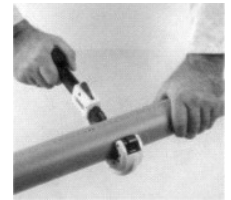


Pipe cutting

The casing pipe should be cut using a sharp Stanley knife or similar. Cut evenly all the way around the corrugation. Carefully cut away / remove insulation.

Cut the carrier pipe with an appropriate pipe cutter as shown.



Use only a wheel cutter for plastic pipe.

Attach rubber end caps. Pull the end cap over the third corrugation of the casing pipe. Use the supplied zip ties to seal the end cap to the casing pipe and the carrier pipe(s).



For All Electrofusion welding - Pipe preparation

Welding should not be undertaken in ambient temperatures below 5°C !



Do not chamfer pipe ends.

Clean the pipe ends and internal weld area of the fitting

Pipe ends and internal weld area of the fitting must be cleaned and free from oil, dirt and grease prior to pipe abrasion.

We recommend the use of Tangit fluid cleaner or Tangit cleaning wipes.



Abrade Pipe Ends

Abrade outer surface of pipe ends with emery cloth (180 GRADE) in a radial direction.

Make sure that at least the insertion depth is abraded



Do not abrade the outer surface of the pipe ends in the longitudinal direction.



Clean the pipe ends and internal weld area of the fitting

Pipe ends and internal weld area of the fitting must be cleaned and free from oil, dirt and grease.

We recommend the use of Tangit fluid cleaner or Tangit cleaning wipes.



Mark Insertion depth

Mark the depth of insertion on the pipe. Insertion depth guides are marked on the fitting

Do not use a wax pencil!



Insert pipes into the fitting

Insert pipes into the fitting as far as the insertion mark.

**Do not tighten the fitting screws !
Use only separate alignment clamps.
See next step.**



Fix and Tighten Fitting Alignment Clamps

Alignment clamps must be used for all pipe sizes 16mm to 110mm.



Execution of Electrofusion

Connect the fusion control box to the power supply.

Connect fusion cable to fitting terminal.

Start the fusion operation by pressing the START button.

Fusion process runs automatically.

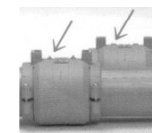


Fusion Check

The optical fusion check is verified by the appearance of the welding indicators.



must be allowed to cool with clamps in place for the following times.....



25mm – 50mm 10mins

63mm – 110mm 15mins

Clamps must not be removed before cooling time has elapsed.