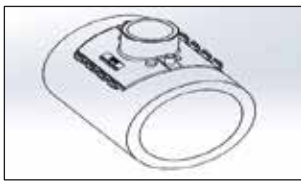
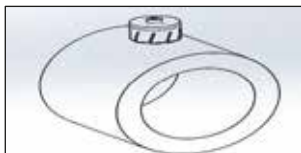


180-315 WELDING AND INSTALLATION INSTRUCTION FOR ELECTROFUSION SADDLE



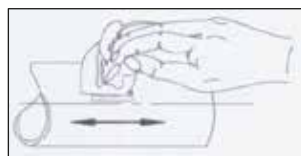
Checks: Check the pipes to be welded (The upper surface of the pipes shall be undamaged and proper). The area to be welded shall not be wet and be cleaned thoroughly. Determine the area to be welded on the pipe and please note that this area must be 1 cm bigger than the welding area of the saddle.



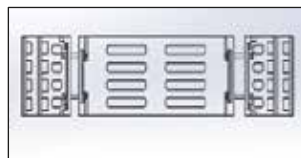
Mark the saddle internally. Perforate the pipe through the inner circle with punch.



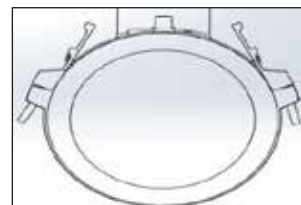
Rub out the oxidised PE layer with the help of a suitable scraper or ripper.



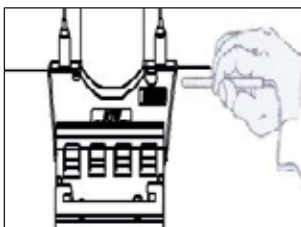
Thoroughly clean the rubbed area and the part of the saddle to be welded (the inner surface) with applicable cleaning liquids (pure ethyl alcohol, pure acetone...) by using cloths which will not leave any particles behind or by using tissues.



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



After the cleaned areas completely dry, place the part of the saddle to be welded on the scraped part on the pipe without human touch by aligning the inner diameter of the saddle with the centres of the hole on the pipe. Place the saddle 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 saddle. 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.

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.