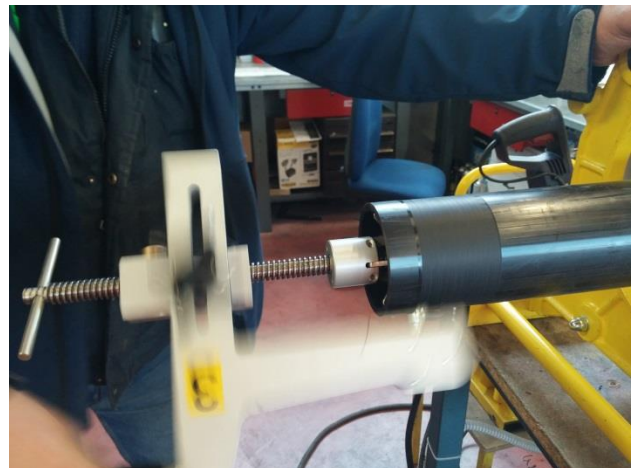
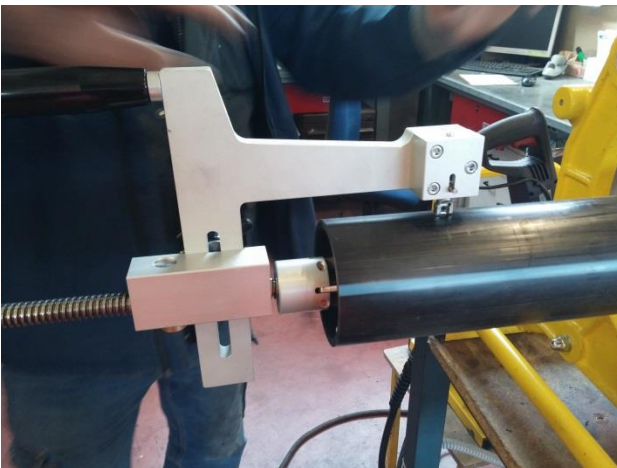


PROCEDURE FOR ELECTROFUSION WELDING

1. Cut the pipes and remove the burrs. The ends of the tubes to be welded must be flat and perpendicular to their axis: the cut must be made with suitable pipe cutter with a fixed blade guide.
2. Place the tubes to be spliced in line, with the ends in contact.
3. Without removing the protective wrapper, position the electrofusion coupler (EFC) on the pipes so that the seam of the tubes are in the center of the EFC.
4. Mark a line on the tube to about 20 mm from the end of the EFC.

Scrape the outer surface of the tubes up to the marked line and chamfer the head of the tube to facilitate the insertion. For this operation we recommend the use of manual or mechanical scrapers. It is **ABSOLUTELY** prohibited **the use of** abrasive paper, rasp, etc. Scraping in any case should not interest a depth greater than 0,2 mm.



5. Remove all traces of mud, dust, grease or other dirt which may be present on the outer and inner surfaces of the tubes in the welding area. Cleaning should be done with a dry cloth, clean and free of lint, soaked in suitable liquid (methylene chloride, isopropyl alcohol, trichloro ethane chlorothene, acetone). Do not use with other products such as thinner, denatured alcohol, gasoline.
6. Take out the EFC from the bag, in case of dirt clean the inner as explained in point "6".
7. Insert the pipes up to the middle of the EFC, making sure that the two heads of the tubes are in contact with each other.
8. Block all the components components; to block the tubes use the proper positioner.



9. Connect with the appropriate cables of the welding machine to the fitting connection.



10. Check the melting time imprinted on the EFC and/or printed on the label.

11.

12. Connect the welding machine to the tension. Set the data of the EFC (via optical reading of the bar code or manually) and check on the digital display the correct time setting.



13. The completion of the welding cycle will be signaled acoustically.

14. Let the joint cool for the cooling time indicated on the EFC, without removing the positioner; the machine connection cables can be removed.

15. Do not pressurize the system until the junction reaches the room temperature.