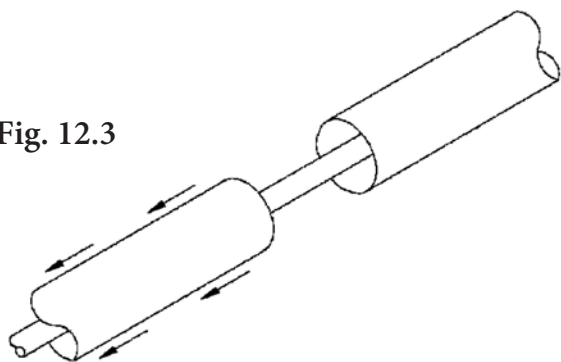
Fig. 12.2



If the job requires a field applied anchor which needs to be applied in the middle of a length of pipe, the anchor must be split in order to apply it. **See figure 12.1**

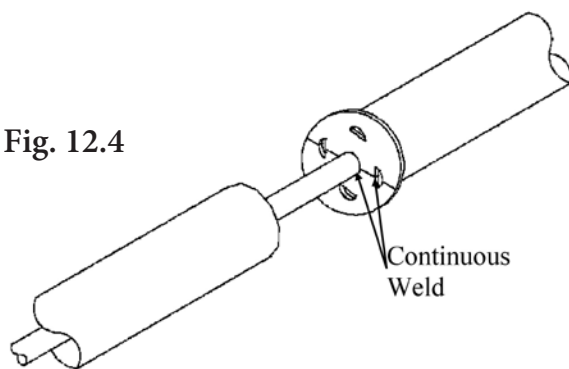
Make a circumferential cut around the metal jacket at the point where the anchor will be installed. **See figure 12.2**

Fig. 12.3



Slide the containment jacket back. **See figure 12.3**

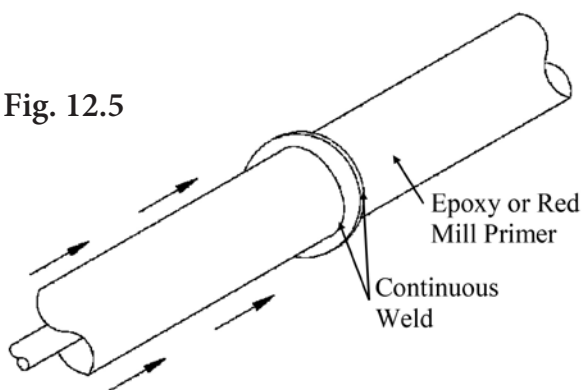
Fig. 12.4



Apply the split anchor plate and weld both sides of the seam. Continuously weld the anchor plate to the carrier pipe and the containment jacket. **See figure 12.4**

Slide the containment jacket up to the anchor plate and make the circumferential welds on both sides of the anchor plate.

