**WARNING:** READ AND COMPLY WITH ALL APPLICABLE OPERATING INSTRUCTIONS AND WARNINGS FOR MULTI-STRAND STRESSING BEFORE STARTING ANY WORK OR OPERATION.

**CAUTION:** WHEN PRESSURIZING GROUT CAPS CHECK CAPS TO CONFIRM THAT BONDS ARE NOT LOOSE OR DAMAGED.

**INSTALLATION PROCEDURE:**

1. **ASSEMBLE THE MULTI-PLANE AND/OR HOPE PIPE AND SPREAD THE HOPE PIPE ATTACHMENT INTO TRANSITION PIECE TO THE END OF MPA. INSERT 5" IPS OR 1/2" HOPE PIPE INTO TRANSITION PIECE AND HEAT SHRINK MOVES BACK THE SPREAD CLOSE TO THE MPA AS SHOWN IN FIGURE 1-1 AND 1-2. CLEAR THE ATTACHMENT IN THE TRANSITION PIECE AND REMOVE LATER.

2. **BOLT THE MULTI-PLANE ANCHOR (MPA) TO THE POCKET ADJACENT TO THE HOPE PIPE AND OR HOPE PIPE ATTACHMENT USING 6-7/8" NPT PIPE NIPPLE AND HOPE PIPE CAP AS SHOWN IN FIGURE 1-1 AND 1-2. SECURE HOPE PIPE CAPS TO THE MPA USING 6-7/8" NPT PIPE NIPPLE AND HOPE PIPE CAPS AS SHOWN IN FIGURE 1-1 AND 1-2.

3. **AFTER FLEXIBLE FILLER HAS SET & FOAM INSULATION (BY OTHERS) HAS BEEN REMOVED (TYP). REFER TO FOOT STANDARD PLANS INDEX 462-033 FOR FT ANCHORING AND TENDON FILLING DETAILS.

4. **CONCRETING CAN NOW PROCEED.

5. **AFTER COMPLETION OF CONCRETE PLACEMENT, PROVE THAT THE DUCTS ARE CLEAR OF ANY OBSTRUCTIONS OR DAMAGE. PASS A TORCHED THROUGH THE DUCT TO DEMONSTRATE.

6. **PROVE THAT ALL FLEXIBLE FILLER VENTS ARE FREE AND CLEAR.

7. **AFTER THE CONCRETE HAS GAINED STRENGTH, THE DUCTS SHOULD BE ORIENTED SUCH THE FLEXIBLE FILLER HOLE POINTS UP. IF FLEXIBLE FILLER HAS NOT SET & FOAM INSULATION (BY OTHERS) HAS BEEN REMOVED (TYP), USE TEFLON TAPE OR PASTE ON THREADS.

8. **INSTALL STRANES BY PULLING OR PULLING INDIVIDUALLY OR A GROUP INTO HOLES. ALLOW ENOUGH TAIL LENGTH FOR STRESSING.

9. **CHECK THE WEDGE PLATE FOR RUST, DIRT AND GRIT. CLEAN ALL PARTS AND COMPONENTS PER THE FDOT’S OPERATING INSTRUCTIONS AND WARNINGS FOR MULTI-STRAND STRESSING BEORIENTED SUCH THE FLEXIBLE FILLER HOLE POINTS UP. IF FLEXIBLE FILLER HAS NOT SET & FOAM INSULATION (BY OTHERS) HAS BEEN REMOVED (TYP), USE TEFLON TAPE OR PASTE ON THREADS.

10. **AFTER THE STRESSING OPERATION IS COMPLETED AND THE ELONGATIONS FALL WITHIN ±7%, OBTAIN APPROVAL FROM THE MANUFACTURER’S INSTRUCTIONS.

11. **INSTALL GROUT CAP WITH O-RING USING SIX BOLTS. USE ONLY CLEAN WEDGES. INSTALL WEDGE PLATE WITH GRACE AND SLIP THE WEDGES OVER THE STRANDS AND LOOSELY SEAT IN WEDGE HOLES.

12. **CONNECT THE 3" IPS OR 1/2" HOPE PIPE CAP INTO THE TRANSITION PIECE AND REMOVE LATER.

13. **AFTER STRESSING OPERATION IS COMPLETED AND ELONGATIONS FALL OUTSIDE THE ±7% LIMIT, INSTALL GROUT CAP WITH O-RING USING SIX BOLTS. USE ONLY CLEAN WEDGES. INSTALL WEDGE PLATE WITH GRACE AND SLIP THE WEDGES OVER THE STRANDS AND LOOSELY SEAT IN WEDGE HOLES.

