



**INSTALLATION GUIDELINES FOR GTI WELDED GROUT PORT™**  
**Version – 150120**

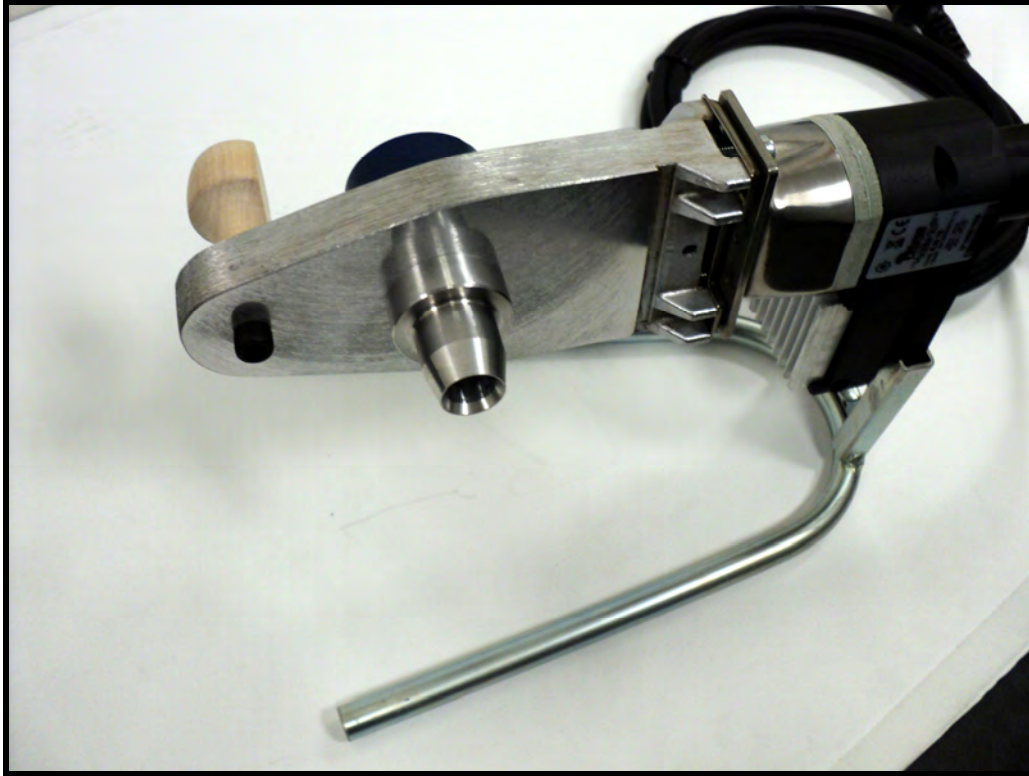


Figure 1. GTI Grout Port Welder

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.

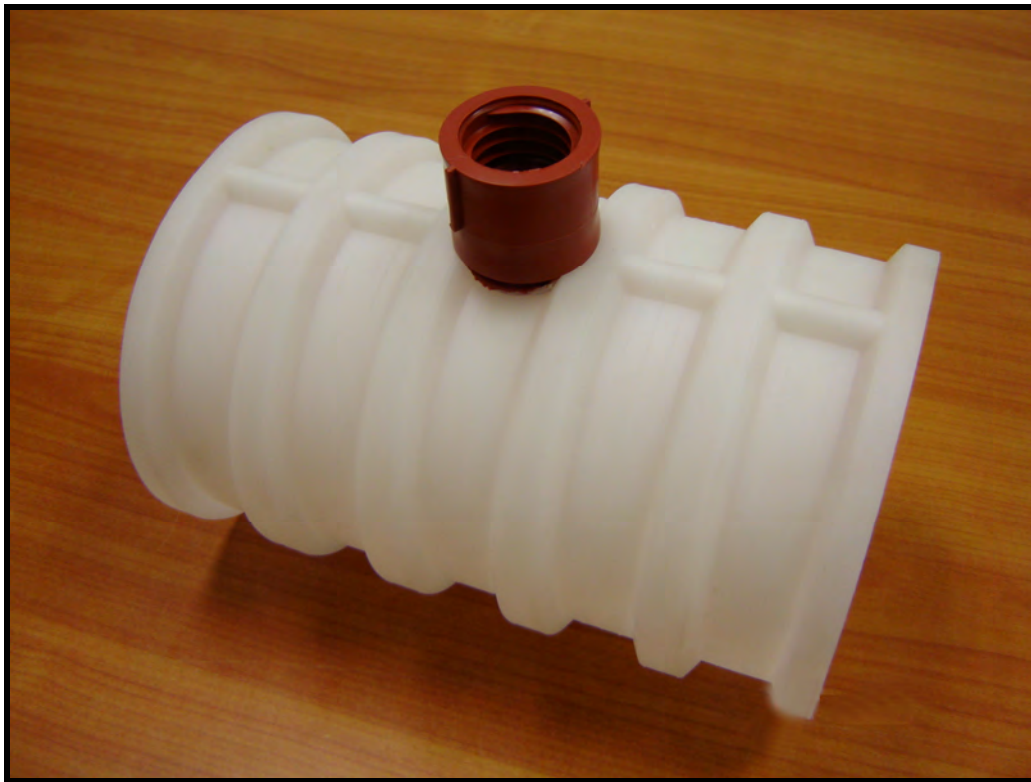


Figure 2. GTI Welded Grout Port™ installed in GTI Duct