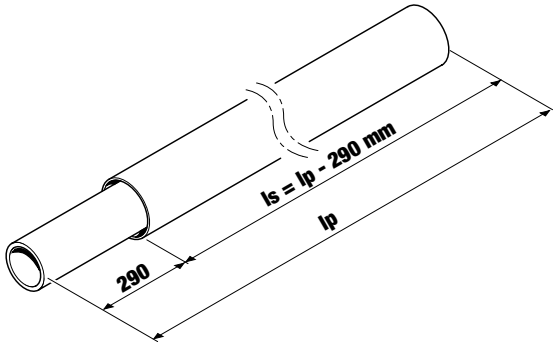
ASSEMBLY INSTRUCTIONS MODEL STEDWR110125

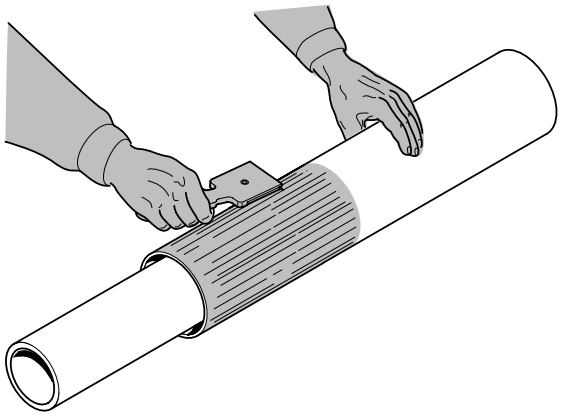
Fig.1



Measure the insertion length of the primary pipes. It is the distance between the complete stop inside the primary tee and the spigot rim of the secondary tee (about 290 mm).

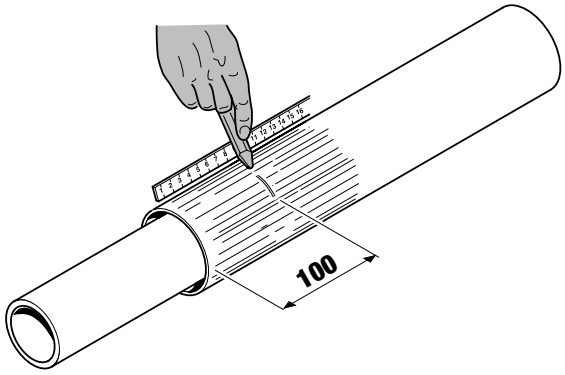
Cut the secondary pipes to the insertion length of the primary pipes previously measured.

Fig.2



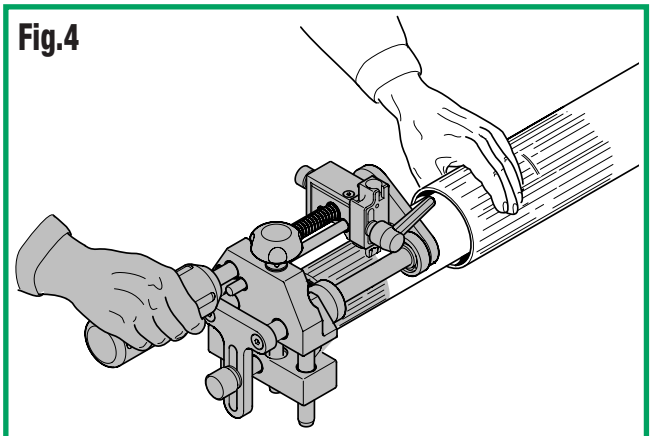
Scrape the secondary pipes to a length of 300 mm each.

Fig.3



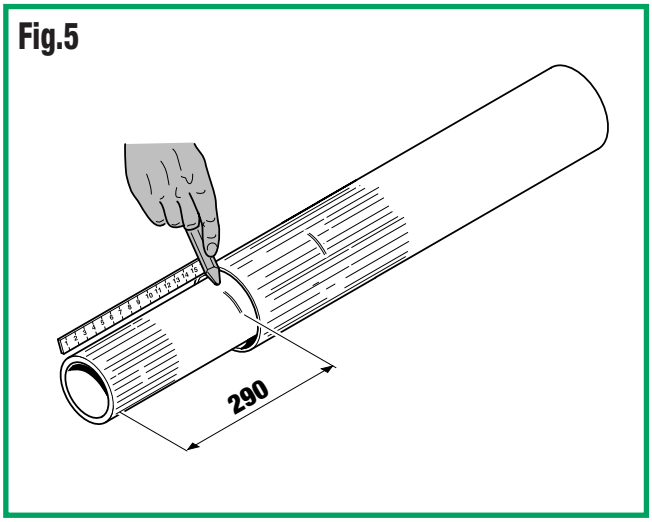
Mark the insertion length of the secondary pipes equal to 100 mm each.

