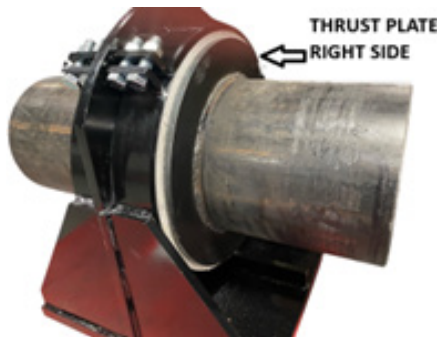
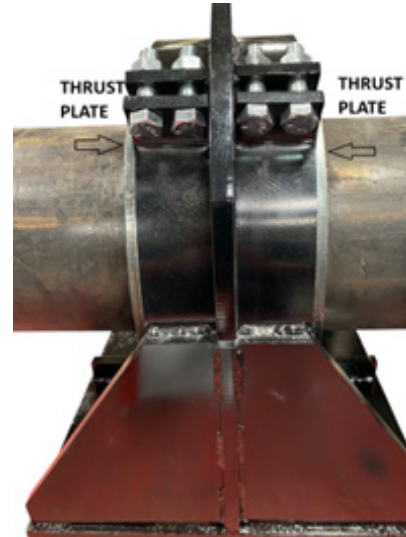
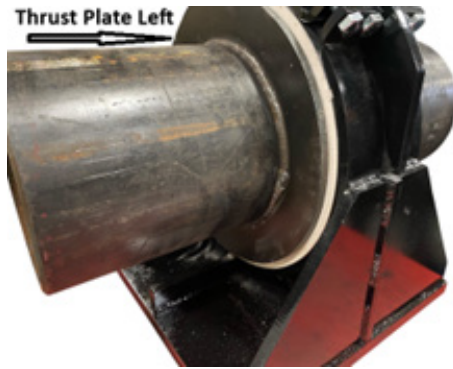


**1. Component: Anchor Assembly**

Anchor ships completely assembled. (do not un-assemble)  
(Bi-Direction Anchors are standard.) No in field welding required for thrust plates.



Inside view of pipe and thrust plate minus insulation insert

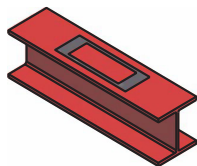


**2. Locate the Anchor Base**

Place the Anchor base on the structural support member and align it under the centerline of the pipe in the lateral direction. Then locate the Anchor base on the structural support member along the axial direction of the pipe. Mark the perimeter of Anchor Base on structural support member for welding preparation.

**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.



Example: Grind support structure

4. Our pre-insulated anchor is Bi-Directional meaning thrust plates have been welded directly to the pipe supplied, please see photo's at top of page (1) for reference.

**5. Weld Anchor Base to Structural Support Member. (Refer to your piping engineering layouts for all welds.**

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

**6. Anchor Bolting Option**

Anchor may be bolted in place instead of welded.

(Refer to your pipe engineering layout for how units should be anchored or bolted)

**7. Attach to adjoining Pipe**

The Pre-Insulated unit comes installed with a pre beveled pipe with thrust plates welded directly to the pipe. Unit is completely drop in place, (Do Not Un- Assemble . Customer supplied pipe should be cleaned, and beveled to weld directly to the unit. Weld pipe according to your pipe engineering layout.

**8. Attach to adjoining insulation**

Fill in any 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.