

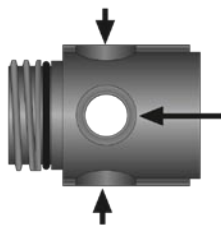
GENERAL GUIDELINES

Please review the instructions and warranty carefully. Assembly and installation are the installer's responsibility and beyond HeatLink's control. Therefore, HeatLink exclusively limits its warranty to the repair or replacement of a defective TwistSeal® manifold for up to 5 years.

1. Assemble the manifold under clean conditions. Any dirt on the o-rings may compromise seal. **Ensure the o-rings are clean.**
2. Use hand tightening only to connect manifold components. Use of wrenches are permitted on cross tee accessories, but do not overtighten o-rings. To tighten manifold nuts use only the manifold nut wrench.
3. Brace or support the supply and return mains parallel to the manifold and centered with the manifold's inlet and outlet. This will prevent stress and possible damage on the manifold supply and return end connections.
4. When assembling **do not** crossthread manifold components.
5. Use precautions when soldering or applying heat within 16" of any manifold component.
6. Use ball valves in front of manifold for servicing requirements.
7. Prevent aggressive substances from coming into contact with the TwistSeal® manifold and its accessories. This warning includes, but is not limited to, thread sealants, leak check compounds, bug sprays, lubricants, strong cleaning solvents, paints, bleaches, fluxes, etc. (see also INFO 24). However, pipe dopes and Teflon tape are permitted for use on the supply end connections.
8. Protect the manifold during all phases of construction using a polyethylene sheet or an enclosure.
9. Retighten the plastic manifold nuts after the first week of system operation.

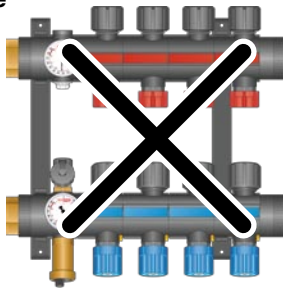
GENERAL GUIDELINES cont.

10. The ports on the cross tee are straight threads. Tightening an NPT threaded fitting into these ports can cause the tee to crack if overtightened. Do not use as test ports. Only TwistSeal® Manifold accessories with o-rings should be used on the cross tee ports.



11. When installing actuators on the supply manifold, the red shut off cap must be removed.

12. **Manifolds are not to be installed upside down.**



13. Do not use TwistSeal® manifolds and accessories for purposes other than those for which they were designed. Do not exceed their specifications. Failure to follow these guidelines or the product's instructions will void the warranty.
14. In case a leak develops during testing, remove pressure from system, clean the o-ring, and reapply silicon lube.
15. **A water analysis is recommended for every installation site. For warranty claims a water analysis is mandatory.**
16. Consult with your HeatLink® dealer or distributor if you have any questions regarding the operations and limits of HeatLink products. Review all instructions and warranty information carefully.

HEATLINK LIMITED WARRANTY TwistSeal® MANIFOLD SYSTEM

Refer to HeatLink Limited Heating Warranty.

WARNING!

DO NOT disassemble the TwistSeal® manifold while the system is under pressure. Serious injury can result.
Use only silicone o-ring lubricant #79951 or #79952. Use of petroleum based lubricants will void the warranty.

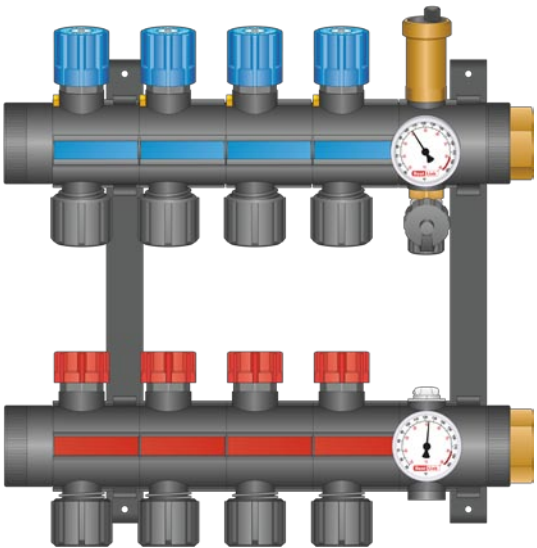
Twist Seal®

79401 TwistSeal Basic Manifold Assembly Kit - 1"

79400 TwistSeal Deluxe Manifold Assembly Kit - 1"

79402 TwistSeal Commercial Manifold Assembly Kit - 1-1/2"

79401 • 79400 • 79402 Assembly Instructions



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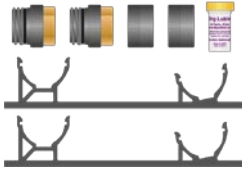
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Twist Seal®

Before you begin, please read the guidelines and assembly instructions carefully.
Make sure that all parts are included in the packages.
Assemble step by step.

