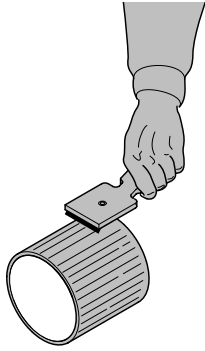


ASSEMBLY INSTRUCTIONS MODEL SMEDWR110125

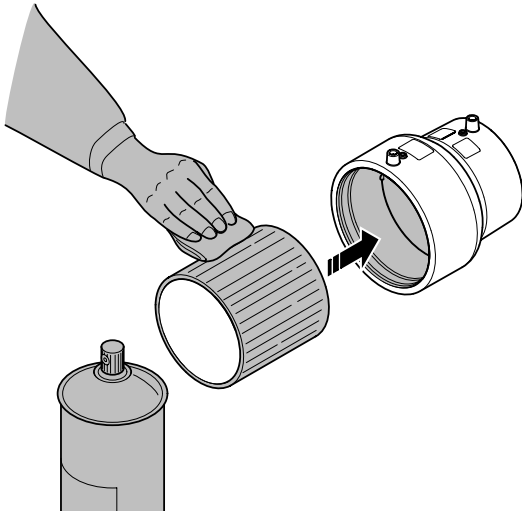


Fig.1



Scrape the secondary straight connector to its complete length.

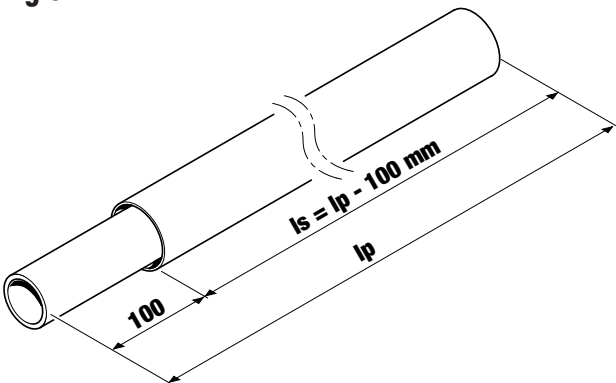
Fig.2



Clean one of the fitting spigots and the internal part of one of the reducer with a recommended cleaning solvent (Model LID1).

Insert the cleaned spigot of the secondary fitting inside the cleaned reducer to its complete stop. Before carrying out this step check and clearly mark the insertion length on the spigot of the secondary fitting.

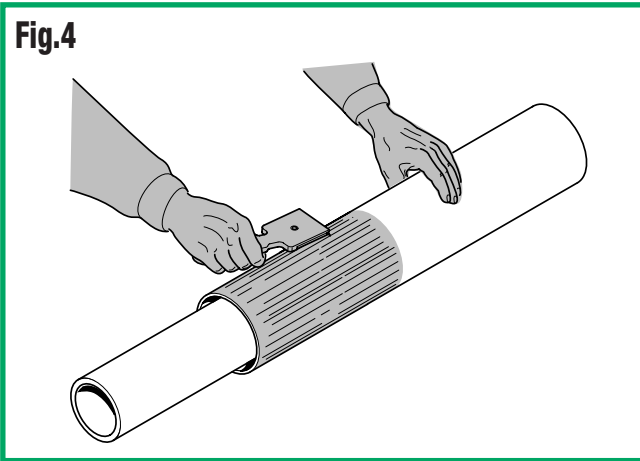
Fig.3



Cut the secondary pipe to a length equal to about 100 mm.

