



NATIONAL PIPE HANGER CORPORATION

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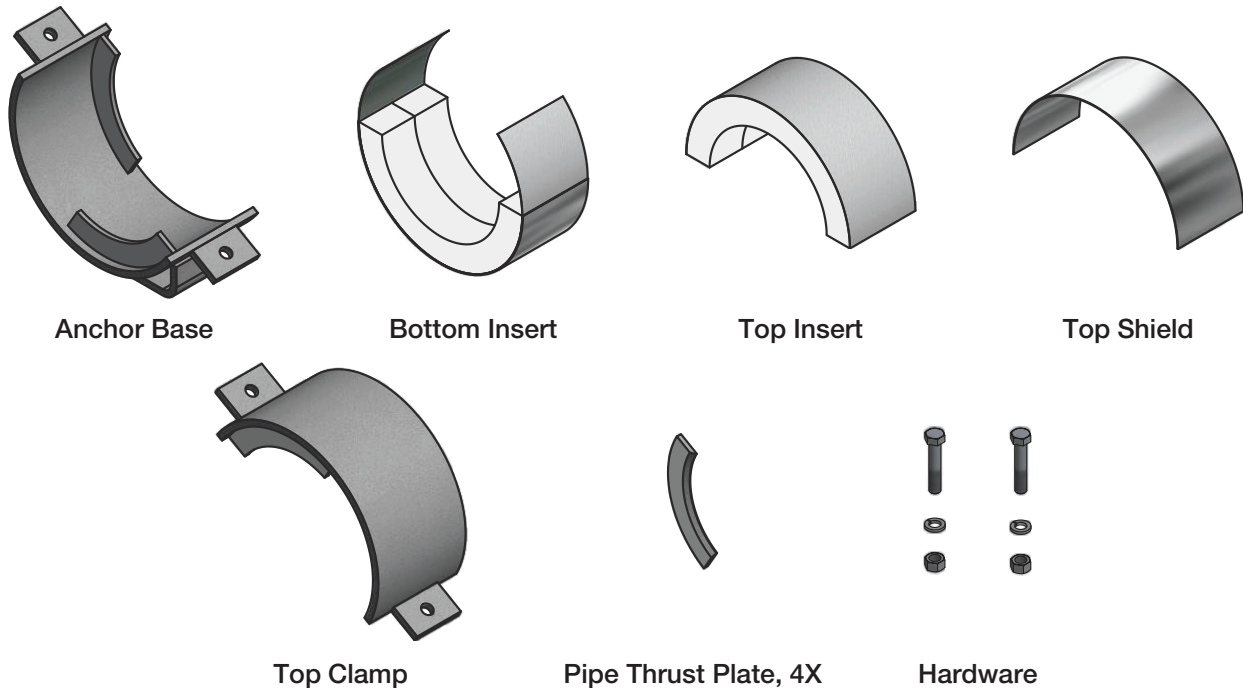
FIG. NA40

Pre-Insulated Pipe Anchor Installation Instructions

FIG. NA40

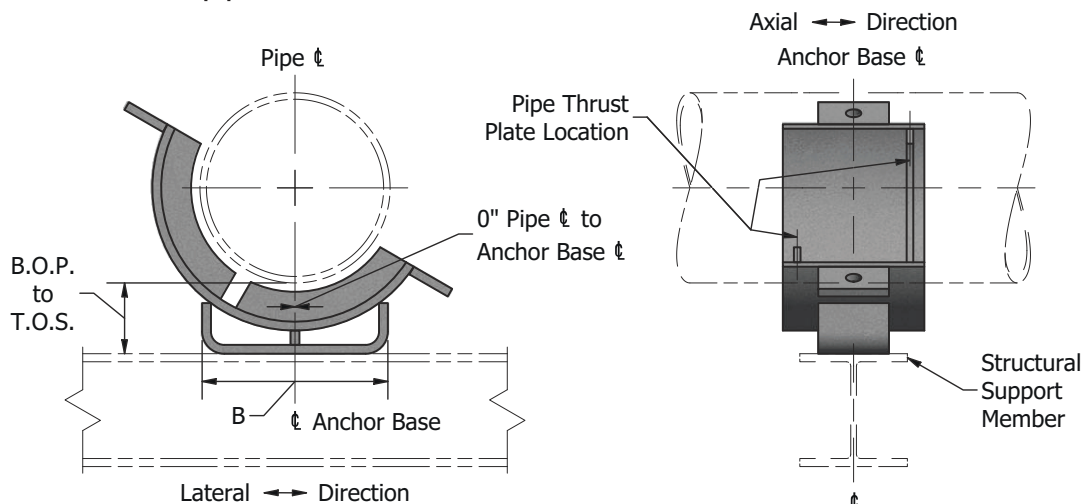
The following installation instructions are for Pre-Insulated Pipe Anchor NA40.