79401 Basic Manifold Assembly Kit

- 2 mounting brackets (#79991)
- 2 - 1" FIP supply end connections (#79902)
- 2 closed end caps (#79901)
- 1 lube bottle (#79952)



79400 Deluxe Manifold Assembly Kit

- 2 mounting brackets (#79991)
- 2 - 1" FIP supply end connections (#79902)
- 2 closed end caps (#79901)
- 1 lube bottle (#79952)
- 2 cross tees (#79908) c/w 3 - 1/2" cross tee plugs (#79911)
- 1 thermometer pair (#79940)
- 1 manual air vent (#79931) with 1 key (#79933)
- 1 automatic air vent (#79932)
- 1 hose bib (#79930)
- 1 wrench for plastic nut (#79922)



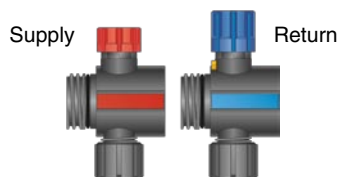
79402 Commercial Manifold Assembly Kit

- 2 mounting brackets (#79991)
- 2 - 1-1/2" MIP supply end connections (#79904)
- 2 closed end caps (#79901)
- 1 lube bottle (#79952)
- 2 cross tees (#79908) c/w 3 - 1/2" cross tee plugs (#79911)
- 1 thermometer pair (#79940)
- 1 manual air vent (#79931) with 1 key (#79933)
- 1 automatic air vent (#79932)
- 1 hose bib (#79930)
- 1 wrench for plastic nut (#79922)



Not Included

Manifold Modules #78400

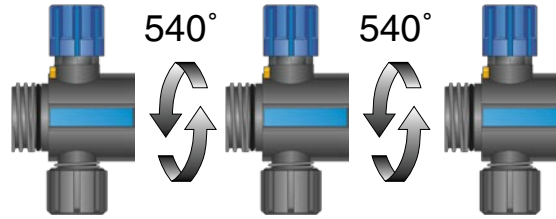


Pipe to Manifold Connectors
#77012, 3/8"
#77005, 1/2"
#77019, 5/8"
#77022, 3/4"



1

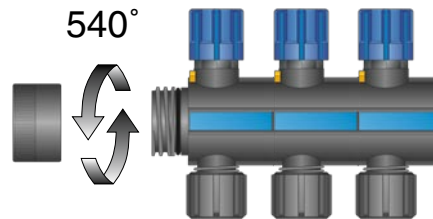
Assemble manifold modules (not included)
(Return modules shown; repeat with supply modules).



• See General Guidelines #11 regarding actuator installation

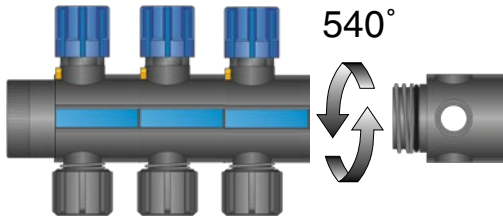
2

Connect closed end cap.
(Return modules shown; repeat with supply modules).



3

Connect cross tee.
(Return modules shown; repeat with supply modules).

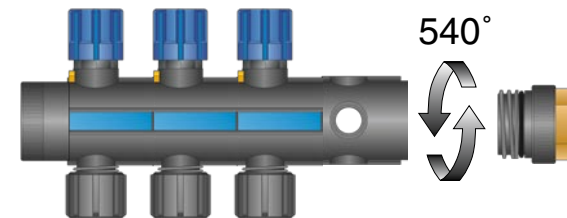


Note: For Basic Kit skip this step.