14. **CHECK THE WEDGE PLATE FOR RUST, DIRT AND GRIT. CLEAN ALL PARTS AND COMPONENTS PER THE FDOT’S OPERATING INSTRUCTIONS AND WARNINGS FOR MULTI-STRAND STRESSING.

15. **INSTALL GROUT CAP WITH O-RING USING SIX BOLTS. USE ONLY CLEAN WEDGES. INSTALL WEDGE PLATE WITH GRACE AND SLIP THE WEDGES OVER THE STRANDS AND LOOSELY SEAT IN WEDGE HOLES.

16. **CONNECT THE 3" IPS OR 1/2" HOPE PIPE CAP INTO THE TRANSITION PIECE AND REMOVE LATER.

17. **AFTER STRESSING OPERATION IS COMPLETED AND ELONGATIONS FALL OUTSIDE THE ±7% LIMIT, INSTALL GROUT CAP WITH O-RING USING SIX BOLTS. USE ONLY CLEAN WEDGES. INSTALL WEDGE PLATE WITH GRACE AND SLIP THE WEDGES OVER THE STRANDS AND LOOSELY SEAT IN WEDGE HOLES.

18. **CHECK THE WEDGE PLATE FOR RUST, DIRT AND GRIT. CLEAN ALL PARTS AND COMPONENTS PER THE FDOT’S OPERATING INSTRUCTIONS AND WARNINGS FOR MULTI-STRAND STRESSING.

19. **INSTALL GROUT CAP WITH O-RING USING SIX BOLTS. USE ONLY CLEAN WEDGES. INSTALL WEDGE PLATE WITH GRACE AND SLIP THE WEDGES OVER THE STRANDS AND LOOSELY SEAT IN WEDGE HOLES.

20. **CONNECT THE 3" IPS OR 1/2" HOPE PIPE CAP INTO THE TRANSITION PIECE AND REMOVE LATER.

21. **AFTER STRESSING OPERATION IS COMPLETED AND ELONGATIONS FALL OUTSIDE THE ±7% LIMIT, INSTALL GROUT CAP WITH O-RING USING SIX BOLTS. USE ONLY CLEAN WEDGES. INSTALL WEDGE PLATE WITH GRACE AND SLIP THE WEDGES OVER THE STRANDS AND LOOSELY SEAT IN WEDGE HOLES.

22. **CHECK THE WEDGE PLATE FOR RUST, DIRT AND GRIT. CLEAN ALL PARTS AND COMPONENTS PER THE FDOT’S OPERATING INSTRUCTIONS AND WARNINGS FOR MULTI-STRAND STRESSING.
NOTES:
1. SPIRAL IS MADE FROM STANDARD #6 REBAR, NO PART NUMBER MARKING IS SHOWN.
2. KEEP SPIRAL AND MPA AXES ALIGNED, IF USING SIDE PORT, ROTATE SPIRAL 10 CLEAR.

NUMBER OF FULL Turns: 9
DEVELOPED LENGTH: 43' - 0 - 1/2"
WEIGHT: ~64.5 LBS.
MATERIAL:
24 GAUGE GALVANIZED SHEET METAL
PER ASTM A653
WALL THICKNESS = 0.0276"
31-0.6 PE SPACER (HEX PATTERN)

DIMENSIONS: INCH / mm

QUALITY PLAN NUMBER:

TOLERANCES: 0.020 UNLESS NOTED
MATERIAL: EN ISO 1872 - PE-HD (HDPE)
WEIGHT ~2.1 LBS.
SCALE 1:3

REV. DATE NAME

PART NUMBER: 68 31 6084

DRAWING NUMBER: 68 31 6084

DYWIDAG-SYSTEMS INTERNATIONAL, USA, INC.
320 MARMON DRIVE - BOLINGBROOK, IL 60440
PHONE: 630-739-1100 FAX: 630-739-1405

THIS DRAWING, THE PERTINENT ENCLOSURES, DESCRIPTIONS, CALCULATIONS ETC., AND THEIR CONTENTS ARE THE PROPERTY OF DYWIDAG SYSTEMS INTERNATIONAL, USA, INC. THEY ARE NOT ALLOWED TO BE DUPLICATED WITHOUT OUR PERMISSION. THEY ARE ALSO NOT TO BE SHOWN OR EXPLAINED FOR ANY REASON TO A THIRD PARTY OTHER THAN FOR REASONS EXPRESSLY INTENDED BY DSI'S SUBMITTAL TO THE ORIGINAL RECEIVER. THEY HAVE TO BE RETURNED UPON REQUEST.
MATERIAL: 5" SDR 17 HDPE PIPE.