1. Components



2. Locate Anchor Base

Place the Anchor Base on the structural support member and align it under the centerline of the pipe in the lateral direction. Locate the Anchor Base on the structural support member along the axial direction of the pipe (shown on member centerline). Mark the perimeter of Anchor Base on structural support member for weld preparation. Mark the Pipe Thrust Plate locations on pipe.





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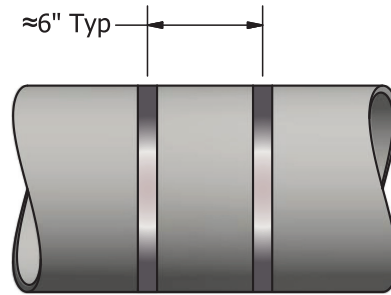
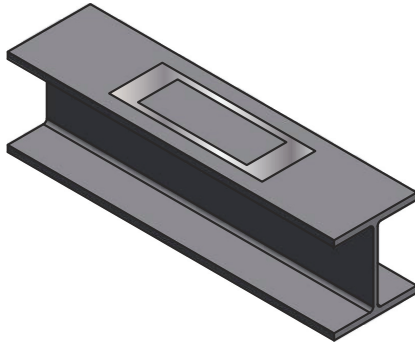
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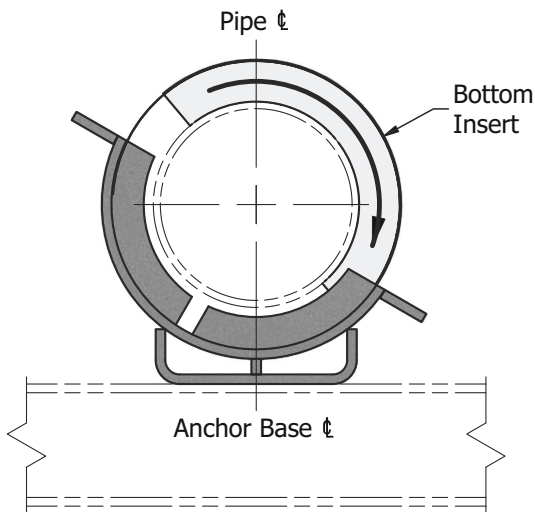
3. Prepare Structural Support Member and Pipe for Welding

Grind structural support member and Anchor Base finish to bare metal in the all-around pattern. See Table 1 for Weld Pattern Details. Grind pipe to bare metal at Pipe Thrust Plate locations.

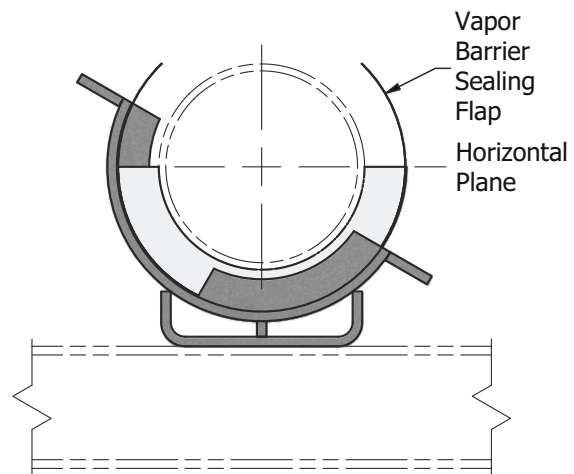


4. Place Anchor Base and Bottom Insert

Place the Anchor Base on top of the structural support member. Align the Anchor Base centerline with the pipe centerline in the lateral direction. Align the Anchor Base on the structural support member in the axial direction as required. Place the Bottom Insert on the top of the pipe and rotate into position until the ends of the segment are parallel to the horizontal plane. Take care not to damage the vapor barrier sealing flaps.



