

Service Bulletin



Field Assembly Instructions for HMA 2 and HMA 2A Hardware Kits # 8452-69, 8452-72 & 8452-73



CAUTION: READ AND UNDERSTAND THIS BULLETIN THOROUGHLY BEFORE STARTING. ONLY A TRAINED EXPERIENCED TECHNICIAN SHOULD ATTEMPT THIS PROCEDURE.

When assembling Make-Up air burners, a few simple but very important assembly procedures must be followed to ensure proper burner performance. **REFER TO MIDCO'S HMA2/2A Installation and Service ENGINEERING MANUAL - 8471-34.** The HMA2/2A series manual can be found on the Midco website <http://www.midcointernational.com/products/hma2/index.htm>

Ordering of kits is based on burner configuration. Be sure to order the correct number of kits for field assembly.

NEEDED for all field assemblies

Part #	Description
	Furnace Cement

Kit # 8452-69 - End Plate, Pilot Plate or Section

Part #	Description	Qty
HW1-214	5/16-18 X 1.75" Bolts	3
HW2-216	5/16" Hex Nuts	3
HW3-170	5/16" Lock Washers	3
HW1-022	#10-24 X 3/8" Screws	10
HW2-115	#10-24 Hex Nuts	10
HW3-146	#10 Lock Washers	10
HW3-140	#10 Flat Washers	10

Kit # 8452-72 - 1-1/2" Gas Inlet Flange

Part #	Description	Qty
HW1-215	5/16-18 X 2" Bolts	3
HW2-216	5/16" Hex Nuts	3
HW3-170	5/16" Lock Washers	3
HW1-022	#10-24 X 3/8" Screws	10
HW2-115	#10-24 Hex Nuts	10
HW3-153	#8 Lock Washers	10
HW3-140	#10 Flat Washers	10

Kit # 8452-73 - Mounting Bracket with Hardware

Part #	Description	Qty
HW3-168	5/16" Flat Washers	6

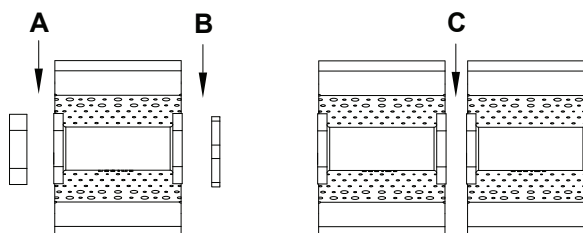


Figure 1 - Typical HMA 2 & HMA 2A 6" Direct Fire Burner Assembly

Instructions:

- 1-1/2" gas inlet flange with pilot plate or blank plate: For assembly use one # 8452-72 kit and furnace cement See Note # 1.
- Blank flange with pilot plate or blank plate: For assembly use one # 8452-69 kit and furnace cement See Note # 1.
- Burner sections: For assembly use one # 8452-69 kit and furnace cement. See Note # 1.

Notes:

- Furnace cement (not supplied by Midco) is only to be applied between the castings and blank plate, pilot plate, or end flanges, not between baffles and end plates.
- Hardware listed in instructions A and B applies to any size burner.
- For definition and views of burner sections, plates, flanges, and hardware refer to pages 16 and 17 of the Midco HMA Installation and Service Instructions - 8471-34. The pdf can be found on the Midco website: <https://midcointernational.com/wp-content/uploads/2021/10/8471-34.pdf>.

- Burner drawing symbols represent a view of the burner from side opposite flame exit.
- In the absence of a rivet gun, use the hardware specified in these kits. Stainless steel hardware is **required**. **UNDER NO CIRCUMSTANCE SHOULD STANDARD GRADE OR ALUMINUM RIVETS BE USED.**
- Hardware between burner sections is the same as the hardware used in Instruction B, above.
- Pilot hardware is included with the pilot assembly.
- Mounting brackets must be installed on the exterior side of the inlet or blank flange. **UNDER NO CIRCUMSTANCE SHOULD MOUNTING BRACKETS BE INSTALLED BETWEEN THE FLANGE AND THE BURNER CASTING.**



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AVOID ERROR IN PARTS SELECTION. When ordering use complete MIDCO Part Number and Description.

IMPORTANT: Availability of parts as well as specifications are subject to change without notice. Please consult factory for item availability.

SAFETY INFORMATION TERMS: The following terms are used to identify hazards, safety precaution of special notations and have standard meanings throughout this manual. They are printed in all capital letters using a bold type face as shown below, and preceded by the exclamation mark symbol. When you see the safety alert symbol and one of the safety information terms as shown below, be aware of the hazard potential.



DANGER:
WARNING:
CAUTION:

Identifies the most serious hazards which will result in severe personal injury or death.
Signifies a hazard that could result in personal injury or death.
Identifies unsafe practices which would result in minor personal injury or product and property damage.