SPECIFICATIONS:
1. PIPE SHALL BE OF HIGH-DENSITY POLYETHYLENE AND SHALL HAVE A MAXIMUM DIMENSION RATIO (DR) OF 17 AS ESTABLISHED BY EITHER ASTM D3035 OR ASTM F714, AS APPROPRIATE FOR MANUFACTURING PROCESS USED.
2. PIPE SHALL HAVE A MINIMUM PRESSURE RATING OF 125 PSI.
3. MEETS REQUIREMENTS OF ASTM D3350 WITH A MINIMUM CELL CLASS OF 445574C.
4. CONTAINS ANTIOXIDANTS WITH A MINIMUM OXIDATIVE-INDUCTION TIME (OIT) ACCORDING TO ASTM D3895 OF 40 MINUTES.
5. REMOLED FINISHED MATERIAL HAS A MINIMUM FAILURE TIME OF THREE HOURS WHEN TESTED FOR STRESS CRACK RESISTANCE USING ASTM F2136 AT AN APPLIED STRESS OF 348 PSI.
6. MINIMUM BEND RADIUS = 30 FT.
<table>
<thead>
<tr>
<th>PIPE SIZE</th>
<th>STRAND SYSTEM</th>
<th>BAR SYSTEM</th>
<th>HEAT SHRINK SLEEVE SIZE</th>
<th>PART NUMBER</th>
</tr>
</thead>
<tbody>
<tr>
<td>2 1/2&quot; IPS DR 17</td>
<td>7-0.6&quot;</td>
<td>1&quot;, 1 1/4&quot;, 1 3/8&quot;</td>
<td>KLNN/L 63-450 BK</td>
<td>U00039063</td>
</tr>
<tr>
<td>3&quot; SDR 17</td>
<td>12-0.6&quot;</td>
<td>1 3/4&quot;</td>
<td>KLNN/L 90-450 BK</td>
<td>U00039090</td>
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<tr>
<td>4&quot; SDR 17</td>
<td>19-0.6&quot;</td>
<td>2 1/2&quot;, 3&quot;</td>
<td>KLNN/L 115-450 BK</td>
<td>U00039115</td>
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<tr>
<td>5&quot; SDR 17</td>
<td>27-0.6&quot; &amp; 31-0.6&quot;</td>
<td></td>
<td>KLNN/L 125-450 BK</td>
<td>U00039125</td>
</tr>
</tbody>
</table>

**NOTE:**
- FOLLOW MANUFACTURER'S INSTALLATION INSTRUCTIONS.

**TOP VIEW**
- CLOSURE TAB
- 1.5" [38.1mm]
- LENGTH VARIES TO FIT PIPE SIZE

**END VIEW**
- CLOSURE TAB
- 1.5" [38.1mm]

**KLNN HEAT SHRINK SLEEVE**

**DIMENSIONS:** INCH (mm)

**QUALITY PLAN NUMBER:**

**DATE:** 02-21-19

**DRAWING NUMBER:** U00039000

**MATERIAL:** POLYOLEFIN MEETS FOOT SPEC 980-2.2.1.8 FOR FLEXIBLE FILLER

**SCALE:** XX

**REV.**

**DATE**

**NAME**

**PART NUMBERS:**
- U00039063
- U00039090
- U00039115
- U00039125

**DRAWING NUMBER:**
- U00039000

**DSI**

**DYWIDAG-SYSTEMS INTERNATIONAL, USA, INC.**

**320 MARMON DRIVE - BOLINGBROOK, IL 60440**

**PHONE:** 630-739-1100  **FAX:** 630-738-1405

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0.6" BARE 270 KSI STRAND

NOTES:
1. NO PART NUMBER OR IDENTIFICATION MARKS ON STRAND.
2. RUST PRODUCING VISIBLE Pitting TO THE UN-AIDED EYE IS NOT ALLOWED.

MATERIAL:
0.6" 270 KSI LOW RELAX STRAND
ASTM A416
3-PART WEDGE FOR 0.6" STRAND

MATERIAL: 12L14
ALL HARDENED

NOTES:
1. SHARP EDGES MUST BE BROKEN.
2. VIBRATE TO SURFACE FINISH OF 63 μIN. MAX.
3. DIP IN SQ70 OIL OR EQUV. FOR CORROSION PROTECTION.
4. MAKE SURE THAT THE BUTTRESS THREAD IS ORIENTED IN THE DIRECTION SHOWN ON THIS DRAWING.
5. NO STAMPED PART NUMBER

SPRING WIRE RING:
WIRE QUALITY: ASTM 22B

SEE NOTE 2

DIMENSIONS: INCH/mm
±.010; ±2°
UNLESS NOTED

TOLERANCES:

