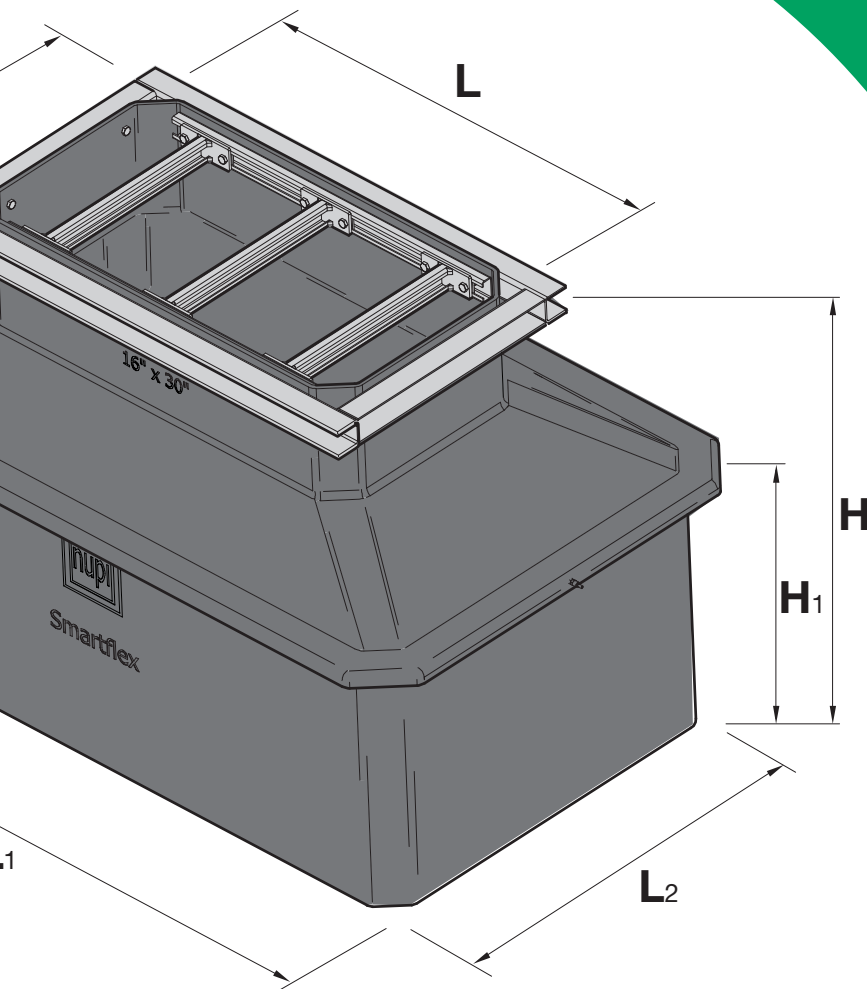


# SMARTFLEX™

## Assembly instructions of an electrofusion dispenser sump

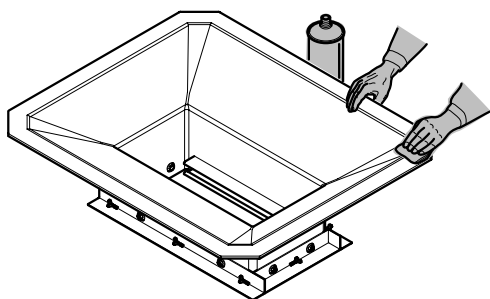




**Attention:** In order to have suitable space necessary to assemble the various components inside the sump, we recommend that you electro-weld the upper section only at the completion of the piping installation process.



**Fig.1**

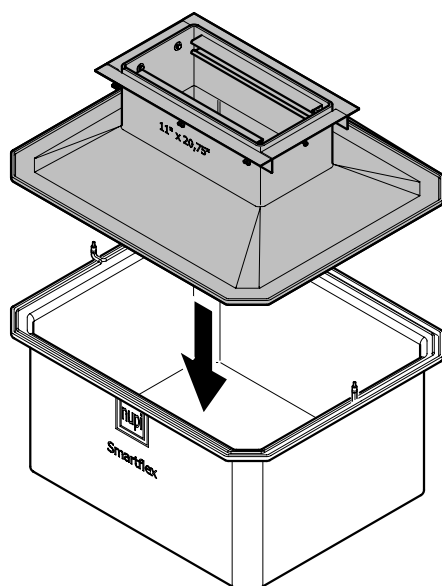


Scrape the surface to be welded with the manual scraper (Model RAM1), then clean all the components involved in the welding with a clean cloth soaked with a recommended cleaning solvent (Model LID1).

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

**Note:** When scraping, a perfectly even surface is required, please take care to remove any roughness that could cause the weld to be unsuccessful.

