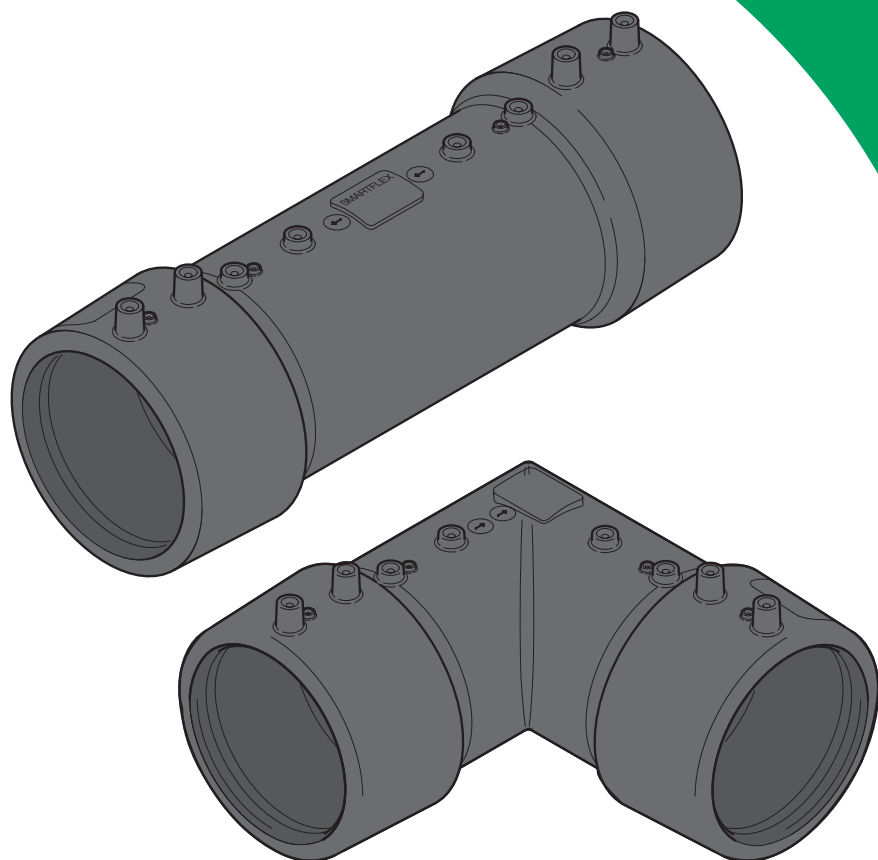
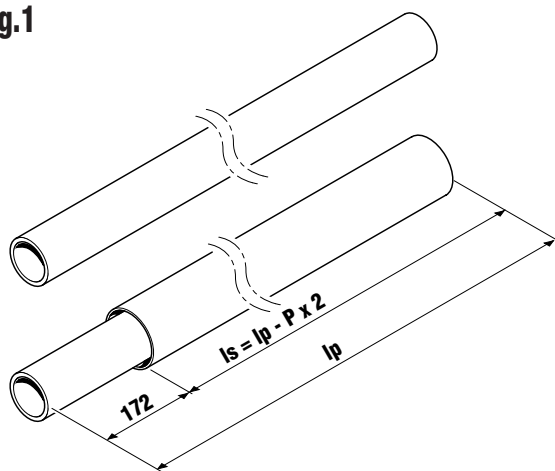


