



SDI Welded Grout Port Installation Procedure

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REVISION LOG:

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0	4/21/14	Initial Release	JMY	MW	MCS
1	9/23/15	Added Operating Temp	JMY	JMY	JMY

Note: All revision changes are identified by a vertical line at left border of text.

WELDED GROUT PORT INSTALLATION PROCEDURE

The purpose of this document is to detail the procedure for installation of the SDI Welded Grout Port on to polypropylene (PP) duct or high density polyethylene (HDPE) pipe.

The equipment required are as follows:

- SDI 110v electric grout port welder.



- 7/8" Hole Saw

The installation procedure is as follows:

- Plug in SDI Grout Port Welder to proper power source. (110v AC)
- Allow Welder to reach operating temp (490° F/255° C). The Red light will turn off when operating temp has been reached.
- Use 7/8" hole saw to cut opening for the grout port.
- Place grout port in the female mandrel of the SDI Grout Port Welder, and simultaneously insert the male welder mandrel into the drilled hole in the duct.
- Apply heat for 25 seconds. Support the welder to prevent it from resting on the duct during this time.

- After 25 seconds, remove welder from duct hole, and grout port from welder.
(Note: In colder climates heating time may need to be increased)
- Insert the grout port into the hole until pressing straight down until the shoulder touches the duct. Hold in place for 10 seconds.
- Unplug welder and allow to cool.



Figure 1: HDPE WELDED GROUT PORT



Figure 2: PP WELDED GROUT PORT