

⚠ 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.*

BEFORE STARTING: Before starting the fusion process, fit the alignment clamp 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° (+0.2°)

Max misalignment 0.08" (+0.005)

Min Pipe OD after peeling at fusion zone: 12.73" (-0.005)

1. Identify the butt fusion area to be repaired.



2. Identify the welding area with a marker.



3. Scrape with a rotary 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%).



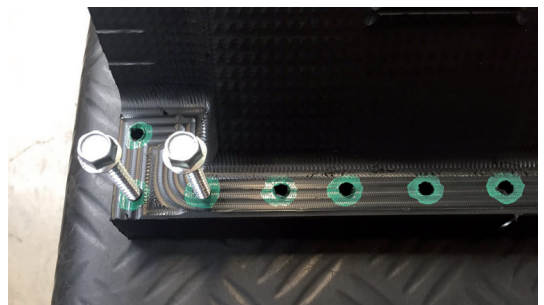
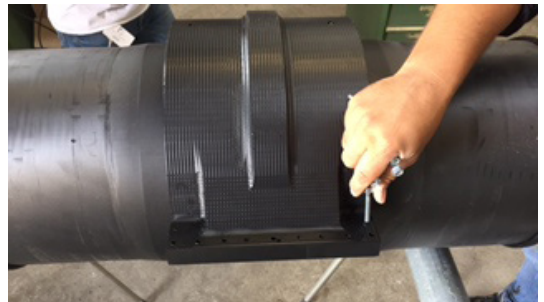
5. Clean the inner surface of the fitting with isopropyl alcohol (minimum concentration 91%).



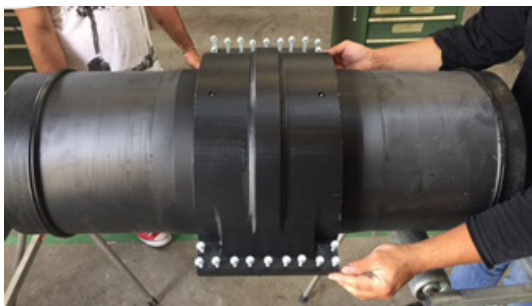
6. Install the two half shells on the pipe. Keeping the bead in the center.



7. Insert the 22 self tapping screws into the holes marked in green.



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8. Using a screw driver tight the two shell together.



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.

10. Using the jumper cable connect the two pins marked with yellow of the lateral welding zone.

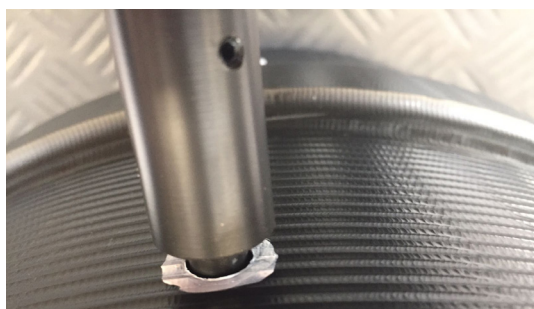


11. Connect the welding unit with the other two pins of the lateral zones. Scan the barcode of the lateral zones and start the welding.



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12. Immediately after completing the weld at point 11 (or within max 10 minutes) connect the two white pins of the central zones by using the jumper cables, and connect the welding machine to the other 2 pins of the central zones.



13. Scan the barcode of the central part and start the welding.



14. Wait 30 minutes to allow the welded parts to cool down.

15. The alignment clamp can be removed 30 minutes after the last fusion is completed.