Fig. 12.5



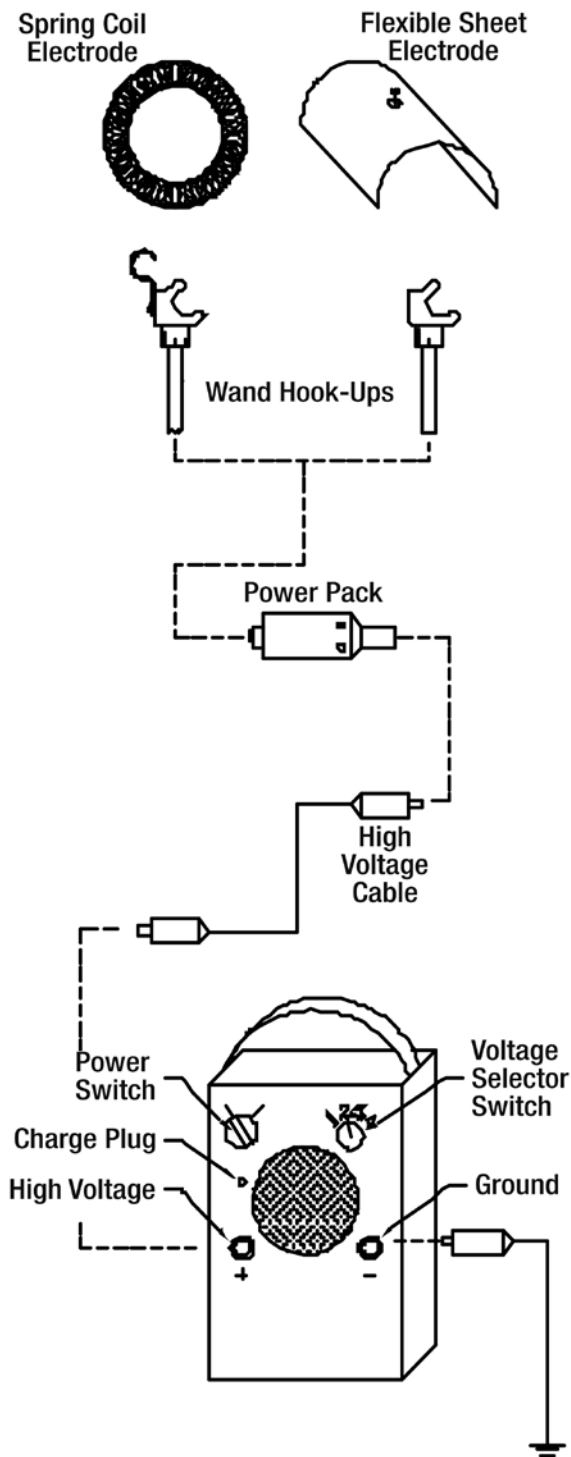
After air testing the outer jacket, clean all exposed steel and coat the anchor plate with epoxy or Red Mill to match the containment jacket. **See figure 12.5**

Section 13: Containment Coating Testing

If required in the specifications, ROVANCO can supply a containment coating tester for rental, credit card payment required. This tester will allow you to inspect the containment coating for damaged areas. These damaged areas are called holidays. ROVANCO's Holiday Detectors are portable, all purpose electrical inspection instruments. They are adaptable for use on both large and small diameter containment. The detector works on damp or dry surfaces.

A. Upon opening the carrying case, notice where the various components are located; repack them in the same manner when not in use. Then remove all components from the carrying case. Inspect them upon receipt. If damage has occurred, contact Rovanco. Check components against packing slip to be sure nothing is missing.

B. Equipment assembly



1. Ensure that the holiday detector ON-OFF switch is in the OFF position.
2. Using the battery tester, insert the test plug, on the battery tester, into the holiday detector charge plug receptacle. If the red LED indicator lights up, then the battery is okay, if not, then the battery needs to be recharged. Remove the tester from the battery.
3. Turn the output voltage selection switch on the detector to desired voltage. Voltages are listed on the individual power packs in ascending order, left-to-right. Use #4, 2,500 volts, for testing 20 mil Epoxy Coated Insul-8 Conduit. NOTE: Higher settings or voltages will damage the epoxy coating.
4. Insert leather belt into side loops on back of detector if belt-mounted method is to be used.
5. Uncoil the ground wire and plug connector into detector port marked ground. The ground wire will trail on bare earth or be attached to the containment being tested.
6. Attach wand to the threaded male end of the power pack. Insert power pack cable (female connector) into male connector of power pack. Insert other end of power back cable into High Voltage port on detector.
7. Assemble the desired electrode and apply to the containment. The electrode should always make an intimate contact with the surface to be inspected.
8. Turn the ON-OFF switch to the ON position. Note that when the switch is in the ON position, a buzzing sound may be heard coming from the detector. The detector is now ready to operate.

A. Operating Methods

1. Grounding: A good ground return system will always give the best and most reliable inspection.

The containment must be grounded to earth at some point. If individual lengths of containment are to be inspected, each will have to be grounded separately.

2. Inspection: The containment should be inspected just prior to backfilling.

3. Inspection Speed: The speed of the electrode travel over the containment surface should be moderate, about 40 feet per minute. Moving the electrode at an excessive speed can result in an inaccurate inspection.

Caution: Do not test the same area twice, unless it is a repaired area, or let the electrode rest in one spot. Either may damage the coating on the containment.

