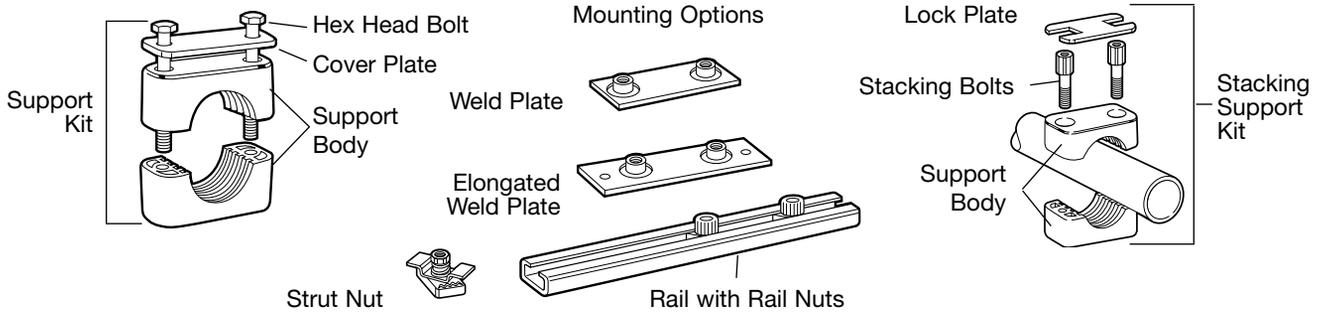


Support System Mounting Options



Weld Plates

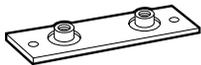
Weld plates mount directly to the support structure and are often used for single tube runs or where space is limited.



- Position the weld plate on the mounting surface.
- Secure the plate with a fillet weld. The weld should cover at least 75 % of the plate perimeter.

Note: Do not weld with support body halves in place, as excessive heat will damage the thermoplastic material.

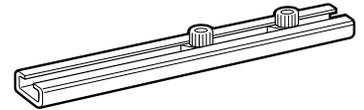
If welding is not appropriate, you can bolt elongated weld plates to the support structure. For this option, drill and tap two mounting holes for each plate to accept M6 or 1/4-20 UNC bolts. See chart.



Group	Hole Spacing	
	Fractional	Metric
1	2 in.	50 mm
3	2 1/2 in.	64 mm
5	3 3/8 in.	86 mm
6	4 in.	100 mm

Rail

Rail is often used for multiple (side by side) tube runs. You can easily adjust rail-mounted assemblies after the rail is in place.

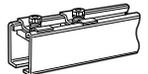


- Cut the rail to appropriate lengths.
- Position the rail on the mounting surface and secure with fillet welds. Welds should cover the entire length of the rail on both sides. Rails can also be drilled and bolted into place.
- Insert rail nuts and turn clockwise to lock. Rail nuts can be inserted anywhere along the rail.

Note: Do not weld with support body halves in place, as excessive heat will damage the thermoplastic material.

Strut

Strut nuts let you mount assemblies to any 1 1/2 in. standard-size structural strut system.



- Insert strut nuts and turn clockwise to lock. Strut nuts can be inserted anywhere along the strut span.

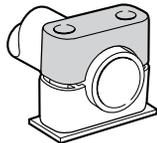
Support System Assembly Instructions



Step 1. Place one body half over the mounting component (weld plate, rail nuts, stacking assembly, or strut nuts).
Note: Body halves are identical and designed for a “snap” fit to facilitate assembly.

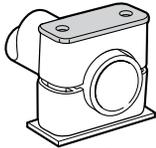


Step 2. Position the tube or hose across the body half.
Note: If rail or strut mounting is used, you can adjust the assembly to ensure proper alignment.



Step 3. Place the other body half over the tube or hose.

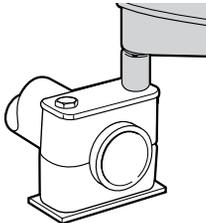
Insert Steps 3A, B, C, and D here when stacking additional supports



Step 4. Place the cover plate over the body assembly.



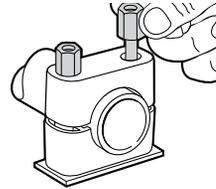
Step 5. Insert the hex-head bolts through the cover plate and body assembly. Tighten until finger-tight.



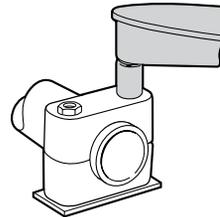
Step 6. Using a torque wrench, tighten each bolt to a maximum torque of 70 in-lb (7.9 N·m). Alternate between bolts while tightening to ensure even pull-up on both sides of the assembly.

Stacking Additional Supports

(Insert Steps 3 A, B, C, and D between Steps 3 and 4)



Step 3A - Insert the hex-head stacking bolts through the body assembly. Tighten until finger-tight



Step 3B - Using a torque wrench, tighten each stacking bolt to a maximum torque of 70 in-lb (7.9 N·m). Alternate between bolts while tightening to ensure even pull-up on both sides of the assembly.



Step 3C - Align stacking bolts until hex flats can receive lock plate.



Step 3D - Place the lock plate over the body assembly and the stacking bolts.

Repeat Steps 1 through 6 with each additional support.

Note: The final support onto any stack will be a non-stacking kit. Contact a Swagelok representative when stacking more than three (3) supports.

Translations available on
www.swagelok.com

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