

1. Make sure that the pipe or spigot ends to be welded are lined up and straight.
2. Scrape the surface of the pipe or the spigot ends to remove the oxidized layer. Scrape the length equal to the depth of the electrofusion fitting +0.4" (1 cm). Mechanical scrapers are recommended. Hand scrapers can be used (refer to your Company procedures).
3. Clean the external surface of the pipe or spigot ends and the internal surface of the fitting with isopropanol and a soft wiping cotton cloth without any printing. Wait until the clean parts are completely dry and mark the insertion depth on both segments of pipe.
4. Insert the pipe or spigot ends in to the electrofusion sockets until they reach the stop and the white marked line.
IT IS ALSO POSSIBLE TO REMOVE THE STOPS INSIDE THE FITTING AND INSERT THE FIRST PIPE COMPLETELY, THEN ALIGN THE TWO PIPE SECTIONS LEAVING ONLY A SMALL GAP BETWEEN THE PIPE ENDS AND SLIDE THE FITTING UNTIL IT IS CENTERED BETWEEN THE TWO LINES MARKED ON THE PIPE.
5. ALWAYS USE THE ALIGNERS (ACCORDING TO THE STANDARDS).
Avoid any stress in the welding area during the welding operation and the cooling time.
6. Connect the welding cables to the fitting connectors, scan the barcode with the barcode scanner or enter the welding parameters manually.
ALWAYS CHECK THE WELDING PARAMETERS ON THE DISPLAY
7. At the end of the welding cycle, disconnect the cables and wait for the cooling time indicated on the barcode (check Table 2).
8. When the cooling time is over, remove the aligners and start the pressure test on the system by the pressure test unit (follow Table 2 and your company procedures).

ATTENTION:

- YOU CAN WELD WITH POLYVALENT WELDING UNIT IN AUTOMATIC MODE (WITH BARCODE SCANNER) OR IN MANUAL MODE.
- IN CASE OF AUTOMATIC WELDING, ALWAYS CHECK TIME AND VOLTAGE PARAMETERS ON THE DISPLAY AFTER BARCODE SCAN.
- IN CASE OF MANUAL WELDING, USE TIME AND VOLTAGE PARAMETERS INDICATED ON THE BARCODE (Fig.1).
- IF THE WELDING UNIT DOES NOT PERFORM WELDING TIME COMPENSATION ACCORDING TO AMBIENT TEMPERATURE, USE THE PARAMETERS ON THE LABEL AFFIXED ON THE BAG (Fig.2).
- KEEP AT A SAFE DISTANCE DURING WELDING.

RECCOMENDATIONS FOR THEIR DISPOSAL:

POLYETHYLENE USED FOR THIS ACCESSORY IS RECYCLABLE: DISPOSE THROUGH AUTHORISED CENTRES. DO NOT DISPERSE WRAPPING AND PACKAGING OF THE PRODUCT, RECYCLE THROUGH COLLECTION.

TABLE 1

COOLING TIME	
INCH	MINUTES
½" to 1 ½"	10
2" to 2 ½"	15
3" to 6"	20

TABLE 2

RECOMMENDED WAITING TIME BEFORE PRESSURE TEST START		
INCH	MINUTES	
	P < 87 PSI	P < 348 PSI
½" to 1 ½"	20 +COOLING TIME	60 +COOLING TIME
2" to 2 ½"	30 +COOLING TIME	90 +COOLING TIME
3" to 6"	40 +COOLING TIME	120 +COOLING TIME

FIG.1 WELDING PARAMETERS



XXX00: FITTING CODE
00v: VOLTAGE
00s: WELDING TIME
c.t. 00 m: COOLING TIME

FIG.2 MANUAL WELDING PARAMETERS