Fig. 13.1

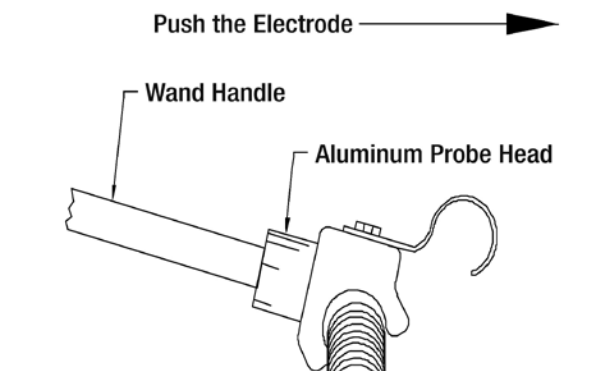


Fig. 13.2

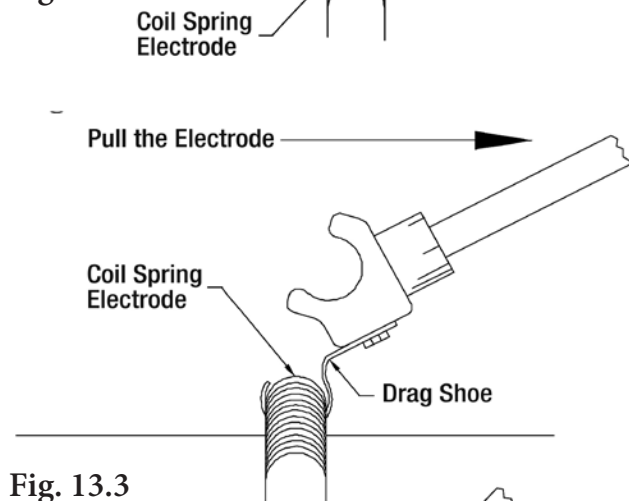
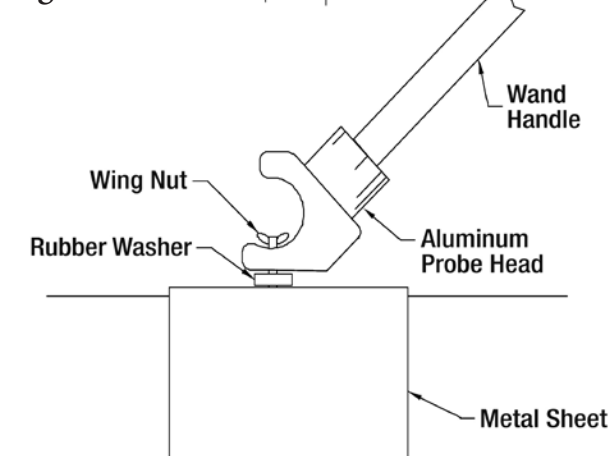


Fig. 13.3



4. Operating Checks:

- Occasional checks of the detector can be made if no holidays are being found. Move the inspection electrode to an area where there is bare metal. A spark and a signal should both occur.
- If the signal does not sound when the spark jumps, the ground return resistance is exceptionally high. For example, sandy, very dry soil or a large diameter pipe. To improve the ground, make a direct connection between the containment metal under inspection, and the detector's ground wire.

5. Inspection Methods

- If the spring coil electrode is used, then use the standard cast aluminum probe head to push the coil spring electrode. This method of propelling the electrode is most effective for small pipe diameters. **See Figure 13.1**
- For larger diameter pipes and particularly for over-the-ditch coating, use the drag shoe to pull the coil spring electrode. The shoe is attached onto the probe head with a cap screw that can be adjusted for lateral movement. A quick twisting motion will release the shoe from the spring. **See Figure 13.2**
- If using the flexible metal/rubber sheet, first remove the drag shoe if necessary. Then attach as per **Figure 13.3**, making sure to insert the rubber washer, and bend the metal/rubber sheet to conform to the containment outer-diameter.

D. Instrument Servicing Repair

- Cleaning:** Keep instrument clean and dry. Clean instrument case with a soft cloth dampened with kerosene or mineral spirits, then wipe dry. Do not use solvents such as lacquer thinner, MEK, etc.