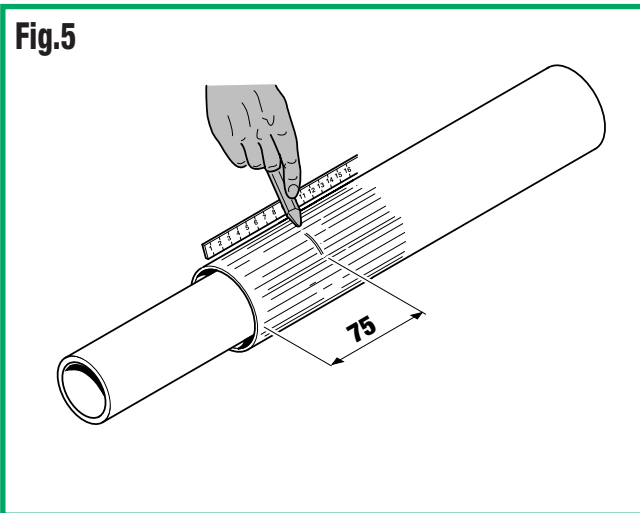


Fig.4



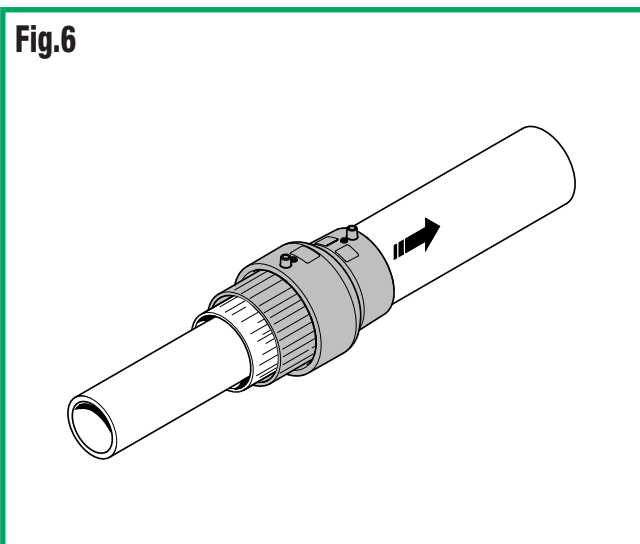
Scrape the secondary pipe to a length of 270mm (1,5 times the length of the reducer).

Fig.5



Mark the insertion length of the secondary pipe equal to about 75 mm.

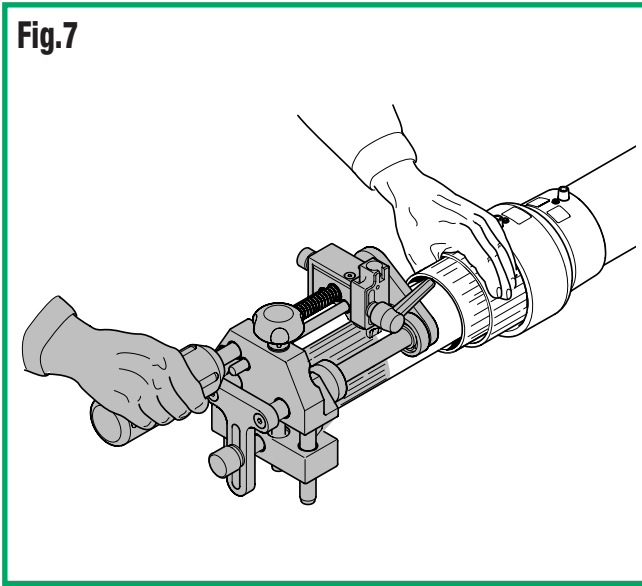
Fig.6



Slide the reducer that has just been assembled on the scraped secondary pipe.

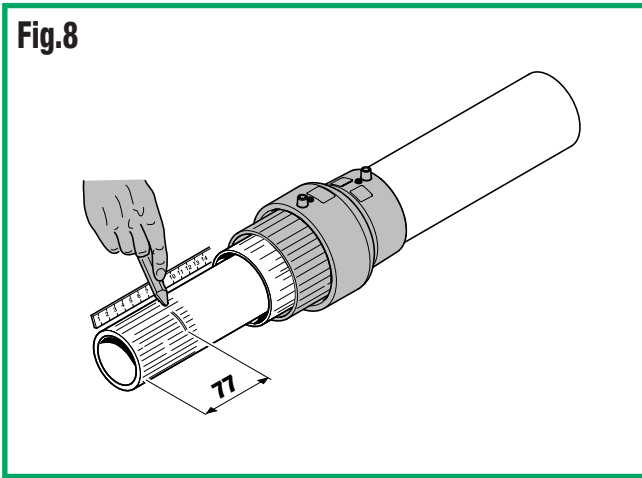


Fig.7



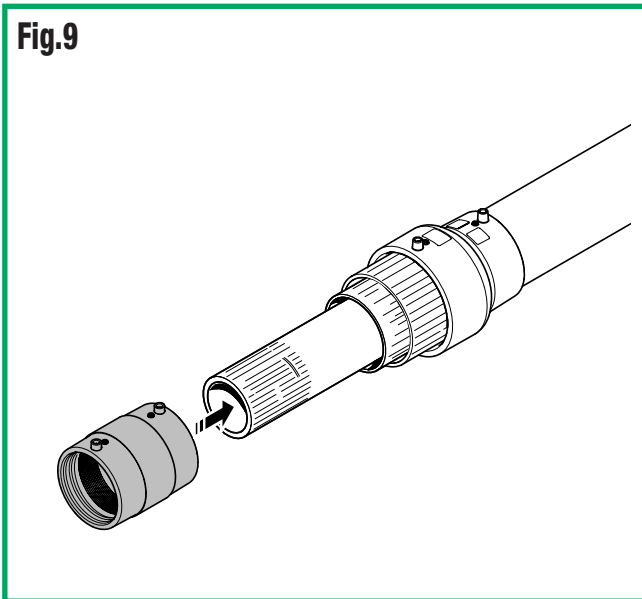
Let the primary pipe come out of the assembly as per figure 6, scrape it and clean it to a length equal to its insertion length inside the primary straight connector.

