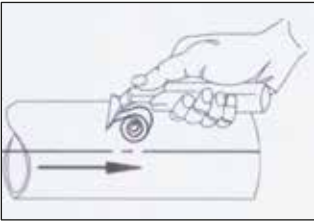
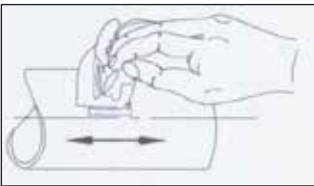


280-315 ELECTROFUSION SERVICE TEE WELDING AND INSTALLATION INSTRUCTION



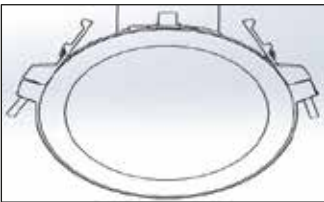
Checks: Check the pipes to be welded (The upper surface of the pipes shall be undamaged and proper). The area to be welded shall not be wet and be cleaned thoroughly. Determine the area to be welded on the pipe and please note that this area must be 1 cm bigger than the welding part of the service TEE. Rub out the oxidised PE layer with the help of a suitable scraper or ripper.



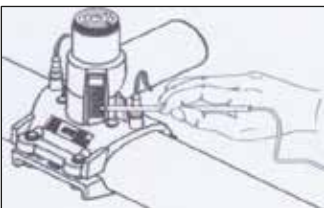
Thoroughly clean the rubbed area and the part of the service TEE to be welded (the inner surface) with applicable cleaning liquids (pure ethyl alcohol, pure acetone...) by using cloths which will not leave any particles behind or by using tissues.



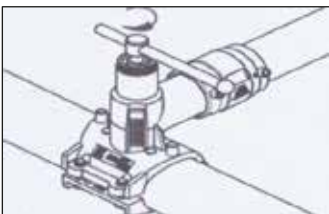
Install the clamps and middle-clamps as it is shown in the picture.



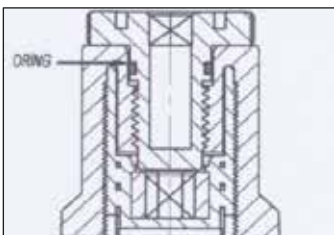
After the cleaned areas completely dry, place the part of the service TEE to be welded by aligning it with the scraped part on the pipe without human touch. Place the service TEE in a way to engage with the fastening lugs of the clamps. Tighten the mounting bolts until the junctures of the clamps are aligned.



Place the probes of the welding machine to the probe entrance of the service TEE. Scan the product barcode with the barcode reader of the welding machine or write the parameters manually.



Check the welding parameters and wait up to the designated cooling period after welding. By the help of allen wrench, start the procedure of perforating by using special perforating tip. When the perforating is complete, pull back the perforating tip upwards.



Place the O-ring cap of the perforator part and fasten it until it gets locked.

Caution! This procedure should only be carried out by the personnel who have electrofusion welding training. A protection tent shall be used against bad weather conditions and excess sunlight. If the welding and installation are not carried out in accordance with this instruction, there shall be no guarantee by the manufacturer.