



## Field Assembly Instructions for Factory Pre-assembled HMA-2 and HMA2A (Make-Up Air Burner) Sections and End Flanges

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When assembling Make-Up air burners, a few simple but very important assembly procedures must be followed to insure proper burner performance. **READ AND UNDERSTAND THIS BULLETIN THOROUGHLY BEFORE STARTING. ONLY A TRAINED EXPERIENCED TECHNICIAN SHOULD ATTEMPT THIS PROCEDURE.**

**IMPORTANT: Furnace cement must be used to join and seal all burner casting joints, and all end flanges to baffle end plates. Use 10-24 x 3/8" stainless steel screws, washers, nuts or steel rivets. Under no circumstances should standard grade hardware or aluminum rivets be used.**

1. Prepare a mixture of furnace cement thinned to the consistency of very heavy cream.
2. Apply a thin coat of furnace cement to both mating surfaces of castings prior to joining with fasteners. Apply cement as you go, as cement should not dry before assembling mating surfaces.
3. Complete mechanical assembly before furnace cement begins to harden.
4. After applying furnace cement between casting surfaces install bolts in casting holes provided. Hand tighten only
5. To secure baffles together install stainless steel screws, washers, nuts or rivets.
6. Tighten stainless screws and nuts or rivets.
7. Align gas channel on each casting and tighten bolts and nuts.
8. Wipe excess cement from castings mating surfaces and low fire zone of casting. Make sure not to clog any gas or lowfire air ports.
9. Pay particularly close attention to all butted surfaces. There must be no visible gaps between castings. If there is a gap or recession, fill in with furnace cement.

