





Using ST2MT or ST4MT Installation Tools

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	Safety glasses must be worn at all times by all persons within ten (10) feet of working metal tie installation tool. CAUTION: Be aware of the ejection of metal cable tie scrap from tool.
	Safety gloves must be worn while applying metal ties using this tool.
	DO NOT use tool on live electrical sources.
	DO NOT place fingers near gripper during tool actuation. Fingers may be pinched by moving gripper.

- Determine minimum acceptable required length for Heat Trace Wave-Ty
 - Nominal pipe diameters are based on either inside diameter (ID) or outside diameter (OD); and there are a number of schedules available throughout the internet.
 - ID is used for pipes sized from 0 – 12 inches. Greater than 12 inch pipe is typically measured in terms of OD.
 - The Panduit Heat Trace Wave Ty can cover pipes ranging from 1 inch up to 36 inches.
- Use look up table for pipe diameters and Heat Trace Wave Ty part numbers.

HTMLT Tie Part Number	Width (in.)	Length (in.)	Pipe Diameter	Std. Pkg. Qty.
			ST2MT/ST4MT Tools	
HTMLT2.7WEH-LP	0.50	10.2	1.0	50
HTMLT4WEH-LP	0.50	14.3	2.0	50
HTMLT6WEH-LP	0.50	20.5	3.0, 4.0	50
HTMLT8WEH-LP	0.50	26.8	6.0	50
HTMLT10WEH-LP	0.50	33.0	7.0, 8.0	50
HTMLT12WEH-Q	0.50	42.2	9.0, 10.0	25
HTMLT16WEH-Q	0.50	54.8	11.0, 12.0, 14.0	25
HTMLT26WEH-Q	0.50	86.2	16.0, 20.0, 24.0	25
HTMLT38WEH-Q	0.50	123.9	26.0 - 36.0	25

If you have a pipe diameter that is not listed on the table, move to the next highest size; i.e., 5 inch pipe diameter. This would require the use of the HTMLT8WEH-LP for the ST2MT/ST4MT tool

- Once you have selected the right size Heat Trace Wave Ty, go to actual onsite installation. For purposes of installing heat trace, first position heat trace against the pipe.

<p>4. Once positioned in place, wrap HTMLT tie around pipe and heat trace every 12 inches. Feed the tail into the head of the wave ty and manual position and tighten. Do not position head of tie over the heat trace.</p>	
<p>5. Use recommended tool for Heat Trace application (either RT2HT, ST2MT or ST4MT). Once HTMLT tie is positioned and hand tightened around pipe and heat trace, begin feeding tail through side entry head of tool.</p>	
<p>6. Once tail is positioned through head of tool, begin squeezing handle to begin tightening HTMLT tie. As you tighten Heat Trace Wave Ty, you should begin to notice that heat trace is getting pulled in contact with the pipe. Repeat squeezing motion with handle until heat trace is tight and secure against pipe.</p>	
<p>7. Do not over tighten HTMLT ties. As tie begins to tighten around pipe, you may begin to notice that wave begins to flatten out. Be sure to stop tightening tie prior to wave becoming flat.</p>	
<p>8. Once heat trace is in contact with pipe and is tight and secure, move cutting handle upward to engage cutting action on the ST4MT and remove excess material. For the ST2MT keep tool engaged and twist counter clockwise (turn to the right) to cut off excess material.</p>	
<p>9. Repeat every 12 inches until heat trace is completely attached along the entire length of the pipe.</p>	



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