Fig.4



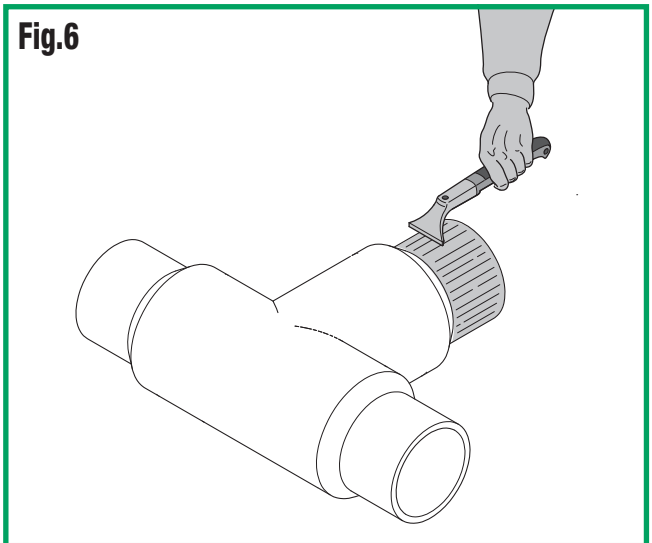
Scrape the primary pipes to a length of 100 mm each.

Fig.5



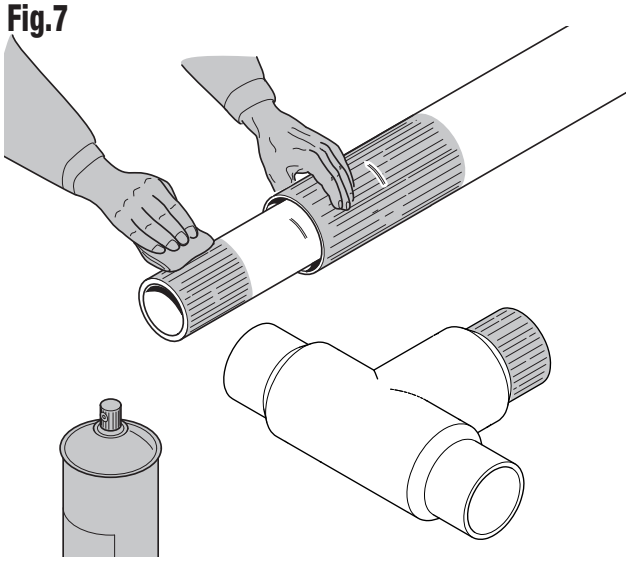
Mark the insertion length of the primary pipes (measured as per figure 1).

Fig.6



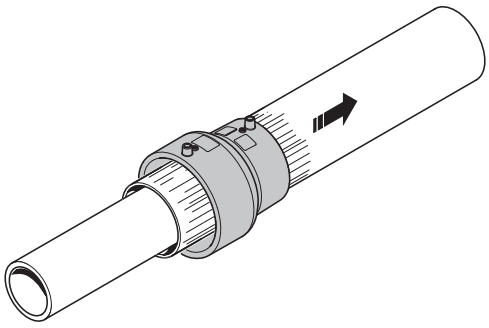
Scrape the secondary fitting spigot to a length of 90 mm.

Fig.7



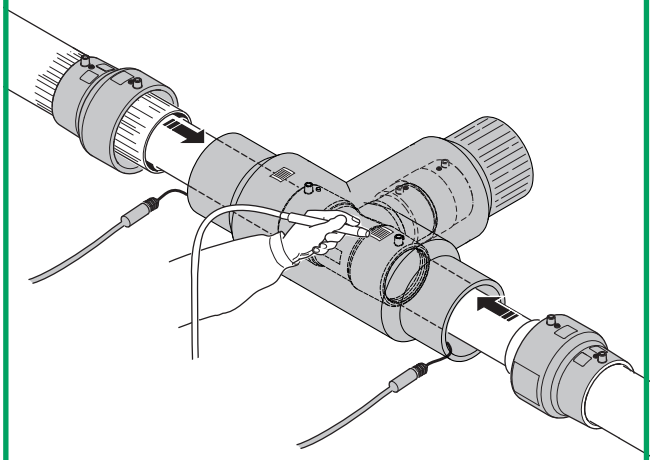
Clean the external surfaces of the pipes, the internal and external surfaces of the fitting and the internal surface of the reducer with the recommended cleaning solvent.

Fig.8



Slide the reducers on the secondary pipes to the whole length of the scraped part.

