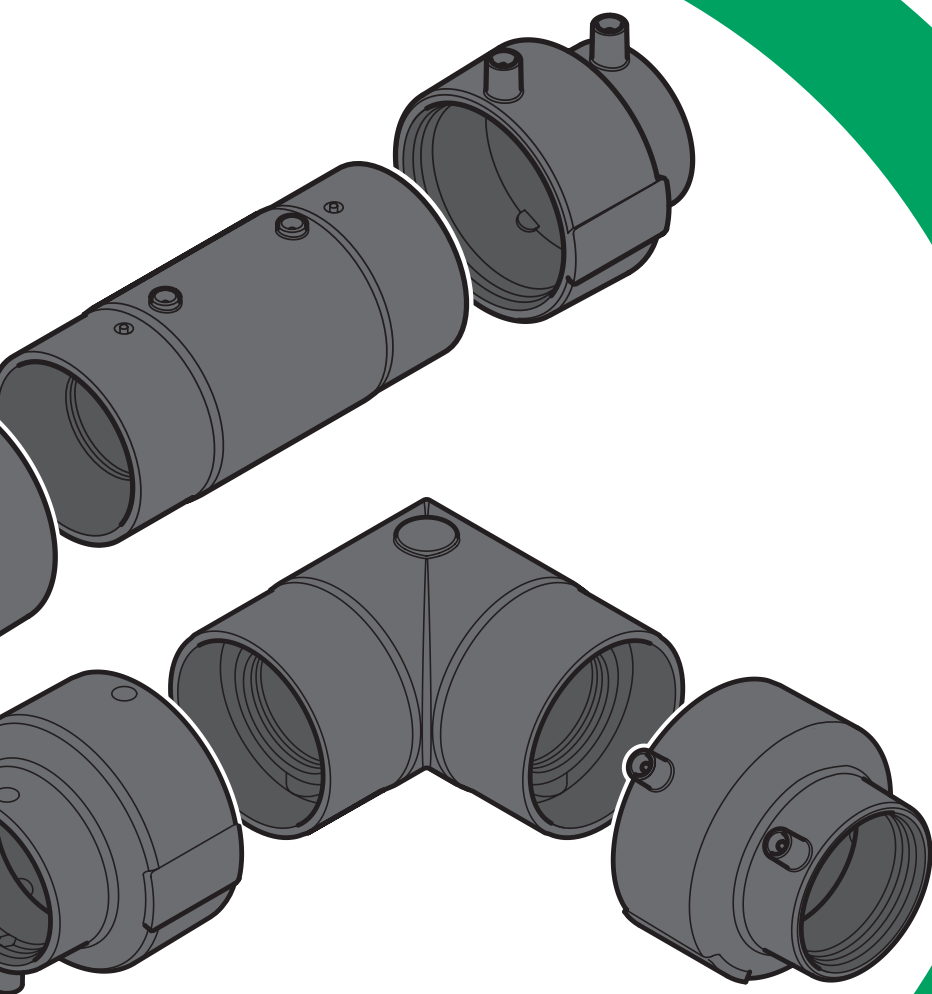


SMARTFLEX™

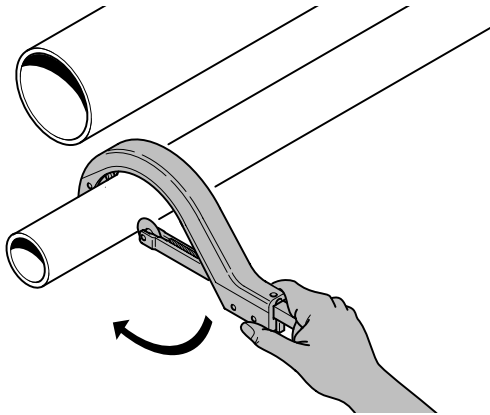
Assembly instructions of coaxial double wall fittings ø50 and ø63 and SGEDW110



