

1. Make sure that the extremities to be welded are straight.
2. Scrape the surface of the pipe or of the spigot of the fitting to remove the oxidized PE layer. Scrape the whole length of the pipe equal to the depth of the electrofusion fitting plus 0.4".
3. Clean the external surface of the pipe or spigot ends and the internal surface of the coupler with the appropriate cleaning solvent ( >90% Isopropyl Alcohol or Pure Acetone) and a soft wiping cloth. Wait for the clean parts to dry completely.
4. Insert the extremities into the coupler. Make sure that they are perfectly lined up and they are in the center of the fitting.
5. Check that the GAP between the coupler and the pipe or spigot end is not greater than 1/16" at any point of the circumference. On the contrary, effect the pre-heating (yellow bar code - figure 3), repeating it maximum three times to reduce the GAP between the pipe and the fitting. Check the GAP again at the end of the pre-heating. If it is still superior to 1/16", contact our technicians!
6. If the temperature is less than 32°F you must always preheat the fitting.
7. Avoid any stress on the welding area during the welding cycle and the cooling phase. Use aligners.
8. Connect the welding cables to the connectors of the fittings, read the bar code (figure 4) with the optical pen or insert the welding parameters manually. Check the welding parameters.
9. Attention: only if you find double barcode THE WELDING PROCESS ALWAYS MUST BE PERFORMED USING FIRST WELDING PARAMETERS AND IMMEDIATELY AFTER WITH SECOND WELDING PARAMETERS (figure 5).
10. At the end of the welding cycle, respect the cooling time indicated on the bar code.
11. After the completion of the welding cycle, you can put in pressure the network. When the cooling time is over (**cooling time, table 1**), remove the aligner and start to pressurize the system (**time for pressurizing the network, table 2**).

**FUSION INDICATOR**

THERE ARE TWO DIFFERENT TYPES OF FUSION INDICATORS:  
 THE **MECHANICAL FUSION INDICATOR** IS WHITE OR GREY. IT COMES OUT PERMANENTLY FROM THE OUTER DIAMETER OF THE COUPLER.  
 DURING THE FUNCTIONING OF **THE THERMAL INDICATOR**, THE SMALL WHITE SQUARE ON THE BLUE STICKER NEXT TO THE FUSION CONNECTORS TURNS GREY.  
 THE FUNCTIONING OF THE FUSION INDICATOR INDICATES ONLY A THERMAL PROCESS, BUT DOES NOT GUARANTEE THE QUALITY OF THE WELD.

**ATTENTION: FOR  $\varnothing \geq 28''$   
 YOU SHALL USE TWO WELDING UNITS: ONE FOR THE FIRST WELDING AND ANOTHER ONE FOR THE SECOND 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.

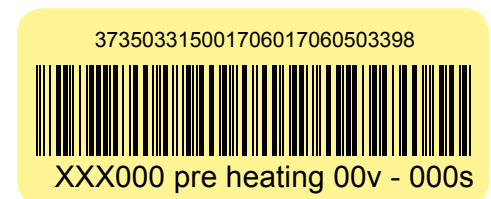
**TABLE 1**

COOLING TIME	
$\varnothing$	MINUTES
8"-16"	40
18"-32"	60

**TABLE 2**

PRESSURE TEST DURATION		
$\varnothing$	MINUTES	
	P < 87 PSI	P < 348 PSI
8"-16"	60 +COOLING TIME	180 +COOLING TIME
18"-32"	80 +COOLING TIME	200 +COOLING TIME

**FIG.3 PRE HEATING BAR CODE**



**FIG.4 WELDING PARAMETERS**



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

**FIG.5 WELDING PARAMETERS**

