

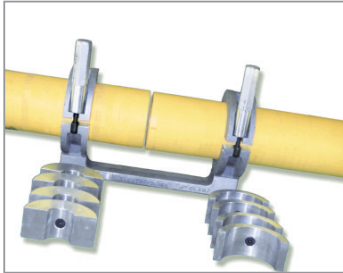


⚠ THE INSTALLATION OF THE EIBFRS NEEDS TO BE DONE UNDER THE FLOW OF GAS. *If this can not be guaranteed (end of line, branch to single users, etc.) the pressure must be reduced to a maximum of 7 PSI.*

POLYETHYLENE GRADE	PRESSURE*
PE4710 PE100 - SDR11/9/7	60 psi
PE3408 PE80 - SDR11/9/7	60 psi

* maximum pressure during the welding

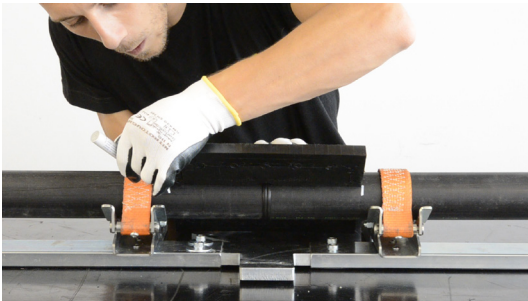
BEFORE STARTING: The fusion process, fit the alignment clamp (12ECLAMP) and check if it is firmly secured on either side of the fitting 'BFRS'.



BEFORE STARTING: If the BFRS is used on an area of pipe that has already been squeezed, you must first re-round the pipe before installing the fitting.

⚠ Max angle between pipes 1.5° - Max misalignment 0.08"

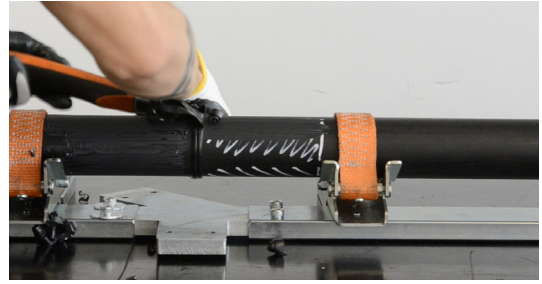
1. Place a half-shell on the pipe across the butt-fusion to be repaired, keeping the bead in the center, then mark the size on pipe surface.



2. Mark the welding area with a marker all along pipe circumference.



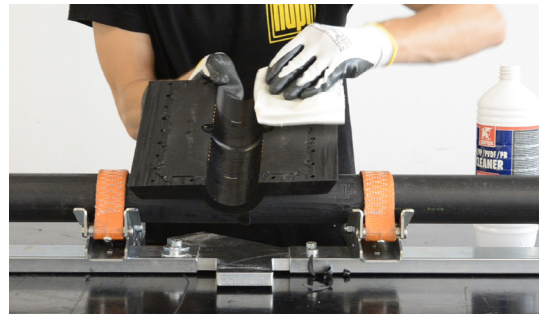
3. Scrape with a manual scraper the part of the pipe where the repair sleeve will be welded without removing the bead.



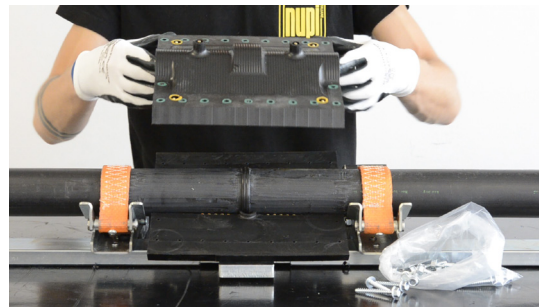
4. Clean the pipe surface with isopropyl alcohol (minimum concentration 91%).



5. Clean also the inner surface of the fitting with the same isopropyl alcohol.

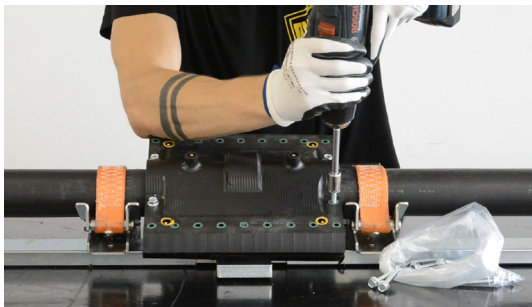


6. Install the two half shells on the pipe, keeping the bead in the center.

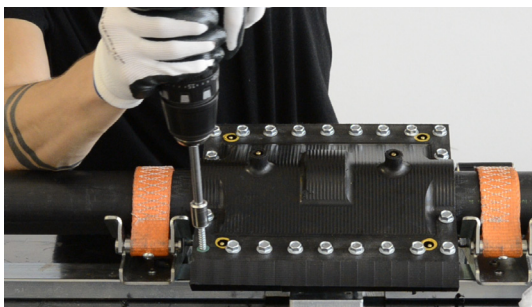




- 7.** Tighten the two shells together using a screw driver. Insert the 22 self tapping screws into the holes marked in green, starting from the 4 central holes.