Fig.8



Mark the insertion length of the primary pipe inside the primary straight connector equal to about 77 mm.

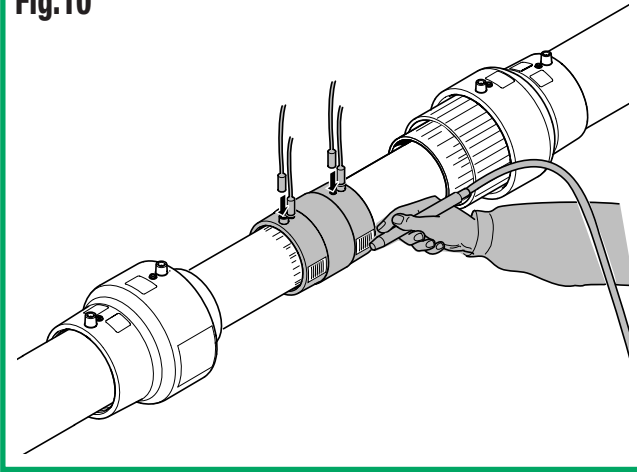
Fig.9



Insert the primary pipe inside the straight connector.



Fig.10



Cut the other secondary pipe to a length equal to about 100 mm. Scrape the secondary pipe that has just been cut to a length equal to 1 time the length of the reducer (about 180 mm). Mark the insertion length of the secondary pipe equal to about 75 mm.

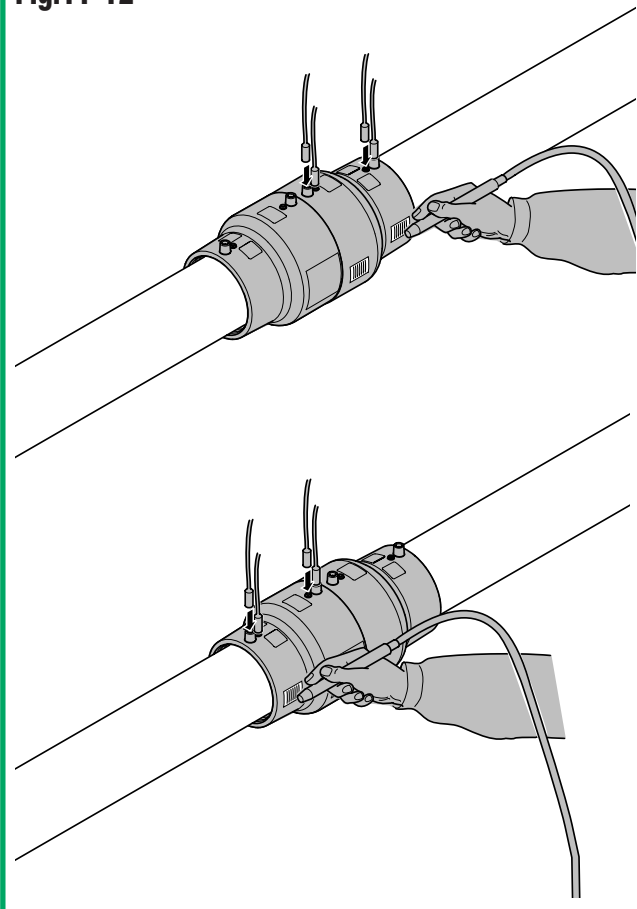
Repeat the steps as per figures 6, 7 and 8.

Weld the primary pipe by reading the barcode indicated on the straight connector.

When the weld is finished and after the fitting passed the hydraulic test, cut/tear off the brass parts of the welding pins so that the copper wire is not visible. Insulate the end of the welding pin by using insulating tape or paste. Place the covered wires so that they remain inside the secondary reducer.

N.B.: We recommend to insulate all cable lugs or metal ends that are visible inside the cavity or non-grounded.

Fig.11-12



Slide the pre-assembled spigot of the secondary fitting on the primary straight connector that has just been welded.

Clean the free spigot of the secondary straight connector and the two ends of the secondary pipe previously scraped with a recommended cleaning solvent (Model LID1).

Insert the second reducer on the free spigot of the secondary fitting.

Make sure that the two secondary pipes have been inserted to the insertion lengths previously marked.

Weld the secondary pipe.

N.B.: We strongly recommend to proceed with the welding of the whole primary line and carry out the pressure test to check the tightness of the joints before proceeding with the welding of the secondary line.