SMARTFLEX™

Assembly instructions of coaxial double wall fittings ø90

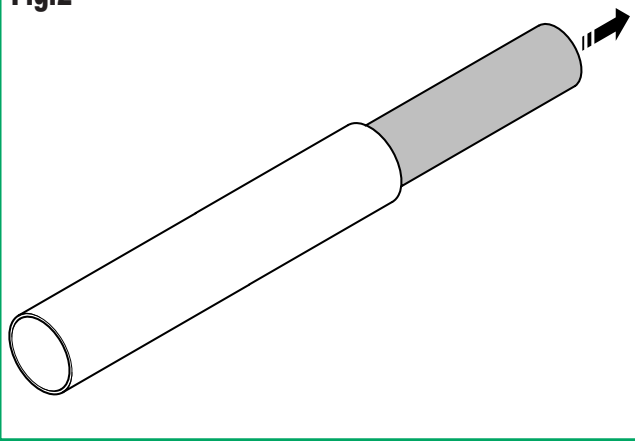


Models
SMEDW90
SCEDW90
SGEDW90
STEDW90

Fig.1

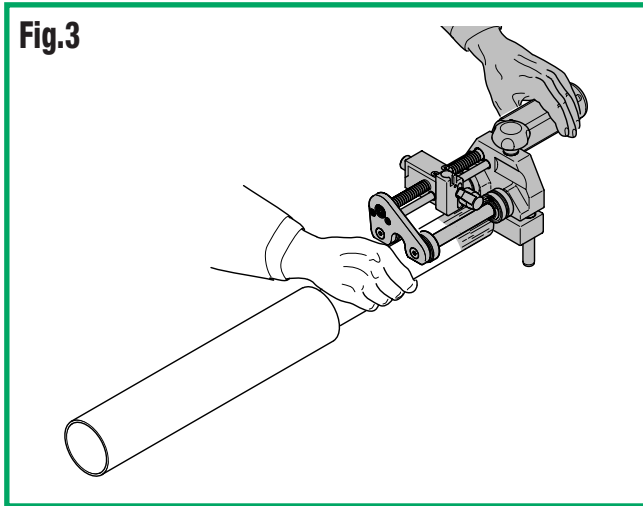
Cut the two pipes perpendicularly using the appropriate pipe cutter (Model SCUT or Model SCUTDW) to the correct length for the installation, then remove a further length equal to $P \times 2$ (as listed in the table) from the secondary pipe using the appropriate pipe cutter (Model SCUT or Model SCUTDW).

ITEM	Sx		S		P (scrape 10 mm more)	
	mm	in	mm	in	mm	in
SMEDW90	86	3,35"	96	3,74"	77	3,03"
SCEDW90	86	3,35"	96	3,74"	76	2,99"
SGEDW90	86	3,35"	96	3,74"	76	2,99"
STEDW90	86	3,35"	96	3,74"	77	3,03"

Fig.2

Separate the primary pipe from the secondary pipe.

Fig.3

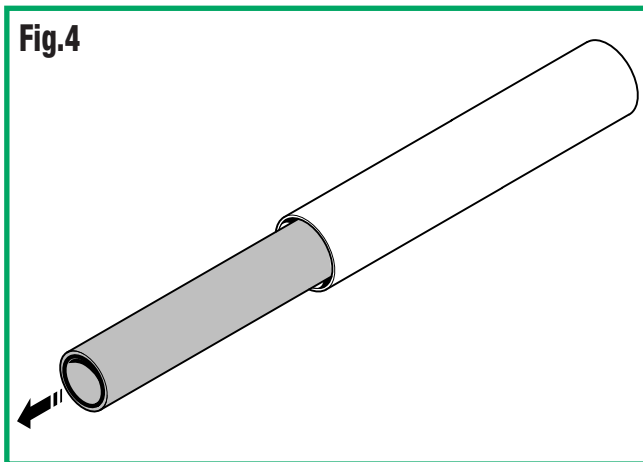


Scrape the primary pipe to a length equal to P using the universal scraper (Model RAT0).

Note: Never use under any circumstances sand paper, emery cloth, files, knives or sharp objects.

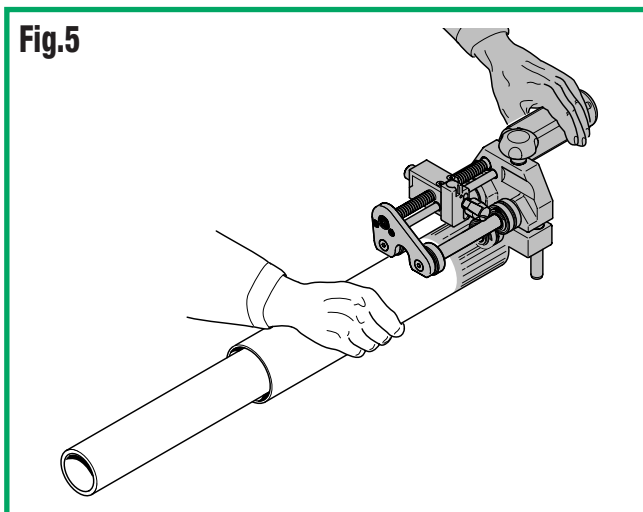
Note: For a correct installation of the SuperSmartflex pipe, ensure to **SCRAPE AND COMPLETELY REMOVE THE GREEN OUTER LAYER** from the primary pipe until the black polyethylene layer is clearly visible on the outside of the pipe. Remove the outer layer completely, including the tie layer, until you reach the black HDPE layer. The omission of this step can cause a weld to fail.