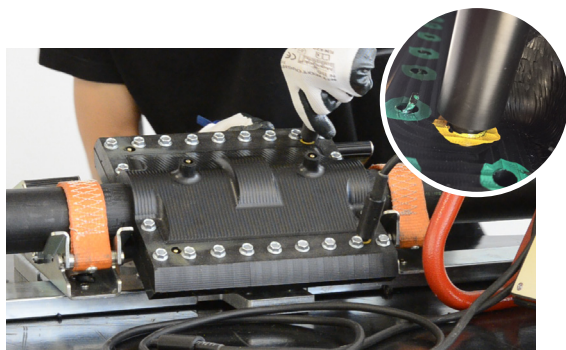
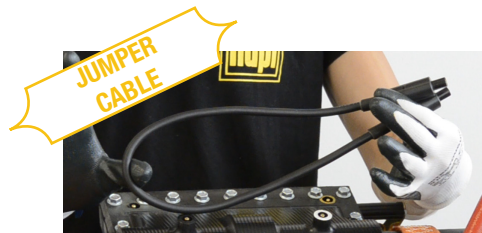
- 8.** Then proceed with the remaining 19 screws.



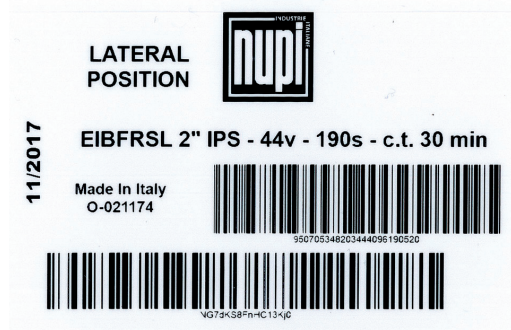
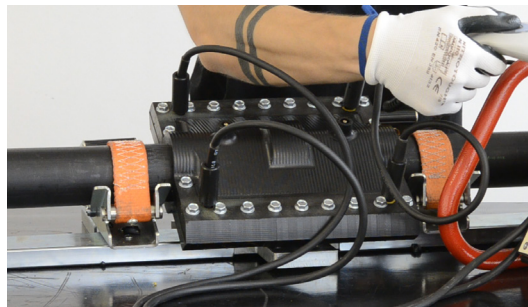
- 9.** In any case before starting the fusion process, fit the alignment clamp and check if it is firmly secured on either side of the 'BFRS'.

FIRST WELDING - LATERAL PARTS

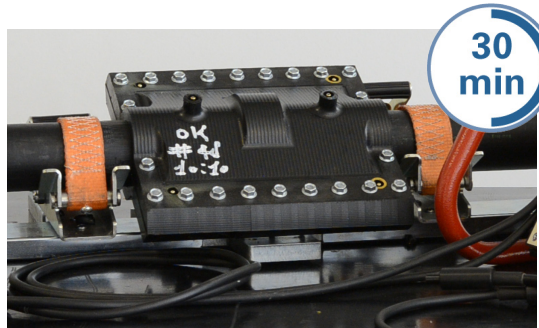
- 10.** Using the jumper cable connect the two pins marked with yellow of the lateral welding zones.



- 11.** Connect the welding unit with the other two pins of the lateral zone. Scan the specific barcode of the LATERAL ZONES and start the welding.



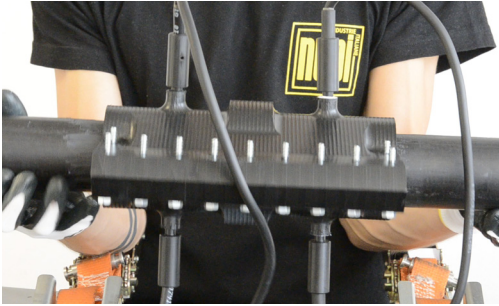
- 12.** At the end of the welding, remove the cables, mark weld number and time on the body of the fitting and wait for 30 minutes to allow the welded parts to cool down.



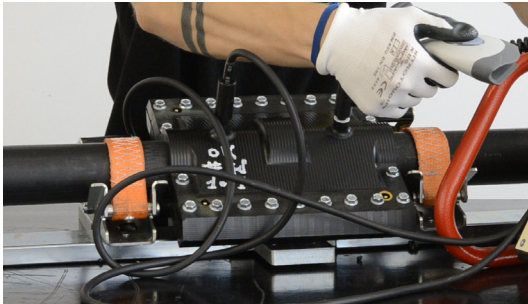
SECOND WELDING - BODY

- 13.** Using the jumper cable connect the two white pins on either side of the central zones. Connect the cables of the welding unit to the other pins on either side of the central zones.

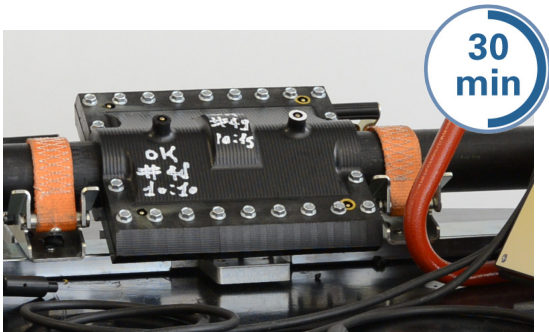




- 14.** Scan the specific barcode of the CENTRAL PART and start the welding.



- 15.** At the end of the second welding, mark again weld number and time on the body of the fitting and wait 30 minutes to allow the welded parts to cool down.



THIRD WELDING - LATERAL PARTS

- 16.** Restart with a new welding of the lateral zone repeating to the point of the first welding (10, 11).

- 17.** At the end of the last welding, mark again the weld number and time on the body of the fitting and wait for 30 minutes before removing the alignment clamp.