Models
SCEDW63
SMEDW50/63
SGEDW50/63
STEDW50/63
SGEDW110

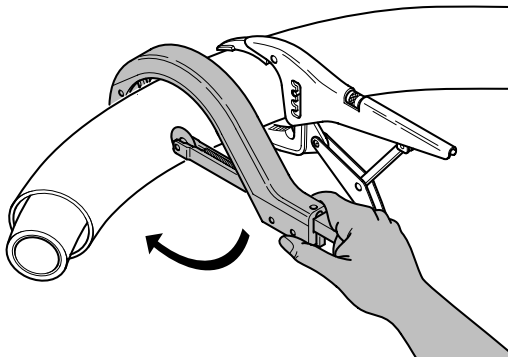


Fig.1



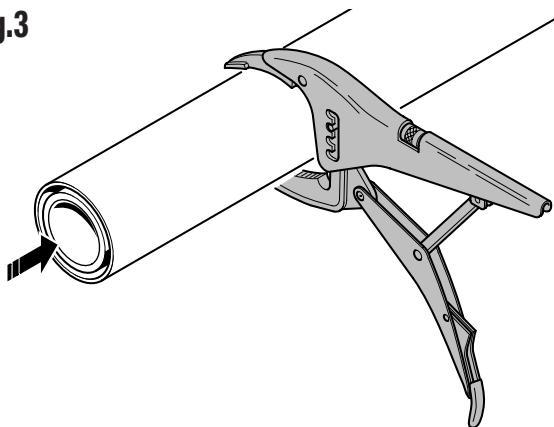
Cut the primary and secondary pipes to the same length using the appropriate pipe cutter (Model SCUT or Model SCUTDW) when using straight lengths pipes.

Fig.2



Cut the primary and secondary pipes to the same length using the appropriate pipe cutter (Model SCUT or Model SCUTDW) when using pipes in coils.

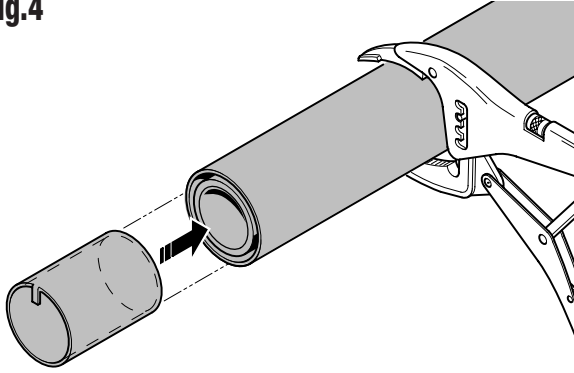
Fig.3



Ensure the primary pipe is constrained by using the pliers for double wall pipes (Model SPLIDW).

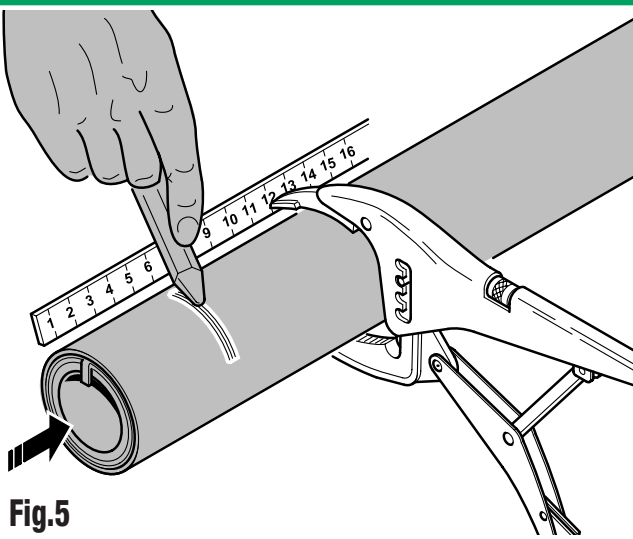


Fig.4



Insert the metallic protective sleeves (Model STP) between the secondary and primary pipes.

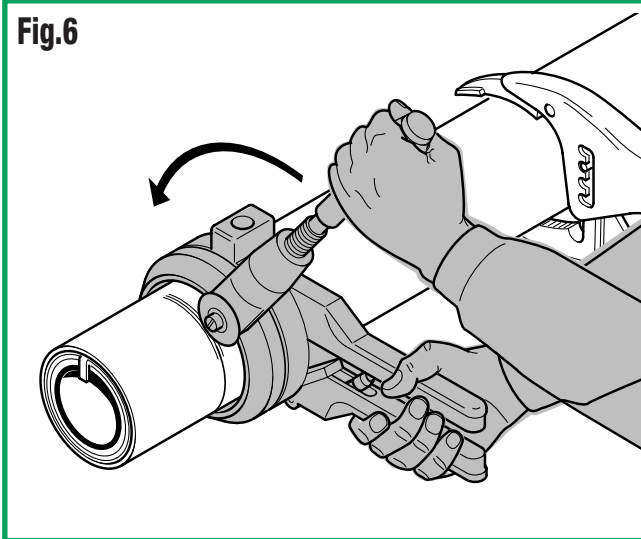
Fig.5



Use the appropriate marker (Model MARK) to clearly indicate on the secondary pipe the measurement **Px** (as listed in the table on page 4).