2. Voltage output Checks:

a. Low Output Voltage:

- Check position of voltage selection switch. It should be on #4, 2,500 volts.
- Check battery conditions using battery tester.
- Check for parted conductor in wand and ground wire.

a. No Output Voltage:

- Check battery condition using battery tester.
- Check battery leads and the power switch for open circuit. Proper input current is .7 to .9 amps.
- Contact ROVANCO for further information.

3. False Signal Indication Check:

- Adjust the 4-position signal sensitivity switch through the porthole provided on the back panel in the belt recess.
- Electrical load conditions vary greatly through pipe sizes, coating thicknesses, and climatic conditions. The far counter-clockwise position, or Position 1, is the most signal sensitive. In most cases it is best to start out using Position 2.
- Check for parted connector in wand and ground wire.

4. No Signal with Spark Discharge:

- Check the position of the signal sensitivity switch.
- Adjust the signal sensitivity switch mentioned above.

E. Battery Charging Instructions

Caution: The detector ON-OFF switch must be in OFF position while charging battery.

1. Use battery charger provided. Part Number 031-5
2. Recharge the battery in the instrument. Ventilation holes in front and back of the instrument case should be kept open.
3. Plug charger into polarized receptacle of instrument. Note: The battery cannot be tested or charged when the instrument power switch is in the ON position.
4. Plug AC power cord into any 120 volt 60 Hz outlet.
5. Charge battery for 14 hours. Charge at temperatures above 45° F for best results.
6. If charger pilot light is out it indicated that the charger is not operating.
 - a. Check the position of the power switch.
 - b. Check for a shorted battery cell.
7. Disconnect charger from battery and AC outlet when not in use.

F. Battery Maintenance Information

1. When the instrument fails to operate in a normal manner, battery is fully discharged. Recharging before this occurs can extend the useful life of the battery considerably.
2. Store at normal room temperature when not in use.
3. If the battery has not been used for six months or more, recharge for 14 hours.

Note: If the detector fails to operate in a normal manner, the first step is to test the battery condition.

Section 14: Repairs to Containment

When damage to the coating has been located, it must be repaired. Large areas of damage can be repaired with wrap-around shrink. Small areas should be covered with field applied coating. ROVANCO has furnished field coating kits to cover any small holidays. Coat, let dry, and then retest the repaired area.

A. Surface Preparation

The performance of any coating is dependent on the cleanliness of the surface. The coating must come in contact with the metal surface itself. Metal must be clean, dry, and free of loose rust, paint, oils, grease etc. Metal surfaces should be either blasted to NACE near-white metal, or cleaned with a surface grinder. Remove all oxidation from the area to be coated, and some of the coating around it. Bare metal surfaces should be coated as soon after cleaning as possible.

B. Red Mil Coating (for Above Ground Systems)

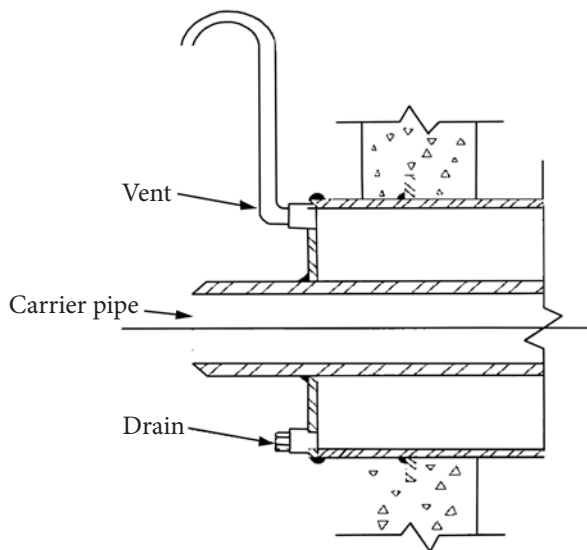
For red mil coating, apply supplied coating using a brush to approximately the same thickness as the rest of the coating on the spool.

C. Handling Precautions

Avoid eye and skin contact; use protective clothing, gloves and eye protection. Avoid breathing vapors. In a non-ventilated area the operator should wear a paint mask. If coating is applied in an enclosed or confined area, operator should wear a positive air mask, and precautions should be taken to prevent the solvent vapor from reaching explosive limits. Remove contaminated clothing and launder before reuse.