Fig.4



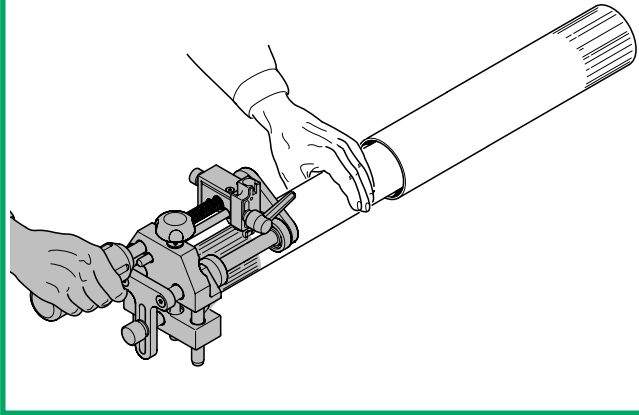
Separate the primary pipe from the secondary pipe.

Fig.5



Scrape the secondary pipe to a length equal to S using the universal scraper (Model RAT0).

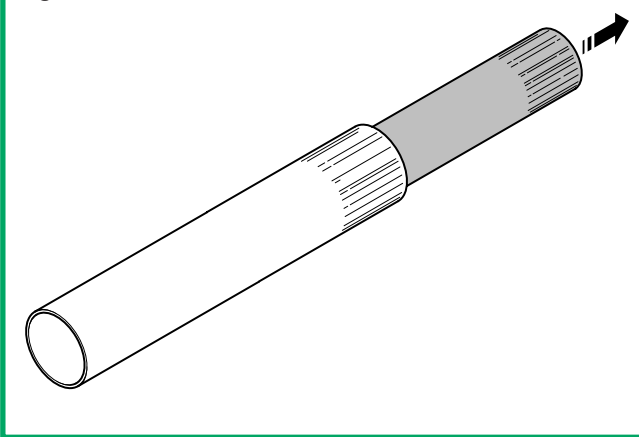
Fig.6



Scrape the other end of the primary pipe to a length equal to P using the universal scraper (Model RAT0).

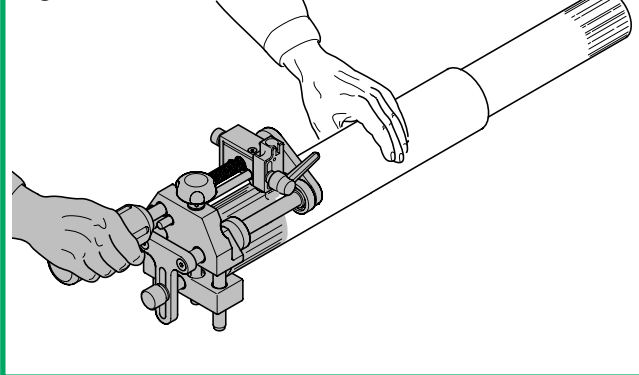
Note: For a correct installation of the SuperSmartflex pipe, ensure to **SCRAPE AND COMPLETELY REMOVE THE GREEN OUTER LAYER** from the primary pipe until the black polyethylene layer is clearly visible on the outside of the pipe. Remove the outer layer completely, including the tie layer, until you reach the black HDPE layer. The omission of this step can cause a weld to fail.