Rotate Bottom Insert



Bottom Insert Installed Position



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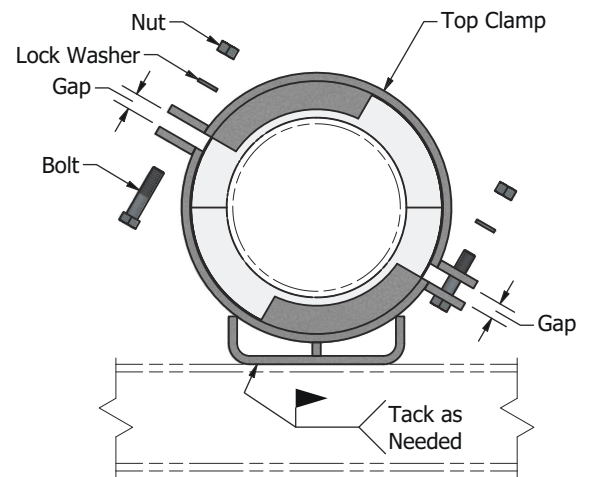
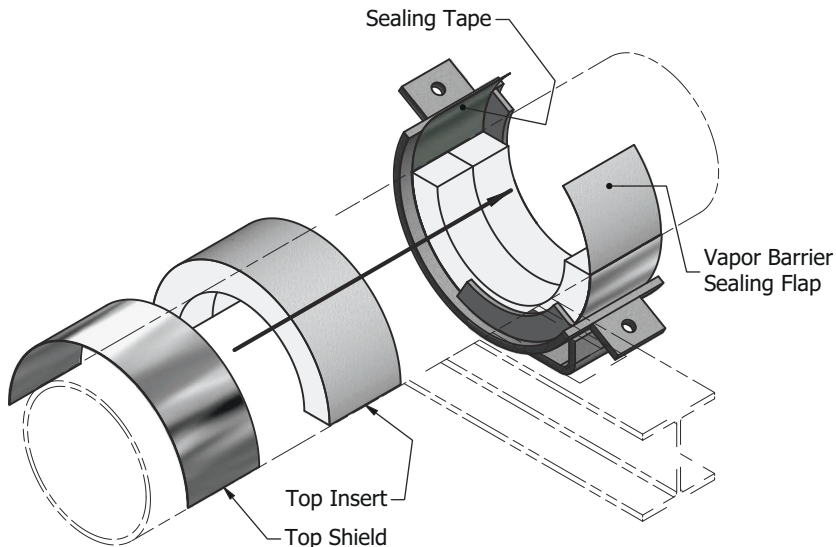
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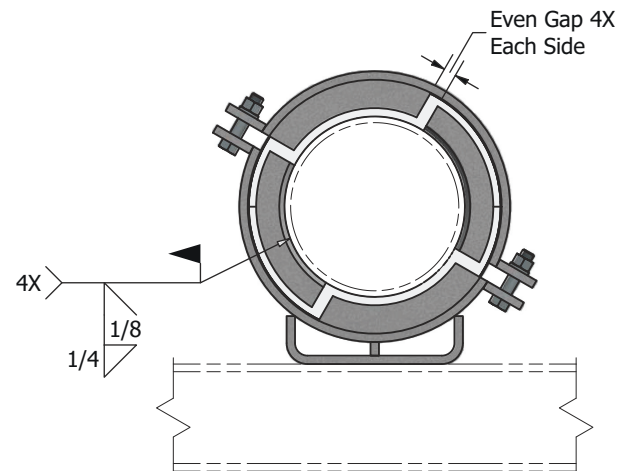
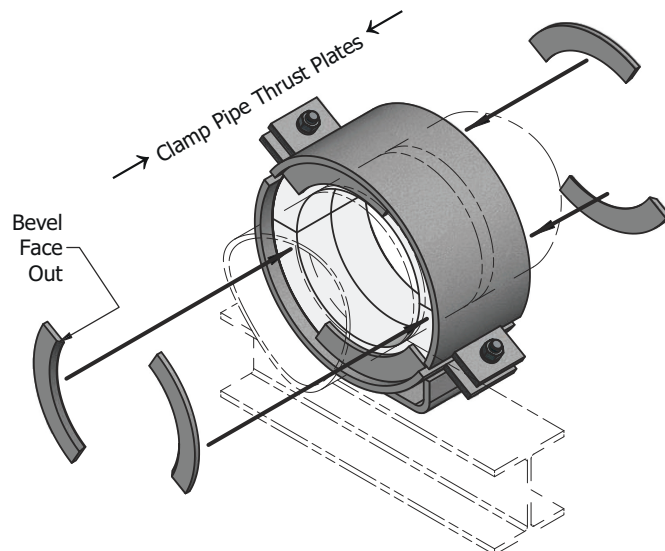
5. Place Top Insert, Top Shield, and Top Clamp