<table>
<thead>
<tr>
<th>NAME</th>
<th>DATE</th>
<th>REV.</th>
<th>WEIGHT</th>
<th>SCALE</th>
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</thead>
<tbody>
<tr>
<td></td>
<td></td>
<td></td>
<td>0.19 LBS.</td>
<td>2:1</td>
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QUALITY PLAN NUMBER: QS00000500D

PART NUMBER: 68 00 0536

DYWIDAG-SYSTEMS INTERNATIONAL, USA, INC.
POST TENSIONING / REINFORCING UNIT
320 MARMON DRIVE - BOLINGBROOK, IL
PHONE: 630-739-1100
FAX: 630-739-1408

DRAWING NUMBER: 68 00 0536

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STAINLESS STEEL 316L BOLTS AND WASHER FOR NYLON CAPS

POS. | PART NUMBER | DESCRIPTION (ALL PARTS 316L STAINLESS STEEL UNLESS NOTED)
--- | --- | ---
1 | 00 00 771 | 3/8"-16UNC HEX BOLT, 2-3/4" LONG (1" LONG THREAD)
2 | 00 00 772 | 3/8"-16UNC HEX BOLT, 3-1/2" LONG (1" LONG THREAD)
3 | 00 00 774 | TYPE A NARROW WASHER FOR 3/8"-UNC BOLT
4 | 00 00 776 | 3/8"-16UNC COUPLER, ZINC COATED
5 | 00 00 777 | 3/8"-16UNC HEX NUT
6 | 00 00 778 | 5/16"-18UNC HEX BOLT, 7/8" LONG, ZINC PLATED
7 | 00 00 783 | 3/8"-16UNC HEX BOLT, 3-1/4" LONG (1" LONG THREAD)
8 | 00 00 784 | 3/8"-16UNC HEX BOLT, 4-1/4" LONG (FULL THREAD)
9 | 00 00 789 | 3/8"-16UNC CARRIAGE BOLT, 4-1/2" LONG
10 | 00 00 790 | 3/8"-16UNC CARRIAGE BOLT, 5-1/2" LONG

NOTE:
The 316L S.S. BOLTS ARE SPECIAL ORDER.
ALL WASHERS, HEX NUTS & COUPLERS HAVE NO MARKINGS.

DRAWING NUMBER: 00 00 770

DIMENSIONS: INCH
QUALITY PLAN NUMBER:

DATE: 09-10-04
DWG: G. MALECKI
CHK: E.A
APP: K.S.

DYWIDAG-SYSTEMS INTERNATIONAL, USA, INC.
POST TENSIONING / REINFORCING UNIT PHONE: 630-739-1100
320 MARMON DRIVE - BOLINGBROOK, IL FAX: 630-739-1405
3/4" NPT PIPE NIPPLES

LENGTH VARIES

3/4" NPT THREAD TYP.

PHOTO DIA: [28.7] NOMINAL

PRESSURE RATED: 150 PSI

MATERIAL: SCH 40 BLACK WELDED STEEL

SCALE: 1:1

DIMENSIONS: INCH (mm)

QUALITY PLAN NUMBER: 0000000200

REV. DATE NAME FORM PART NUMBER

DATE: 01-29-19 DWG: G. MALECKI CHK: S.L. APP: S.L.

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DYWIDAG-SYSTEMS INTERNATIONAL, USA, INC.
320 MARMON DRIVE - BOLINGBROOK, IL 60440
PHONE: 630-739-1100 FAX: 630-739-1405

DRAWING NUMBER: 0000878
3/4" NPT, 14 THREADS PER INCH, 0.55" THREAD ENGAGEMENT

PRESSURE RATED: 150 PSI

DIMENSIONS: INCH [mm] FOR REFERENCE ONLY

3/4" BALL VALVE

WEIGHT: 0.77 LBS.

MATERIAL: BRASS

SCALE: 3/4" = 1"
PRESSES RATED: 150 PSI

<table>
<thead>
<tr>
<th>DIMENSIONS: INCH (mm)</th>
<th>QUALITY PLAN NUMBER:</th>
</tr>
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<tbody>
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</tbody>
</table>

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3/4" NPT NYLON PLUG

<table>
<thead>
<tr>
<th>MATERIAL: NYLON</th>
<th>SCALE</th>
</tr>
</thead>
<tbody>
<tr>
<td>COLOR: WHITE</td>
<td>1:1</td>
</tr>
</tbody>
</table>

| DATE: 03-12-19 | DMG: G. MAADEKK | CHK: S.J. | APP: S.J. |

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1/2" NPT PIPE NIPPLES

PRESSURE RATED: 150 PSI
1/2" NPT, 14 THREADS PER INCH, 0.53" THREAD ENGAGEMENT

PRESSURE RATED: 150 PSI

MATERIAL: BRASS
SCALE: 3/4" = 1"
1/2" NPT NYLON PLUG

PRESSURE RATED: 150 PSI
PRESSURE RATED: 150 PSI

3/4" NPT PIPE NIPPLES

LENGTH VARIES

\[ \varnothing 1.050 \text{ (NOMINAL)} \]

3/4" NPT THREAD TYP.