Fig.7



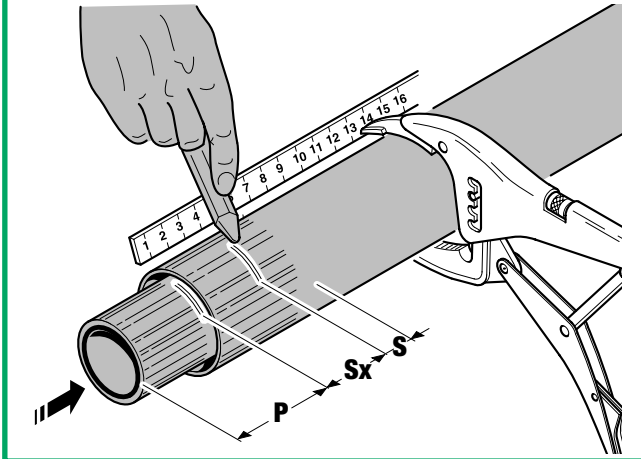
Separate the primary pipe from the secondary pipe.

Fig.8



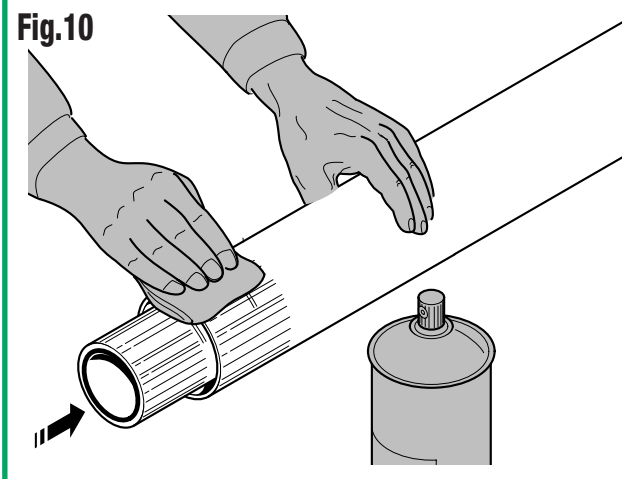
Scrape the secondary pipe to a length equal to S using the universal scraper (Model RAT0).

Fig.9



Use the appropriate marker (Model MARK) to clearly indicate the insertion lengths on the surface of the primary and secondary pipes.

Fig.10

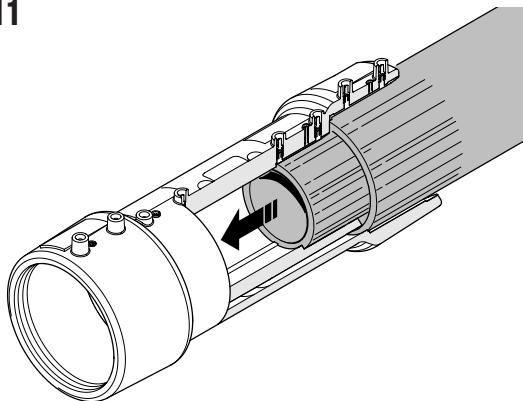


Clean the ends of the primary and secondary pipes, the fitting spigot and the socket with a clean cloth soaked with a recommended cleaning solvent (Model LID1).

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

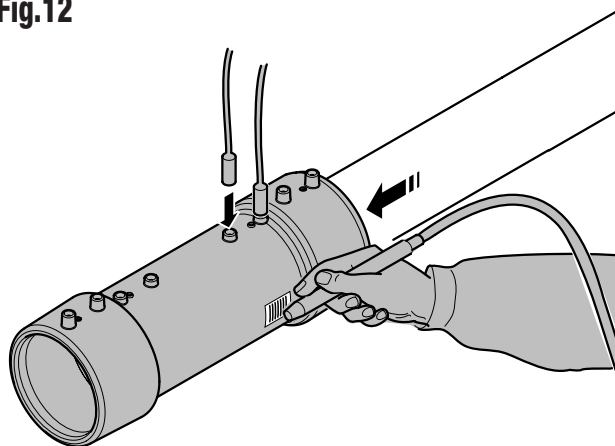
Note: When possible, always use the pipe aligner (Model ALL225/4) to eliminate stress and/or tension during the welding process.

Fig.11



Insert the double wall pipe into the fitting, ensuring that the marked insertion depth is reached or until it comes to a stop against the internal stop inside the fitting.