Pull the vapor barrier sealing flaps on the Bottom Insert away from the pipe. Slide the Top Insert along the axis of the pipe and over the Bottom Insert, aligning them end-to-end. Remove the sealing tape backing on each vapor barrier sealing flap and adhere them to the Top Insert vapor barrier. Slide the Top Shield over the Top Insert aligning it end-to-end and lip-to-lip with the Bottom Shield. Take care not to tear the vapor barriers with the edges of the Top Shield. Place the Top Clamp over the Top Insert and Top Shield. Insert the bolts through the Top and Bottom Clamp ears and hand tighten. Incrementally and alternately tighten the bolts while maintaining an even gap on each side. See Table 2 for Clamp Bolt Torque.



6. Weld Pipe Thrust Plates to Pipe

Locate the Pipe Thrust Plates against the pipe with the beveled edge facing out and up against the Bottom and Top Inserts. Clamp the Pipe Thrust Plates against the Top and Bottom Inserts. All welds to be full penetration bevel groove welds. Multiple weld passes permitted. Pipe Thrust Plate shop beveled.





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7. Weld Anchor Base to Structural Support Member

Post-weld repair prepared areas by painting or applying cold galvanizing per ASTM A-780.

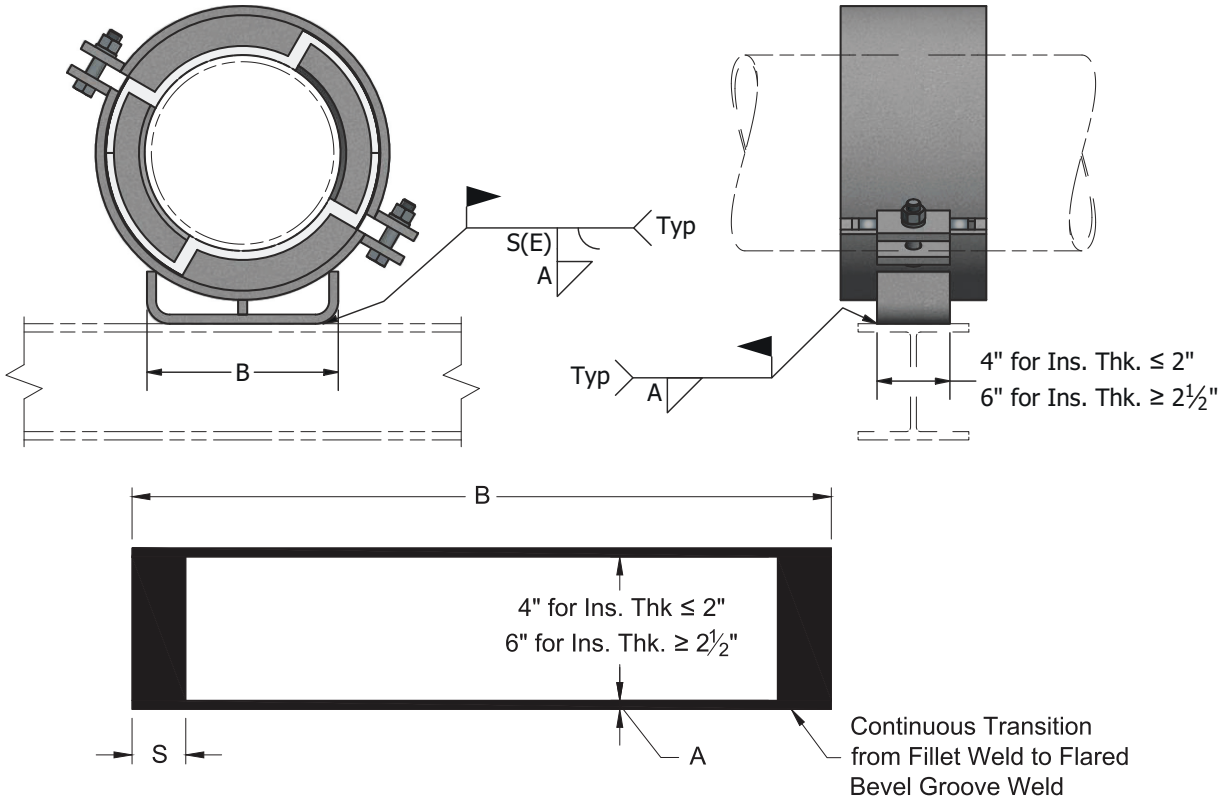


Table 1. Anchor Base Weld Pattern Details

PIPE SIZE	INS THK = 1"				INS THK = 1½"				INS THK = 2"				INS THK = 2½"				INS THK = 3"				INS THK = 4"			
	B	S	E	A	B	S	E	A	B	S	E	A	B	S	E	A	B	S	E	A	B	S	E	A
2"	2.5	0.625	0.313	0.188	3	0.75	0.375	0.25	4	1.5	0.75	0.375	4.5	1.625	0.813	0.375	5.5	1.625	0.813	0.375	7.5	1.625	0.813	0.375
2½"	2.5	0.625	0.313	0.188	4	0.75	0.375	0.25	4.5	1.5	0.75	0.375	5.5	1.625	0.813	0.375	6.5	1.625	0.813	0.375	8	1.625	0.813	0.375