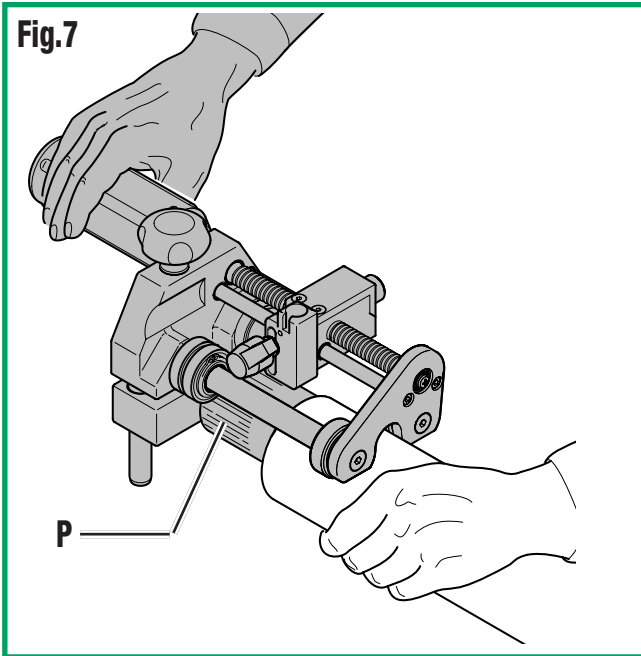


Fig.6



Cut the pipe at the correct length using the appropriate pipe cutter (Model SCUTDW or Model SCUT).

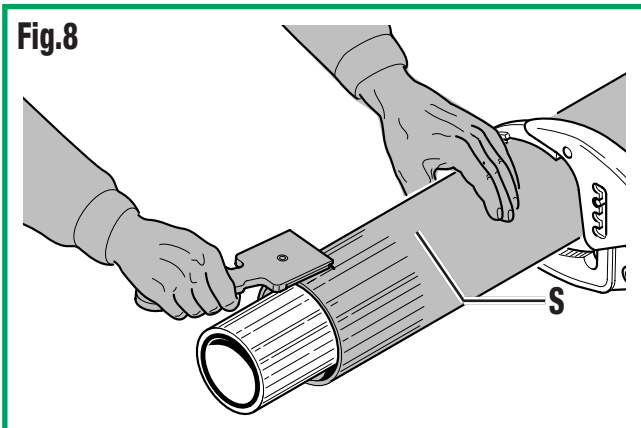
Fig.7



Scrape the primary pipe to a length equivalent to **P** (as listed in the table on page 4), using the universal scraper (Model RAT0).

Note: For a correct installation of the SuperSmartflex pipe, ensure to **SCRAPE AND COMPLETELY REMOVE THE GREEN OUTER LAYER** from the primary pipe until the black polyethylene layer is clearly visible on the outside of the pipe. Remove the outer layer completely, including the tie layer, until you reach the black HDPE layer. The omission of this step can cause a weld to fail.

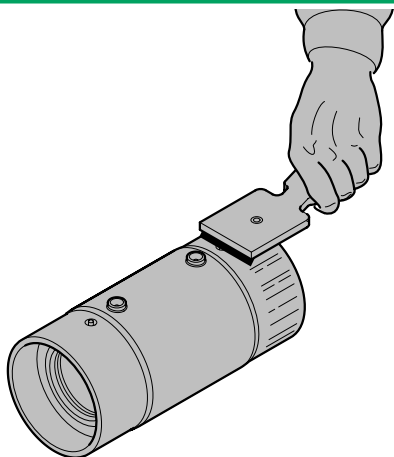
Fig.8



Scrape the secondary pipe to a length equivalent to **S** (as listed in the table on the page 4) using the manual scraper (Model RAM1) or the universal scraper (Model RAT0).



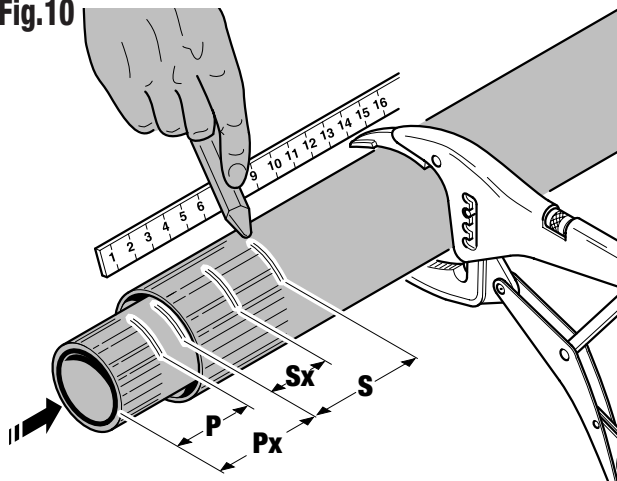
Fig.9



Scrape the fitting spigot with the manual scraper (Model RAM1). If the fitting is taken from its protective wrapping and used immediately it is not necessary to scrape it.