Section 15: Manhole or Building Entries

Fig. 15.1



See Figure 15.1 for the proper building entry or manhole entry detail. Also, as mentioned in the previous section, be sure before turning the job over to the owner that the vent on each end of the system is piped up above any potential water level and goose necked for venting. This is done so that water can not get high enough to enter the system. The drains should remain closed. It is recommended that at least 2" of containment enter through the wall before our system ends.

Section 16: Operation & Maintenance for Containment

Annual: Remove the drain plugs to check for the presence of water in the air space yearly. When removing the drain plug, be alert for a possible steam flash. If water is found follow the repair procedure outlined below. The drain plugs must be replaced after the inspection to insure water does not inadvertently enter the air space from a flooded manhole or mechanical room.

CAUTION: Extreme caution must be exercised when entering steam manholes and opening vents and drains.

Also do an air test of the containment yearly. Using an air compressor, pressurize the air space to 15 psig and hold for one (1) hour. If the pressure can not be maintained, see the repair procedure below. Warranty will void if this is not done and logged year to year.

Repair: If a leak in the casing is found, it should be repaired, tested, coated, and backfilled as it was originally installed.

If a leak in the carrier pipe is found, at least a 2' section of pipe should be removed and replaced. The carrier pipe should then be hydrostatically tested at 1½ times it's operating pressure, not to exceed 500 psig. Re-insulate the carrier pipe as specified. Repair the inner containment casing using a split sleeve, similar to the connector band used in assembling the field joints. Air test the inner containment casing, then insulate as specified. Cover with a polyethylene sleeve and seal with a wrap around shrink sleeve.

Insulation: If insulation within the conduit becomes wet, then force ventilate the air space in the system at a rate of not less than 3 cubic feet per minute, and apply heat through the internal piping. Introduce the air through the system's high point vent, and force out the low point drain. Caution personnel regarding the possibility of a steam flash out of the low point drain while air is being forced through the system. Place a cool mirror at the exhaust point for a short time at appropriate intervals and position to indicate maximum fogging due to moisture. Continue ventilation until the mirror exhibits no visible fogging.

System Shutdown: If the system is shut down for any length of time, seal the system vents by plugging the goose neck or removing it and installing a plug. Purge with dry nitrogen before sealing system. The vents must be opened and the goose neck replaced before the system is turned on again. This will prevent moisture entry during shutdown.

Manholes: Automatic sump pumps, if any, should be thoroughly inspected for proper operation annually. Steam traps, if any, should be routinely inspected and/or replaced, based upon the recommendations of the manufacturer. All flanges should be checked for leakage and tightened if necessary. Any evidence of groundwater leakage should be investigated and repaired. Gland seals, end seals, and the inside wall of prefabricated steel manholes should be routinely inspected for leaks and/or corrosion. Sand and repaint any corrosion to match the existing coating. Check valves routinely for leaks and repack when necessary. Insulation and jacketing of internal piping and equipment should routinely be checked and replaced when necessary. Warranty will void if manholes flood over Rovanco's piping systems.

If you have any questions about anything in this instruction manual, or have any difficulty in completing the work please feel free to contact ROVANCO's Customer Service Department at our main office in Joliet, Illinois (815) 741-6700.

Thank you once again for showing your confidence in ROVANCO by purchasing our Hi-Temp Insul-8 products. We want you to know that we have a full line of pre-insulated and pre-fabricated piping systems for almost any temperature, pressure, or site condition.

If you are not familiar with our complete product line and you would like to know more about our product or would like to have our local Manufacturer's Representative call on you, call ROVANCO at (815) 741-6700, at rovanco.com, or email us at marketing@rovanco.com

Section 17: Parameters For Properly Installing & Operating Systems

Rovanco's pre-insulated and pre-fabricated products are carefully engineered to function as intended. If these products are properly installed, fully-tested, maintained and operated within the parameters for which they were designed, these systems should provide the user with years of trouble-free, efficient operation.

Refer to Rovanco's Installation Instruction(s) and the associated documentation from Rovanco's Engineering Department for important information and instructions that will carefully detail installation, testing, operating, and maintenance procedures. If needed, you are always welcome to contact Rovanco for assistance.