**Fig.2**

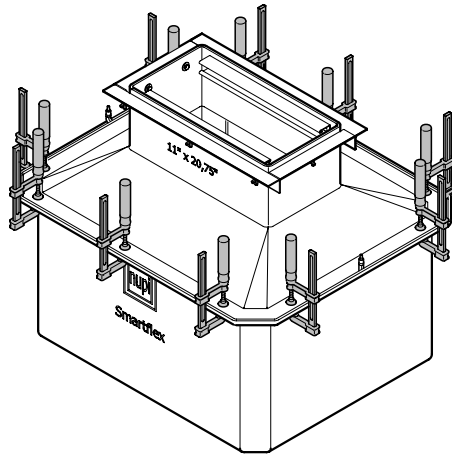


Position the upper section of the sump on the base.

**Note:** Take care not to damage the connectors necessary for the welding process.

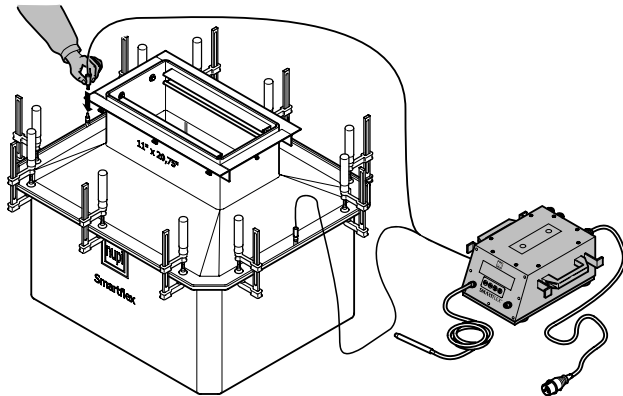


**Fig.3**



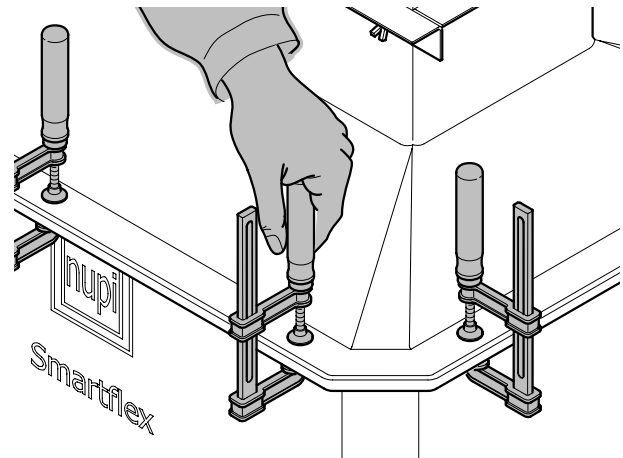
Secure the two components together using 10 clamps (3 positioned on the long sides and 2 on each short side).

**Fig.4**



Weld the sump using the specific bar code, following the instructions shown on the welding machine's display.

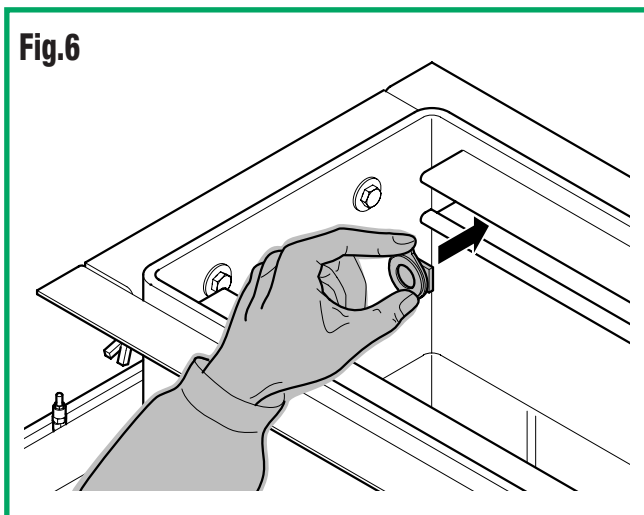
**Fig.5**



During the welding and cooling down time further tighten the clamps to increase the adhesion between the two components.



**Fig.6**

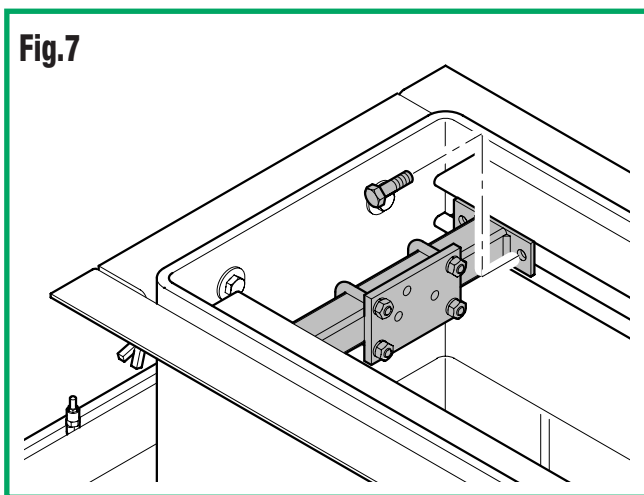


Wait until the cooling down time shown on the bar code of the sump has elapsed, then remove the clamps.

