INSTALLATION GUIDELINES FOR GTI WELDED GROUT PORT™
Version – 150120

Figure 1. GTI Grout Port Welder

The installation guidelines below have been prepared to assist the placer in the proper installation of the GTI Welded Grout Port™.

1. Preparing the Hole
   1.1. Mark the GTI Duct or GTI Duct Coupler with the location of the grout port.
   1.2. Drill a 7/8" (22mm) hole in the GTI Duct or GTI Duct Coupler.
   1.3. Clean hole and GTI Welded Grout Port™.

2. Preparing the Socket Welding Device
   2.1.1. Correct Adapter
      2.1.1.1. Confirm that Socket Welding Device is cool and unplugged.
      2.1.1.2. Mount correct adapter on Socket Welding Device.
   2.1.2. Heating
      2.1.2.1. Confirm there is proper power source.
      2.1.2.2. Place Socket Welding Device in the cradle.
      2.1.2.3. Connect the Socket Welding Device to the power source.
      2.1.2.4. Allow to Socket Welding Device to reach its working temperature.
3. The Welding Process
   3.1. Heating
      3.1.1. Simultaneously, insert male adapter of Socket Welding Device into drilled hole and place GTI Welded Grout Port™ into female adapter.
      3.1.2. Apply light pressure for 20 – 25 seconds by pushing the GTI Welded Grout Port™ with the palm of hand.
   3.2. Assembly
      3.2.1. Simultaneously, remove Socket Welding Device from drilled hole and GTI Welded Grout Port™ from female adapter.
      3.2.2. Insert GTI Welded Grout Port™ into hole until the shoulder is reached.
      3.2.3. This operation should be carried out as quickly and carefully as possible, within 5 seconds.
   3.3. Setting
      3.3.1. Firmly hold the pieces together for a minimum of 10 seconds.
      3.3.2. Ensure that the region of the weld is not subjected to any force during this time.
   3.4. Cooling
      3.4.1. Allow the GTI Duct or GTI Duct Coupler and GTI Welded Grout Port™ to cool for a minimum of 4 minutes.
      3.4.2. After the cooling time has finished, the GTI Welded Grout Port™ is connected.
      3.4.3. The GTI Duct or GTI Duct Coupler can now be used as necessary.

Figure 2. GTI Welded Grout Port™ installed in GTI Duct