4

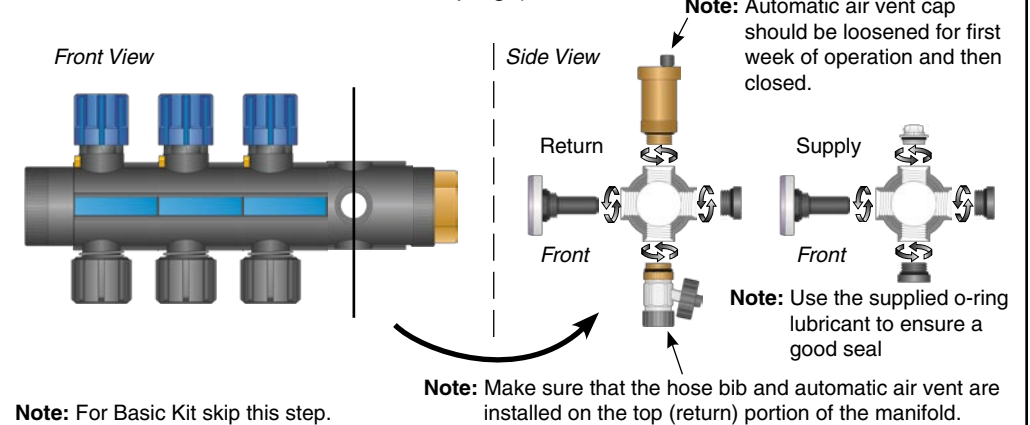
Connect 1" or 1-1/2" supply end connection.
(Return modules shown; repeat with supply modules).

When installing fittings into supply end connections: loosen the supply end connection one quarter of a turn (the connection is still sealed). Use a backup wrench on the supply end connection when tightening fitting. When the fitting is tight, the supply end connection can be turned back to its original position. Do not turn the supply end connection past the stop wedges.



5

Install cross tee accessories (automatic air vent, thermometers, hose bib, manual air vent, and cross tee plugs).



6

Snap manifold into brackets. Return on top and supply on bottom.

When placing the manifold into the supporting bracket:

place the bottom snap-in lock in the bottom (braced) notch and then rotate it so that the top snaps into place. Bracket may fail if installed incorrectly.

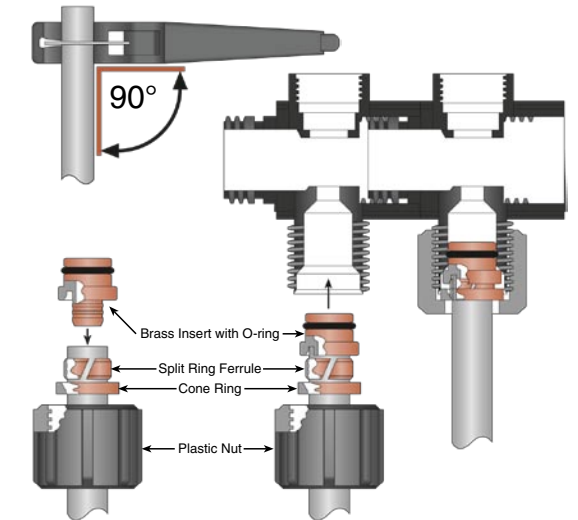


Brackets should be placed as close to ends of the manifold as possible (see complete manifold on front panel). Cross tee must be supported with a bracket. Manifolds with more than 5 module pairs should be supported by additional #79991 bracket(s).

Note: Supply & return piping must be supported as per General Guideline #3.

7

PEX Pipe to Manifold Connection using #77000 Series Connectors (not included)



1. Remove Plastic Manifold Nut from Manifold Module.
2. Lubricate the inside of the manifold port with silicone o-ring lubricant (#79952).
3. Cut the PEX pipe at a 90° angle.
4. Place the Plastic Manifold Nut, Cone Ring, and Split Ring Ferrule onto the PEX pipe (the bevelled edge of the Cone Ring must be facing the Split Ring Ferrule).

Method A

5. Push the Brass Insert onto the PEX pipe as far as it will go.
6. Push the PEX pipe with Brass Insert as far as it will go into the manifold module. Ensure the o-ring is clean and take care not to pinch it.

Method B

5. Push Brass Insert as far as it will go into the manifold module. Ensure the o-ring is clean and take care not to pinch it.
6. Push PEX pipe onto the Brass Insert as far as it will go.
7. Use the multi-purpose wrench to tighten the nut. To prevent overtightening, the wrench is designed to slip when the nut is tight.