3"	3	0.625	0.313	0.188	4	0.75	0.375	0.25	4.5	1.5	0.75	0.375	5.5	1.625	0.813	0.375	6.5	1.625	0.813	0.375	8	1.625	0.813	0.375
4"	4	0.625	0.313	0.188	4.5	0.75	0.375	0.25	5.5	1.5	0.75	0.375	6.5	1.625	0.813	0.375	7.5	1.625	0.813	0.375	9	1.625	0.813	0.375
5"	4.5	0.625	0.313	0.188	5.5	0.75	0.375	0.25	6.5	1.5	0.75	0.375	7.5	1.625	0.813	0.5	8	1.625	0.813	0.5	9.5	1.625	0.813	0.5
6"	5.5	0.625	0.313	0.188	6.5	0.75	0.375	0.25	7.5	1.5	0.75	0.375	8	1.625	0.813	0.5	9	1.625	0.813	0.5	10.5	1.625	0.813	0.5
8"	7.5	0.625	0.313	0.188	8	0.75	0.375	0.25	9	1.5	0.75	0.375	9.5	1.625	0.813	0.5	10.5	1.625	0.813	0.5	12	1.625	0.813	0.5
10"	9	0.625	0.313	0.188	9.5	1.5	0.75	0.375	10.5	1.5	0.75	0.375	11	1.625	0.813	0.5	12	1.625	0.813	0.5	13	1.625	0.813	0.5
12"	10.5	0.625	0.313	0.188	11	1.5	0.75	0.375	12	1.5	0.75	0.375	12.5	1.75	0.875	0.5	13	1.75	0.875	0.5	14.5	1.75	0.875	0.5
14"	11	0.625	0.313	0.188	12	1.5	0.75	0.375	12.5	1.625	0.813	0.5	13	1.75	0.875	0.5	14	1.75	0.875	0.5	15.5	1.75	0.875	0.5
16"	12.5	0.625	0.313	0.188	13	1.5	0.75	0.375	14	1.625	0.813	0.5	14.5	1.75	0.875	0.5	15.5	1.75	0.875	0.5	16.5	1.75	0.875	0.5
18"	14	0.625	0.313	0.188	14.5	1.5	0.75	0.375	15.5	1.625	0.813	0.5	16	1.75	0.875	0.5	16.5	1.75	0.875	0.5	18	1.75	0.875	0.5
20"	15.5	0.625	0.313	0.188	16	1.5	0.75	0.375	16.5	1.625	0.813	0.5	17.5	1.75	0.875	0.5	18	1.75	0.875	0.5	19.5	1.75	0.875	0.5
24"	18	0.625	0.313	0.188	19	1.5	0.75	0.375	19.5	1.625	0.813	0.5	20.5	1.75	0.875	0.5	21	1.75	0.875	0.5	22.5	1.75	0.875	0.5
30"	22.5	1.5	0.75	0.375	23	1.625	0.813	0.5	24	1.75	0.875	0.5	24.5	2	1	0.5	25	2	1	0.5	26.5	2	1	0.5
36"	26.5	1.5	0.75	0.375	27.5	1.625	0.813	0.5	28	1.75	0.875	0.5	28.5	2	1	0.5	29.5	2	1	0.5	31	2	1	0.5
42"	31	1.5	0.75	0.375	31.5	1.625	0.813	0.5	32.5	1.75	0.875	0.5	33	2	1	0.5	33.5	2	1	0.5	35	2	1	0.5



