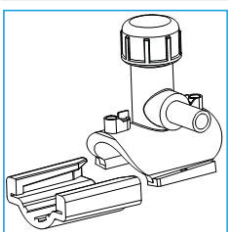


IPEX ELECTROFUSION TAPPING TEES – PE4710

INSTALLATION PROCEDURE

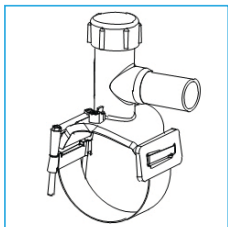
1. Using appropriate scraping tools, all areas of pipe and spigot part to be fused must be scraped free of pipe surface oxidation. Always scrape a slightly larger area of the pipe and spigot part to be fused.
2. Clean the fusion areas of pipe and fitting using a clean cloth impregnated with 96% or greater isopropyl alcohol to make sure they are free of contaminants (grease, mud, humidity, soilage, etc).
3. Position the fitting in accordance with clamping device provided.
4. See and follow electrofusion procedure.
5. Before pressure testing using the tapping tool **retract the cutter blade completely to the stop at top of chimney and give 1/4 turn more to give tightness.** Replace cap and hand tighten only.
6. Tap main after pressure testing using tapping tool then **retract cutter blade back to the stop at top of chimney and give 1/4 turn to give tightness.** Replace cap and hand tighten only.



UNDERCLAMP OPTIONS FOR TAPPING TEES & BRANCH SADDLES

1. Permanent PE Underclamp

Slide the underclamp on the tapping tee lips and insert it with a mallet until contact is made with the stop. Ensure underclamp is inserted in correct direction. **Re-mark surface at fitting placement area.**



2. Permanent Strap Underclamp

Insert the end of the strap with screws onto the opposite lip of the tapping tee outlet and tighten the screws until they lock. **Re-mark surface at fitting placement area.**

ELECTROFUSION PROCEDURE

Manual/Bar Code

1. Connect electrofusion controller leads to terminals of electrofusion fittings ensuring they are connected correctly.
2. Activate fusion cycle by either scanning bar code label on fitting or manually entering the fusion time indicated on the label.
3. After the fusion cycle has completed wait 15 seconds before removing the leads.
4. Allow the correct cooling time indicated on the label of the fitting before removing any clamping devices and before pressure testing.

Any movement of the fusion indicator is a visual verification that fusion has taken place. No movement at all in the fusion indicator indicates that there has been a problem during the fusion cycle and further investigation and possible replacement is required.

Movement i.e. the height of the fusion indicator does not guarantee the integrity/quality of the joints as this is subject to a number of factors including:

- Pipe preparation
- Size tolerance of the components
- Ovality of the pipe/fitting
- Ambient temperature
- Pipe temperature
- Outside diameter
- Pipe material
- Adequate clamping system (saddles)
- Correct fusion times followed



Shape and size
e.g. 4IPS Coupler

Voltage of
Fitting

Fusion
Time

Cooling
Time