MATERIAL:
SCH 40
BLACK WELDED STEEL

SCALE: 1:1

DYWIDAG-SYSTEMS INTERNATIONAL, USA, INC.
320 MARMON DRIVE - BOLINGBROOK, IL 60440
PHONE: 630-739-1100 FAX: 630-739-1405

REV. DATE NAME FORM

PART NUMBER: 00 00 878

DIMENSIONS: INCH (mm)
mm FOR REFERENCE ONLY

QUALITY PLAN NUMBER: C000100020P

DATE: 01-29-19 DWG: G. MALECKI CHK: S.I. APP: S.I.

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3/4" NPT FEMALE COUPLER

PRESSURE RATED: 150 PSI

MATERIAL: SCH 40 BLACK

SCALE: 1:1

DYWIDAG-SYSTEMS INTERNATIONAL, USA, INC.
320 MARMON DRIVE - BOLINGBROOK, IL 60440
PHONE: 630-739-1100  FAX: 630-739-1405
3/4" NPT 90° ELBOW, FEMALE-FEMALE

PRESSURE RATED: 150 PSI

DIMENSIONS: INCH (mm) mm FOR REFERENCE ONLY
QUALITY PLAN NUMBER: 0000000020P

DATE: 05-01-19  DWG: G. MALECKI  CHK: S.L  APP: S.L

MATERIAL: SCH 40 BLACK STEEL SCALE 1:1

PART NUMBER: 00 00 880
DYWIDAG-SYSTEMS INTERNATIONAL, USA, INC.
320 MARMON DRIVE - BOLINGBROOK, IL 60440
PHONE: 630-739-1100  FAX: 630-739-1405
INSTALLATION PROCEDURE:
(SEE MANUFACTURER INSTRUCTION MANUAL FOR DETAILED INSTRUCTIONS)

1. CUT PIPE ENDS PRECISELY AT RIGHT ANGLES TO THE PIPE AXIS.
2. CLEAN BOTH PIPE ENDS CAREFULLY.
3. SCRAP BOTH PIPES ENDS AS REQUIRED TO REMOVE THE OXIDE LAYER COMPLETELY.
4. CLEAN BOTH PIPE ENDS WITH CONCENTRATED ISOPROPYL ALCOHOL.
5. USE REROUNDING TOOLS TO CORRECT OVAL PIPE IF NEEDED.
6. USE ALIGNMENT CLAMPS TO SECURE THE ALIGNMENT OF CONNECTED PIPES.
7. PROVIDE SUPPORT TO THE PIPE AND COUPLER TO PREVENT ANY MOVEMENT.
8. ENSURE THERE IS NO EXISTING GAPS BETWEEN COUPLE AND PIPE FACE.
9. ATTACH LEADS OF THE FUSION PROCESSOR TO THE COUPLER.
10. SCAN THE BARCODE ON THE COUPLER AND CONFIRM THE COUPLER'S SIZE ON THE PROCESSOR SCREEN.
11. INITIATE FUSION PROCESS.
12. UNPLUG THE LEADS AS SOON AS THE FUSION PROCESS ENDS.
13. CHECK COOLING TIME OF THE PROVIDED COUPLER BASED ON COUPLER'S SIZE.
14. DO NOT ALLOW MOVEMENT OR APPLIED PRESSURE ON THE JOINTS BEFORE COOLING TIME ENDS.
WELDING OPERATIONS:
DRILL A HOLE USING SPECIFIED CONE DRILL TOOL
WHEREVER NEEDED IN COMMON POLYETHYLENE
DUCTS OF ALL BRANDS. HEAT UP POLYETHYLENE
GROUT PORT AND THE HOLE IN DUCT FOR ABOUT
10 SECONDS USING PES-TEC WELDING EQUIPMENT.
RELEASE THE GROUT PORT AND PRESS INTO THE
HOLE IN DUCT BY HAND FOR 15 SECONDS.

MATERIAL: POLYETHYLENE
COLOR: BLACK (UV PROTECTED)
USAGE: FOR SMOOTH HDPE PIPES
PRESSURE RATED: 150 PSI