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8. Attach to Adjoining Insulation

Fill the gaps between the pipe and Pipe Thrust Plates with loose insulation. Abut the adjoining insulation against the surface of the Pipe Thrust Plates. Seal around the circumference of the joint between the Top and Bottom Clamps and adjoining insulation with mastic. Insulate over Top and Bottom Clamp ears and inside clamp gap.

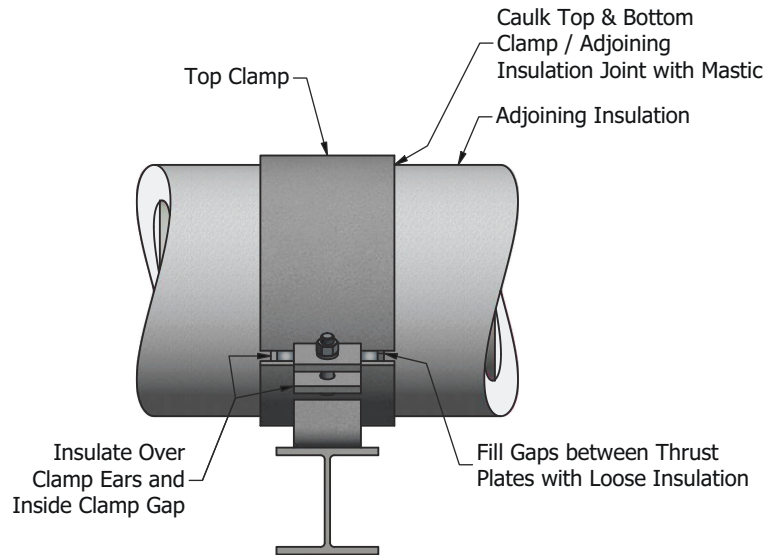
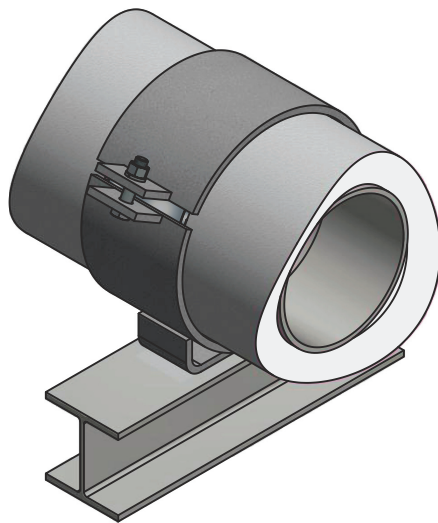


Table 2. Clamp Bolt Torque

BOLT SIZE	TORQUE ft*lb
1/2 - 13 UNC	25 - 35
5/8 - 11 UNC	50 - 60
3/4 - 10 UNC	90 - 100
7/8 - 9 UNC	160 - 170
1 - 8 UNC	230 - 250
1 1/8 - 7 UNC	280 - 300
1 1/4 - 7 UNC	400 - 420