

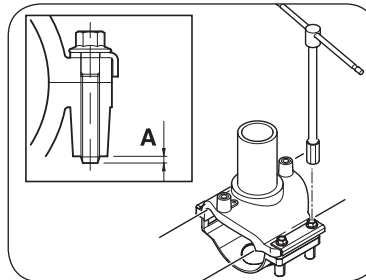
# ELECTROFUSION BRANCH SADDLE INSTALLATION

1. Measure the length of the fitting and mark the welding area with a marker. Scrape the pipe surface carefully using a scraper.
2. After scraping, remove dirt and grease from the welding area of the pipe and the inside of the saddle, using an appropriate cleaning agent. Wait until the clean parts are completely dry.
3. Apply the saddle onto the pipe watching out not to dirty the previously cleaned surfaces.

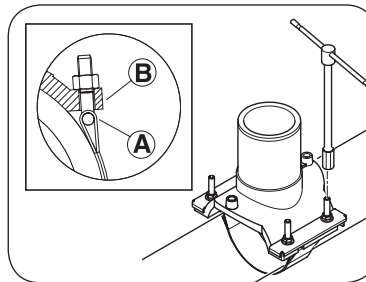


4. Fasten the saddle on the pipe using the

**QUICK-COUPLING PLASTIC UNDERCLAMP:** hook up the square holes of the underclamp to the teeth of the upper part. Line up the metal spacer and use a wrench to tighten the two screws until they are in position **A** in the lower part (feel the screws sticking out the bottom).



**FLEXIBLE BELT:** use a wrench to tighten the four screw nuts until the U-bolt **A** and the top part of saddle **B** come into tight contact.



5. Connect the two cables of the electrofusion machine to the connectors of the branch saddle, scan the barcode with the barcode scanner or enter the welding parameters manually. After completing the welding process, verify that no material has leaked out of the joint between the pipe and the fitting and wait for the completion of the cooling time indicated on the barcode.



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6. For automatic welding units, always check the welding parameters on the barcode (**SEE FIG.5**). For manual welding please use the time and voltage indicated on the barcode. If the welding unit does not perform welding time compensation according to ambient temperature, use the parameters in the label affixed on the bag (**SEE FIG.6**).

After completing the welding process, verify that no material has leaked out of the joint between the pipe and the fitting. Wait for the cooling time as indicated on the fitting barcode before rough handling.

7. At the end of the cooling time it is possible to start the pressure test with the Pressure Sensor. In the following table (**TABLE 1**) you find the recommended waiting time in MINUTES before starting the test.

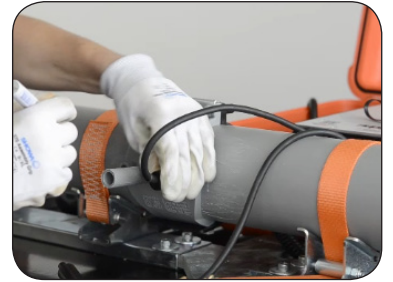
Table 1. WAITING TIME BEFORE PRESSURE TEST START		
∅	P < 87 psi	P < 348 psi
inch.	6 BAR	24 BAR
1"¼ to 2"	cooling time + 20 minutes	cooling time + 30 minutes
2"½ to 12"	cooling time + 20 minutes	cooling time + 60 minutes

8. Proceed now with the perforation of the pipe through a specific cutter (drill bit or hole saw).

**NEVER PERFORATE THE PIPE BEFORE COMPLETING THE WELDING PROCESS**

9. Connect the service line with the spigot of the outlet, following the installation instructions for that specific fitting. The underclamp may be removed or left permanently.

- **ALWAYS CHECK THE WELDING PARAMETERS.**
- **CHECK THAT THE DIAMETER OF THE CUTTER IS COMPATIBLE WITH THE INSIDE DIAMETER OF THE SPIGOT.**
- **AVOID ANY DAMAGE TO THE SPIGOT DURING THE PERFORATION.**
- **KEEP AT A SAFE DISTANCE DURING WELDING.**
- **THE COMPANY IS NOT RESPONSIBLE FOR ANY DAMAGE TO PERSONS OR PROPERTY IF SAFETY RULES ARE NOT OBSERVED.**



**FIG.5 WELDING PARAMETERS**



**27NCOL...** : FITTING CODE  
**00v:** VOLTAGE  
**000s:** WELDING TIME  
**c.t. 00 m:** COOLING TIME

**FIG.6 MANUAL WELDING PARAMETERS**



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



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