Fig.9

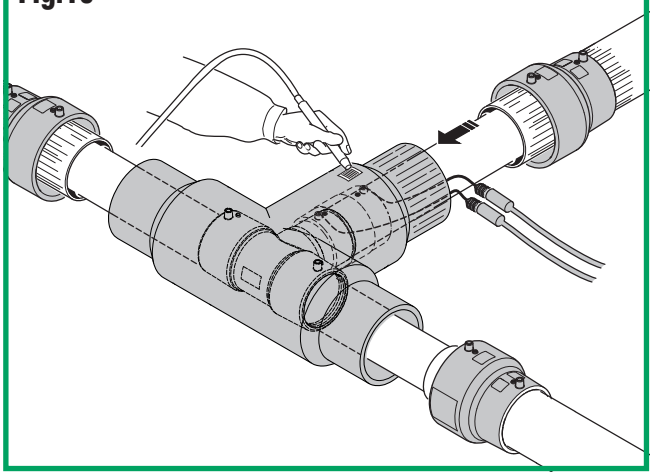


Insert the two primary pipes inside the fitting in both the ends of the long side to its complete stop inside the internal tee.

Make sure that the welding pins come out of the fitting.

Weld the two primary pipes of the long side at the same time (the internal fitting is single-wire) by reading the barcode indicated on the long side of the external tee.

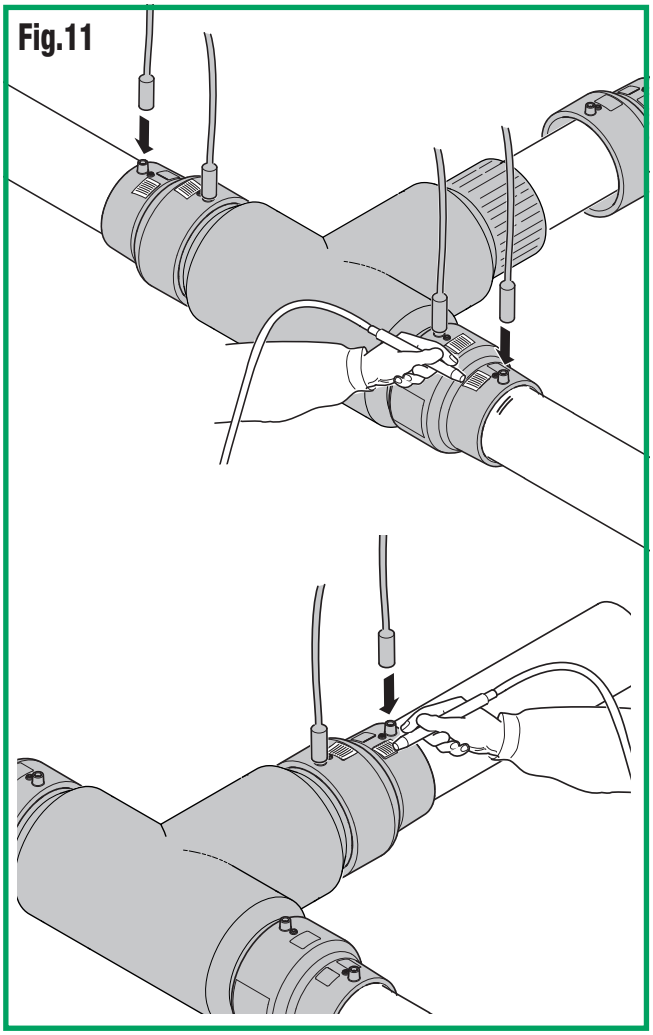
Fig.10



Insert the primary pipe to its complete stop inside the straight connector placed on the short side of the internal tee.

Insert the connectors (short side) inside the pins of the welding machine and weld by reading the barcode indicated on the short side of the external tee.

Fig.11



Slide the electric reducers on the secondary fitting spigot previously scraped and cleaned. Make sure that the insertion length indicated in figure 4 is reached.

Weld the reducers by reading the barcode indicated on the reducers.

When the weld is finished and after the fitting passed the hydraulic test, cut/tear off the brass parts of the welding pins so that the copper wire is not visible. Insulate the end of the welding pin by using insulating tape or paste. Place the covered wires so that they remain inside the secondary reducer.
N.B.: We recommend to insulate all cable lugs or metal ends that are visible inside the cavity or non- grounded.

N.B.: We strongly recommend to proceed with the welding of the whole primary line and carry out the pressure test to check the tightness of the joints before proceeding with the welding of the secondary line as the welding pins will remain trapped in the interstitial space of the secondary line. It will not be possible to repeat the welding operation.