

PE Electrofusion Instructions for Use

By using the preheating barcode, a larger annular gap (> 0.04 inch, max. 0.1 inch) can be compensated between coupling and pipe. The preheating technique can be used on couplings with PE pipes SDR 9 – SDR 17.6:

Coupling 8" – 18"	option, if gap is larger than 0.04 inch
Coupling 20" – 30"	requirement



Steps for Preheating Barcode:

1. Preparation of the area to be connected according to the assembly instructions.
2. Center the coupler on the pipe so that the annular gap is about equal all the way around.
3. Close annular gap with tape in order to avoid loss of heat.
4. Close open pipe ends (chimney effect).
5. Start preheating process (yellow barcode).
6. On completion of the preheating cycle, allow 10 minutes to warm through.
7. Check gap. If it still exists, preheat again.
8. When the gap has closed sufficiently, start fusion process (white barcode).
9. Note cooling period (refer to cooling time card included with Genesis F3). Fusion and cooling times of the two fusion zones may overlap.

For further information, please refer to IPEX assembly instructions for 16 IPS and larger couplings.

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Steps for Re-rounding Device:

1. Use a ruler to establish the maximum and minimum outside diameter, measuring on the outside face of the pipe. Mark the maximum outside diameter dimension "A" and the minimum outside diameter dimension "B".
2. Prepare the pipe end per the electrofusion coupling installation instructions.
3. Install the appropriate sized re-round device centered on the dimension "A" axis. Position the device squarely on the pipe. Allow enough room for the coupling to be installed on the pipe. In some cases where the pipe is severely out of round, it may be necessary to place the re-round device near the pipe end in order to start the coupling on the pipe. Once the coupling is started, the device can be moved further back onto the pipe. In those cases insure that the device is clean and free of debris to avoid contaminating the electrofusion.
4. Apply force by tightening the jack screw sufficient to cause the pipe to re-round.
5. Check with a ruler to insure that dimensions "A" and "B" are the same value. When this is accomplished the pipe will be rounded to accomplish an acceptable electrofusion.
6. Leave the re-round device in place until the electrofusion is completed and cooled.