**Note:** At this stage ensure all nuts and bolts are tight on strut assemblies as they may have loosened during transit.

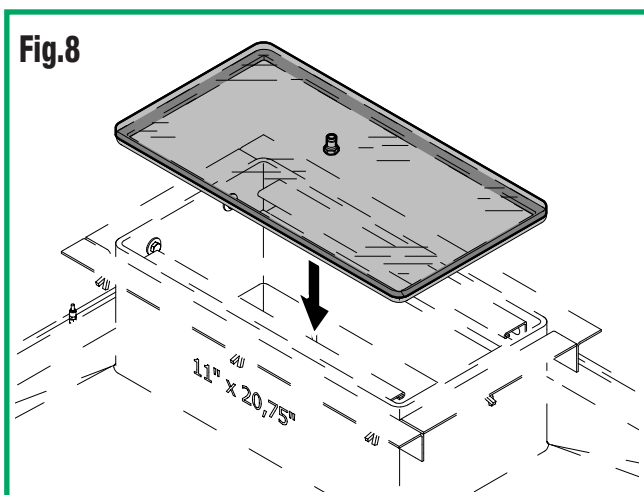
Insert the nuts provided inside the side struts positioned on the long sides of the sump. Slide the nuts into the correct position.

**Fig.7**



Secure the stabilizer bars on the side struts using the studs provided.

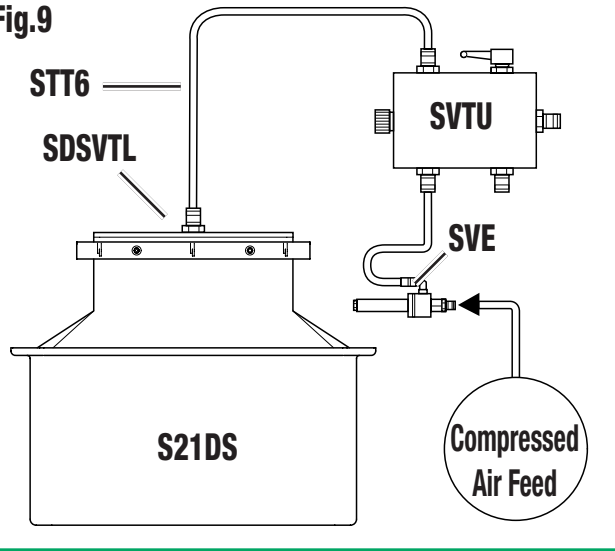
**Fig.8**



Position the Plexiglas lid (Model SDSVTL) onto the top of the sump.



**Fig.9**



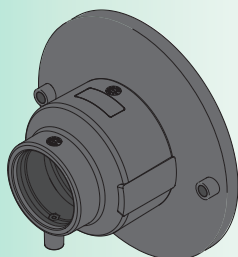
**Note:** To perform a vacuum test on the lid it is necessary to follow these steps:

1. Connect the specific test tube for the test (Model STT6).
2. Connect the ejector (Model SVE) to the compressor line to generate a vacuum to commence the vacuum test.
3. Connect the test line to the vacuum test unit (Model SVTU) following the specific instructions.

The vacuum test for all dispenser sumps (Models S21DS2111, S21DS2518, S21DS3016, S21DS4211 and S21DS4216) shall be performed at a  $P_r = -0.08$  bar for 20 minutes (to simulate a burial depth of 0,8 metres).

The following items are required for the connection of piping to the dispenser sump:

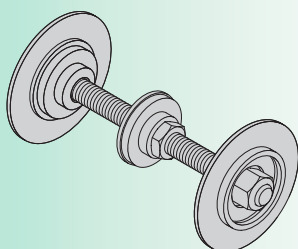
#### ELECTROFUSION ENTRY BOOT FOR DOUBLE WALL SYSTEM



Ø mm	Code	Package (pcs)	Notes
32	SEBE32	1	for single wall pipe Ø32mm
40	SEBE40	1	for single wall pipe Ø40mm
50	SEBE50	1	for single wall pipe Ø50mm
63	SEBE63	1	for single wall pipe Ø63mm for double wall pipe Ø50mm
75	SEBE75	1	for double wall pipe Ø63mm
90	SEBE90	1	for single wall pipe Ø90mm
110	SEBE110	1	for single wall pipe Ø110mm
125	SEBE125	1	for double wall pipe Ø90mm

