

- 1** Mark the welding area on the main pipe with a wax crayon or marker (00MARK).
- 2** Scrape carefully the surface of the pipe and the spigot of the outlet with a hand scraper to remove the oxidized PE layer.
- 3** Clean the external surface of the pipe, the spigot of the outlet and the welding area of the saddle with isopropanol and a soft wiping cotton cloth without any printing. Wait until the clean parts are completely dry; mark the insertion depth on the spigot of the outlet (00LID1).
- 4** Apply the branch on to the pipe watching out not to contaminate the previously cleaned surfaces.
- 5** Fasten the tapping tee on the pipe using the integrated underclamp. Depending on models, there are three types of underclamp:

TAPPING TEES WITH RAPID JOINT: hook the square holes of the underclamp to the teeth on 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 (see fig.1).

TAPPING TEE WITH BELT: Use a wrench to tighten the four screw nuts until the threaded connector A and the top part of tapping tee B meet (see fig.2).

TAPPING TEE WITH PLASTIC UNDERCLAMP: Use a wrench to tighten the four screw nuts until top and bottom part A and B come into tight contact (see fig.3).

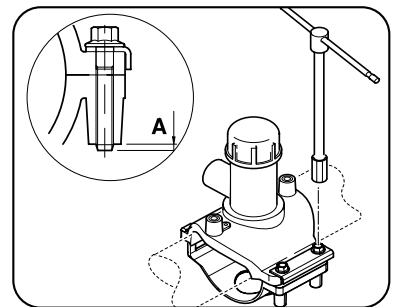
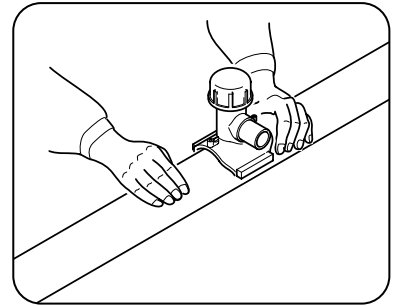
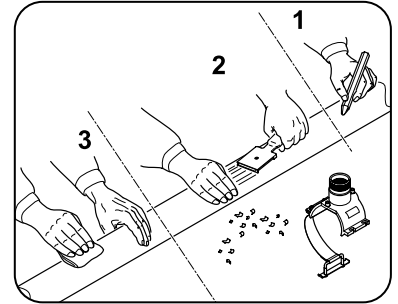


FIG.1

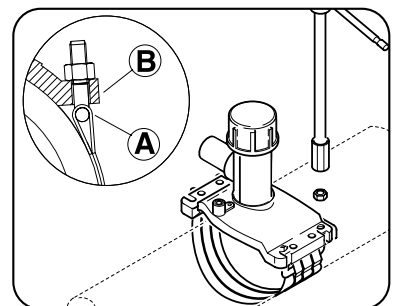


FIG. 2

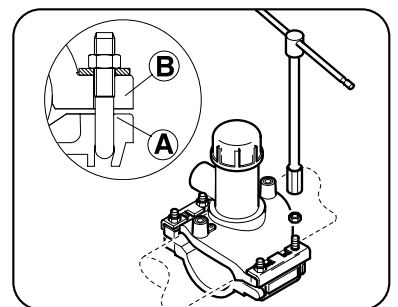


FIG.3

6 Connect the service line at the spigot of the outlet, following the installation instructions for that specific fitting. *(NOTE: this step may be delayed until after the tee is fused to the main and the rough handling cooling time has been met.)*

7 Connect the two electric pins to the welding connectors of the saddle. Scan the bar code (figure 4) with the bar code scanner or enter the welding parameters manually. **ALWAYS CHECK THE WELDING PARAMETERS.** 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 cooling time (20 minutes).



- **YOU CAN WELD WITH POLYVALENT WELDING UNIT IN AUTOMATIC MODE (WITH BARCODE SCANNER - See fig.5) OR IN MANUAL MODE (see fig.6).**
- **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.**
- **IF THE WELDING UNIT DOES NOT PERFORM WELDING TIME COMPENSATION ACCORDING TO AMBIENT TEMPERATURE, USE THE PARAMETERS ON THE LABEL AFFIXED ON THE BAG.**
- **KEEP AT A SAFE DISTANCE DURING WELDING.**

8 After the cooling time it's possible to do the pressure test with the Pressure Sensor. In the following table you find the minum time in MINUTES to start the test or refer to your Company procedures.

RECOMMENDED		
WAITING TIME BEFORE PRESSURE TEST START		
Dn pipe (inch)	P =< 87 PSI	P=< 348 PSI
ø 1"1/4 - 2"	cooling + 20'	cooling + 30'
ø 2" 1/2 - 12"	cooling + 20'	cooling + 60'

FOR GAS PIPELINES:

The Max Operating Pressure for this fitting is 145 PSI.

The Max Test Pressure for this fitting is 217psi for 1 hour.

DO NOT EXCEED MAX OPERATING OR MAX TEST PRESSURES.

9 When the pressure test is over, remove the top cap and start the perforation of the pipe using the cutter installed in the tapping tee; the cutter is disposable and is designed to keep the coupon inside. Use the appropriate tool to screw down manually the cutter (turn clockwise) until the pipe is drilled, then move back the cutter to the upper position (turn counter-clockwise). Replace the cap and tighten down to the stop. (You can tighten by hand or with a type 00CHIAVExx).

10 You can either leave the underclamp on the saddle or remove it.



- **NEVER PERFORATE THE PIPE BEFORE COMPLETING THE WELDING PROCESS.**
- **KEEP THE BODY CLEAR OF THE FITTING DURING THIS OPERATION.**
- **DO NOT USE AUTOMATIC DRILLS.**
- **DO NOT REMOVE THE UPPER STOPPER**

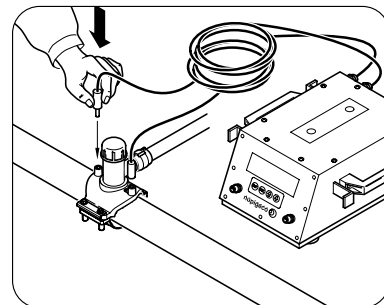


FIG.4

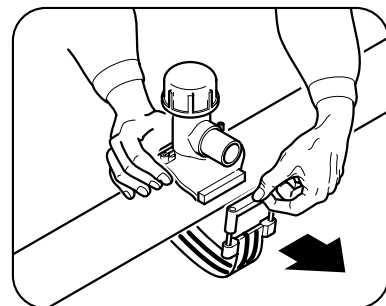
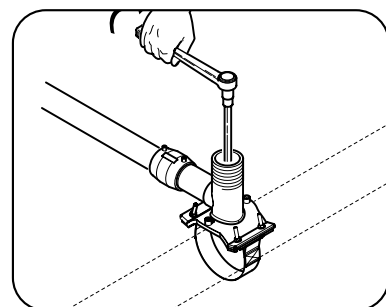


XXX00: FITTING CODE
00v: TENSION
00s: WELDING TIME
c.t. 00 m: COOLING TIME

FIG.5: WELDING PARAMETERS



FIG.6: MANUAL WELDING PARAMETERS



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

NUPI Americas, Inc. - 314 Commerce Parkway, Early Branch, SC 29916 - Tel: +1 803-398-3579 - Fax: +1 803-398-3639
 Web site: www.nupinet.com - Email: info@nupiamericas.com