Note: Never use under any circumstances sand paper, emery cloth, files, knives or sharp objects.

Fig.10



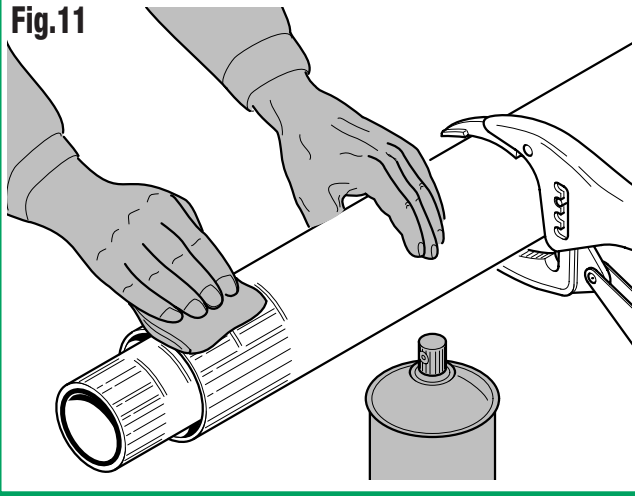
Use the appropriate marker (Model MARK) to clearly indicate the insertion length **Px** on the primary pipe and **Sx** (as listed in the table on page 4) on the secondary pipe.

Note: When possible, always use the pipe aligner (Model ALL225/4) to eliminate stress and/or tension during the welding process.

ITEM	Sx		S		P		Px	
	mm	in	mm	in	mm	in	mm	in
SMEDW50	47	1,85"	100	3,94"	56	2,20"	75	2,95"
SMEDW63	60	2,36"	120	4,72"	62	2,44"	83	3,27"
SCEDW63	60	2,36"	120	4,72"	62	2,44"	83	3,27"
SGEDW50	47	1,85"	100	3,94"	56	2,20"	75	2,95"
SGEDW63	60	2,36"	120	4,72"	62	2,44"	83	3,27"
STEDW50	47	1,85"	100	3,94"	56	2,20"	75	2,95"
STEDW63	60	2,44"	120	4,72"	62	2,44"	83	3,27"
SGEDW110	105	4,13"	200	7,87"	95	3,74"	125	4,92"



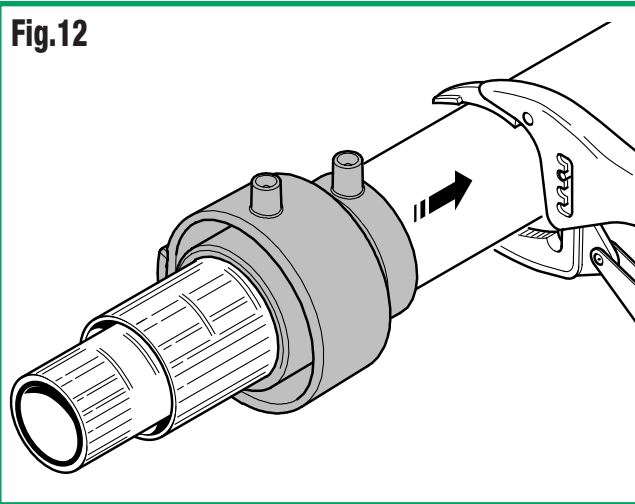
Fig.11



Clean the ends of the primary and secondary pipes, the fitting spigot and the socket with a clean cloth soaked with a recommended cleaning solvent (Model LID1).

Note: The following solvents may be used, **Acetone, Isopropyl Alcohol, Trichloroethane and Dichloromethane**. The use of other primers or solvents is not allowed.