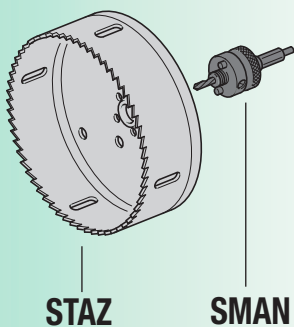
• For a correct installation it is necessary to use the **SEBECOMT** tool

#### ELECTROFUSION ENTRY BOOTS INSTALLATION TOOLS



	Code	Package (pcs)	Notes
-	SEBECOMT	1	compression tool

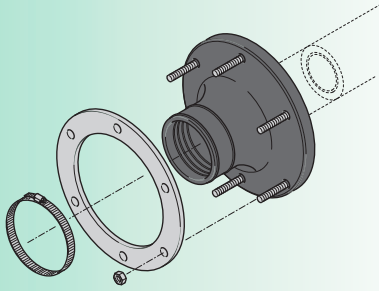
#### HOLE SAW AND MANDREL



Ø (mm)	Code	Package (pcs)	Notes
35	STAZ35	1	for saddles reducing to 50 mm
48	STAZ48	1	for saddles reducing to 63 mm
70	STAZ70	1	to install SEB25, SEB32, SEB40 SEBE32, SEBE40
98	STAZ98	1	to install SEB50, SEB63, SEB75, SEB90, SEBE50, SEBE63, SEBE75, SEBE90
140	STAZ140	1	to install SEB110, SEB125 SEBE110, SEBE125 and SCUFV180110
-	SMAN	1	mandrel for hole saws

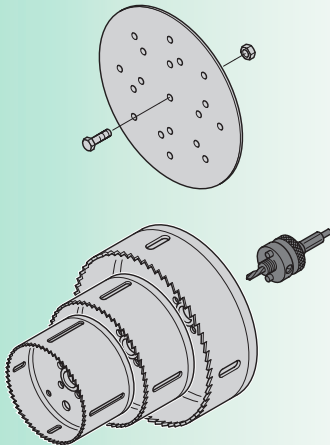


## ENTRY BOOT



Ø (mm)	Code	Package (pcs)	Notes
25	SEB25	1	
32	SEB32	1	for single wall pipe Ø32mm
40	SEB40	1	for single wall pipe Ø40mm
50	SEB50	1	for single wall pipe Ø50mm
63	SEB63	1	for single wall pipe Ø63 and for double wall pipe Ø50mm for secondary pipe Ø63mm
75	SEB75	1	for double wall pipe Ø63mm for secondary pipe Ø75mm
90	SEB90	1	for single wall pipe Ø90mm
110	SEB110	1	for single wall pipe Ø110mm
125	SEB125	1	for double wall pipe Ø90mm for secondary pipe Ø125mm

## ENTRY BOOT/TERMINATING FITTING INSTALLATION KIT

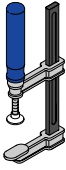
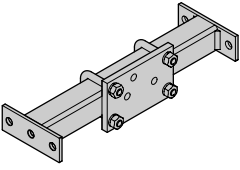
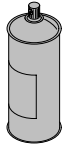

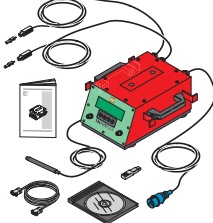


Ø (mm)	Code	Package (pcs)	Notes
25 - 180	SSET4	1	

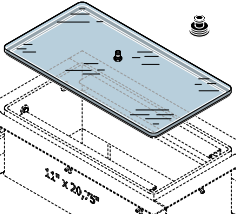

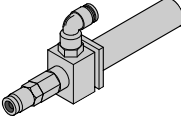
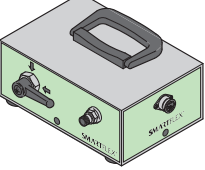
The kit includes:  
- nr. 1 template (STEM)  
- nr. 1 mandrel (SMAN)  
- nr. 3 hole sawS (STAZ70, STAZ98, STAZ140)



## Tools and equipment necessary for the assembly:

1		10 clamps  (Model SDSIK)
2		Stabilizer bars with proper nuts and bolts  (Model SBS)
3		Cleaning solvent or primer  (Model LID1)
4		Soft cloth
5		Welding unit  (Model SSEL)

## To perform the vacuum test:

6		Dispenser sump vacuum test lid  (Model SDSVTL)
7		Ø 6 Rilsan test tube  (Model STT6)
8		Ejector  (Model SVE)
9		Vacuum test unit  (Model SVTU)



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