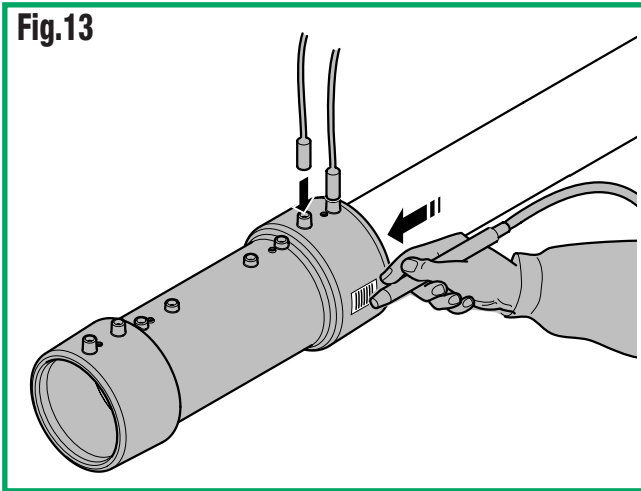
Fig.12



You can now commence the welding process of the primary pipe following the instructions shown on the welding unit's display.

NOW WE RECOMMEND YOU TO PERFORM THE PRESSURE TEST ON THE PRIMARY LINE.
The test can be performed only after the cooling down process has been completed.

Fig.13

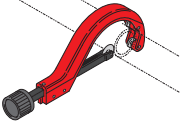
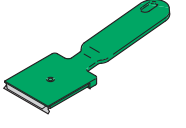
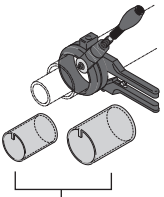
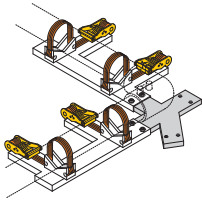
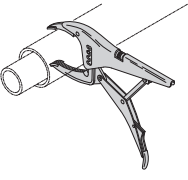
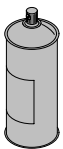
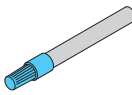

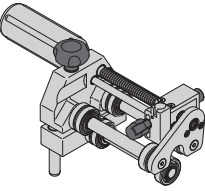
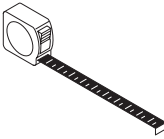
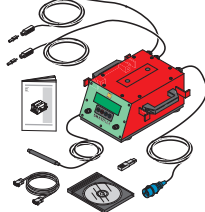


You can now commence the welding process of the secondary pipe following the instructions shown on the welding unit's display.

Recommended tools and equipment necessary

NOW WE RECOMMENDED YOU TO PERFORM THE PRESSURE TEST ON THE SECONDARY LINE.
The test can be performed only after the cooling down process has been completed.

for the assembly:

1 	Pipe cutter (Model SCUT) (Model SCUTDW)	5 	Manual scraper (Model RAM1)
 STP	Protective sleeves (Model STP)	6 	Aligner (optional) (Model ALL225/4)
2 	Pliers for double wall pipe (Model SPLIDW)	7 	Cleaning solvent or primer (Model LID1)
3 	Marker (Model MARK)	8 	Soft cloth
4 	Universal scraper (Model RAT0)	9 	Measuring tape
		10 	Welding unit (Model SSEL8404)

This document is property of NUPIGECO S.p.a, no part of it may be copied or reproduced, without prior written consent from NUPIGECO. NUPIGECO S.p.a reserves the right to make the opportune technical modifications without notice. NUPIGECO S.p.a doesn't guarantee the correct operation of the system in case the information contained in this document are not followed.

NUPIGECO S.p.A.

Via dell'Artigianato, 13 - 40023 Castel Guelfo di Bologna - Italy

Phone (39) 0331 344211 - Fax (39) 0542 670851

E-Mail: info@nupigeco.com - Web Site: www.nupigeco.com

NUPI Americas, Inc.

1511 Superior Way, Houston, TX 77039

Phone (281) 590 4471 - Fax (281) 590 5268

E-Mail: info@nupiamericas.com - Web Site: www.nupiamericas.com