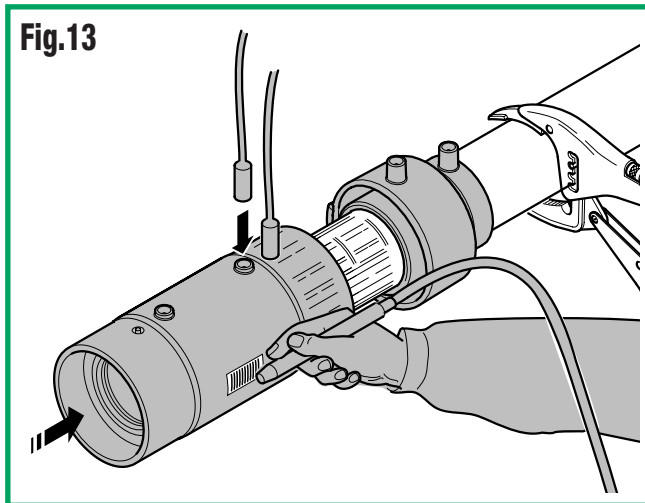
Fig.12



Fit the reducer and slide it along the secondary pipe.



Fig.13



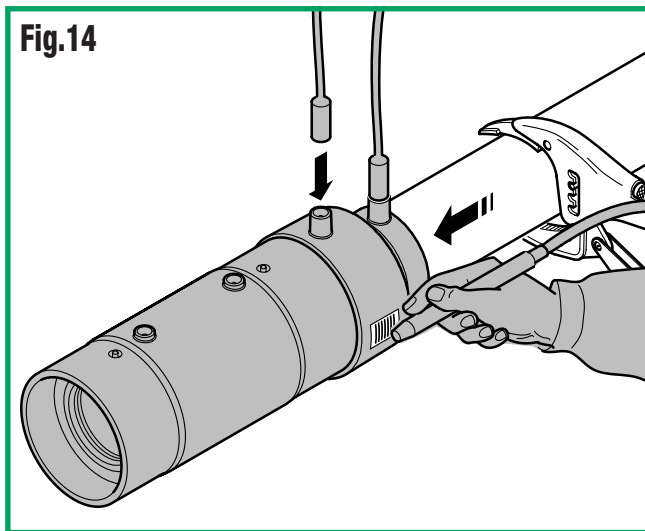
WELDING OF THE PRIMARY PIPE

Check that the pipes are correctly clamped with the pliers (Model SPLIDW), then insert the primary pipe ensuring that the insertion length **Px** (as listed in the table on page 4) is reached.

Electro-fusion welding of pipe and fitting may now commence following the instructions shown on the welding unit's display.

NOW WE RECOMMEND YOU TO PERFORM THE PRESSURE TEST ON THE PRIMARY LINE.
The test can be performed only after the cooling down process has been completed.

Fig.14



WELDING OF THE SECONDARY PIPE

Slide the reducer until it fits correctly on the fitting and check the insertion length **Sx** previously marked on the pipe is visible.

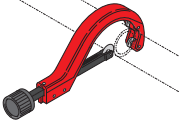
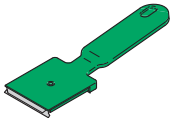
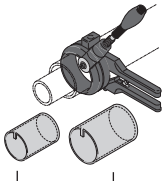
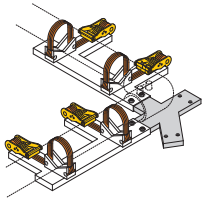
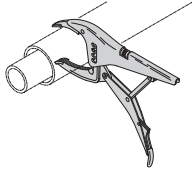
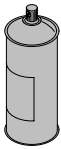
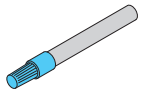

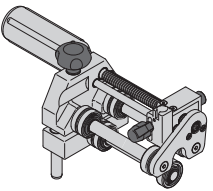
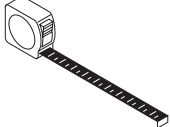
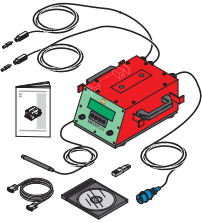
Note: Do not force the pipe to a complete stop inside the fitting as this may shut off the interstitial space.

Electro-fusion welding of secondary pipe may now commence following the instructions shown on the welding unit's display.

NOW WE RECOMMEND YOU TO PERFORM THE PRESSURE TEST ON THE SECONDARY LINE.
The test can be performed only after the cooling down process has been completed.



Recommended tools and equipment necessary for the assembly:

1 	Pipe cutter (Model SCUT) (Model SCUTDW)	5 	Manual scraper (Model RAM1)
 STP	Protective sleeves (Model STP)	6 	Aligner (optional) (Model ALL225/4)
2 	Pliers for double wall pipe (Model SPLIDW)	7 	Cleaning solvent or primer
3 	Marker (Model MARK)	8 	Soft cloth
4 	Universal scraper (Model RAT0)	9 	Measuring tape
		10 	Welding unit (Model SSEL8404)

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