Failure to comply with the procedures as outlined in the Installation Instructions and Engineering support documentation could result in product damage, reduced product service life, costly repairs due to product failure, hazardous conditions which could result in injury to people, property and/or equipment. In addition, it will void Rovanco's warranty.

If any Rovanco product does not perform as it is intended to, please inform Rovanco immediately.

Some problems and their potential causes are listed below. Although this list is not all-inclusive, you may be able to find additional information in Rovanco's Installation Instruction(s) and/or the Engineering Department documentation.

General Piping System Care:

- Wet insulation does not perform as intended and causes the premature failure of the system. Therefore, it is important the system's insulation is kept dry at all times. This includes during storage, installation and when system is operating.
- Our systems have been engineered to operate within a specific temperature & pressure range and under appropriate environmental conditions. Therefore, do not install or put our systems into service if these parameters are not within the product's specifications.
- If you find it is necessary to alter a Rovanco piping system, review the planned alterations with Rovanco or a qualified piping system designer before making any changes.
- Maintenance plays an important role in assuring you get the full service-life out of the system. Rovanco systems are designed to provide years of trouble-free operation, but changing conditions can affect that. So, systems should be inspected regularly to verify they are in good operating condition and functioning as intended. If repairs are required, make them promptly.

Pre-Insulated Foam Systems:

- Piping systems must be kept dry. Moisture of any amount can corrode carrier pipe and prematurely break-down insulation. This will shorten piping system service-life and/or prevent it from operating properly. Keep all piping system dry during storage, installation and when it is operating.
- Assure field joints are completed correctly. This includes the proper field insulating and enclosing the outer jacket in the joint area. Improper completion of field joints could result in water ingress effecting carrier pipe and/or insulation.
- Damage to jacketing must be repaired immediately. Failure to do so could allow moisture to reach the insulations and/or carrier pipe.
- When installing piping systems designed for underground use that require external expansion pads, you must assure these expansion pads are properly installed according to specifications. Proper installation will allow for associated thermal expansion. Improperly installed expansion pads will put unwanted stress on a piping system that could damage it.

Conduit & Containment Systems:

- Moisture negatively affects a systems functionality and shortens its service-life. Moisture will corrode carrier, conduit & containment piping, leak detection or pull cables and it will degrade insulation. It is important that the air space in these systems is kept dry. If any type of moisture is detected, it must be dried immediately so system is returned to a dry state during installation and operation.
- A combination of moisture in the air space and high operating temperatures will accelerate the destruction of piping, its coating and any insulation. This can result in costly repairs, system damage and possibly system failure. Therefore, do not ever operate these systems under the negative conditions of moisture presence and high temperatures.
- Gland seals provide a seal against a service pipe while still allowing that service pipe to have axial movement. Therefore, it is important all gland seals are adjusted properly to these conditions are met and there is no binding of the service pipe.
- End seal vents and drain piping play an important role in keeping the air space dry. They allow the annular air space to vent and drain as well as prevent moisture ingress. So it is important end seal vents and drain piping is installed properly. This will allow them to function as intended.
- One important detail that will help keep the air space dry and drainable is to assure the piping system is installed with the proper slope so any moisture can drain as intended.

Systems Intended For Underground Installation:

- Plan for adverse weather conditions prior to installation. If trenches gather water, they must be drained prior to the installation of the piping.
- Inspect all steel piping that will be buried prior to backfilling using a Holiday tester. Any holidays or damage to coating must be repaired in accordance with Rovanco's installation instructions prior to backfilling. Failure to repair voids or damage to coating will promote premature corrosion and effect system performance and length of service.
- Prior to backfilling, all carrier pipe, conduit and containment piping must be tested. If piping system integrity is not tested prior to backfilling, it will result in costly excavating and will not be Rovanco's responsibility.
- Cathodic protection system must be installed with thin-coated steel conduit or containment that will be direct buried. The cathodic protection will prevent the premature corrosion of thin-coated steel piping system.
- Line trench accordingly before piping installation. Backfill and compact post-installation in accordance with Rovanco's installation instructions. If these procedures are performed properly, it will help prevent damage to the system when the ground settles.
- Manholes must be kept dry at all times. Installing sump pumps, keeping end seals above water levels and not installing manholes in low points will help prevent water from draining into them.