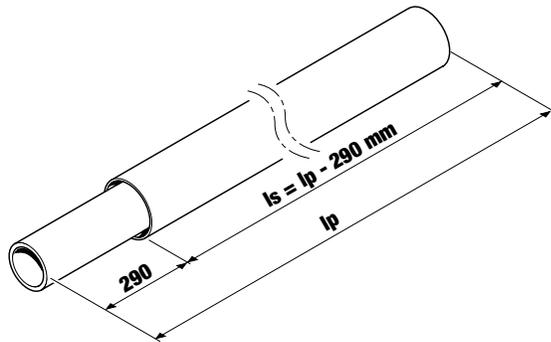


ASSEMBLY INSTRUCTIONS MODEL SGEDWR160225



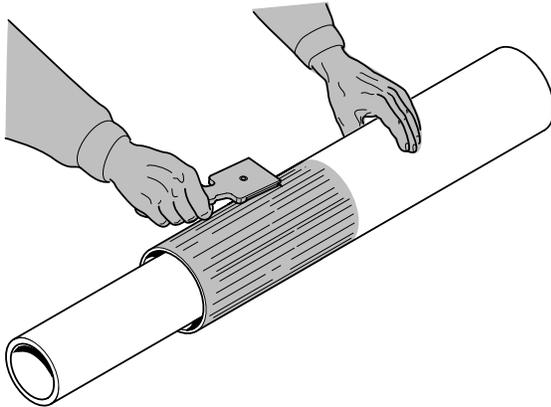
Fig.1



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

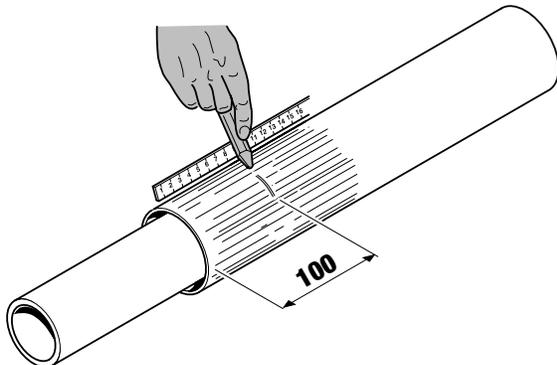
Cut the secondary pipe to the insertion length of the primary pipe previously measured.

Fig.2



Scrape the secondary pipe to a length of 300 mm.

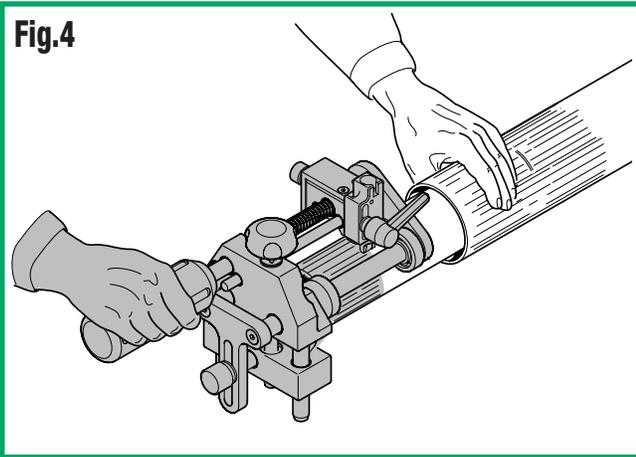
Fig.3



Mark the insertion length of the secondary pipe equal to 100 mm.

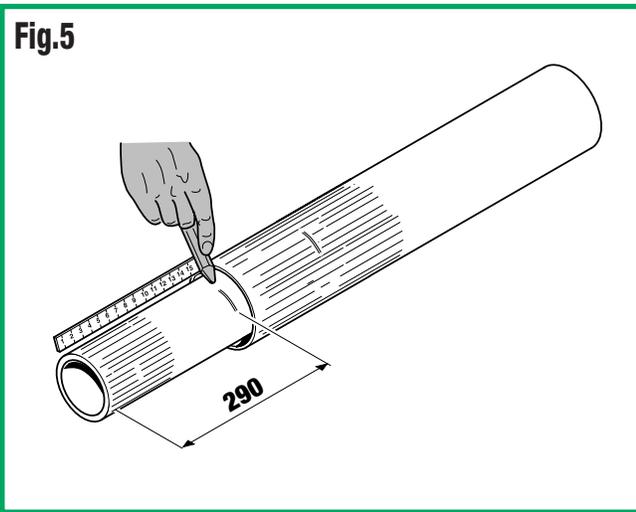


Fig.4



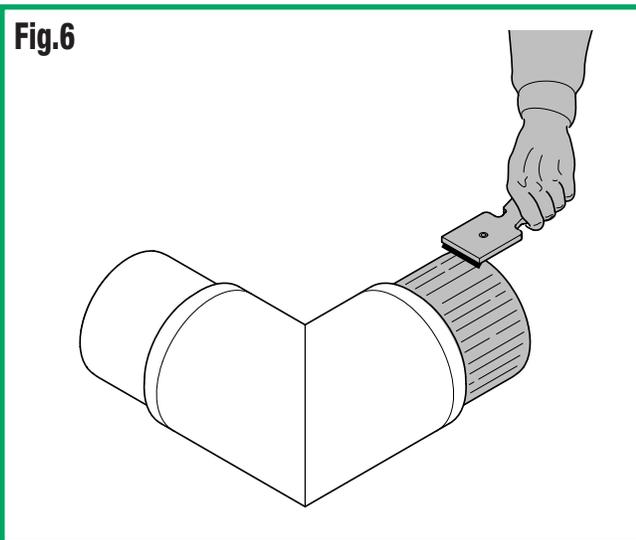
Scrape the primary pipe to a length of 100 mm.

Fig.5

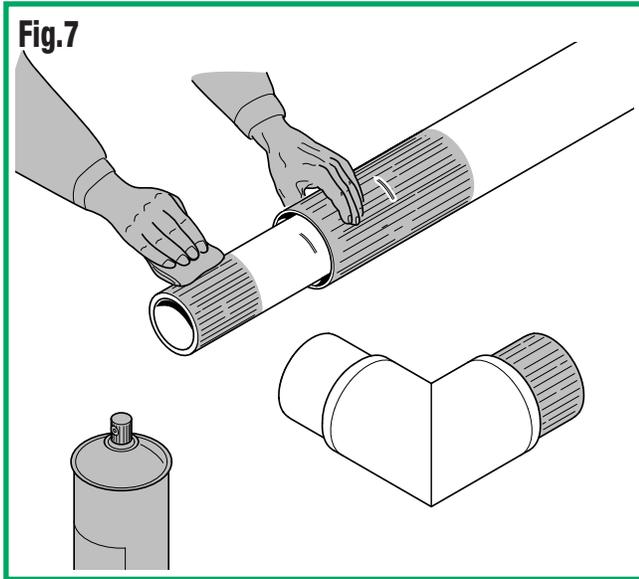


Mark the insertion length of the primary pipe (measured as per figure1).

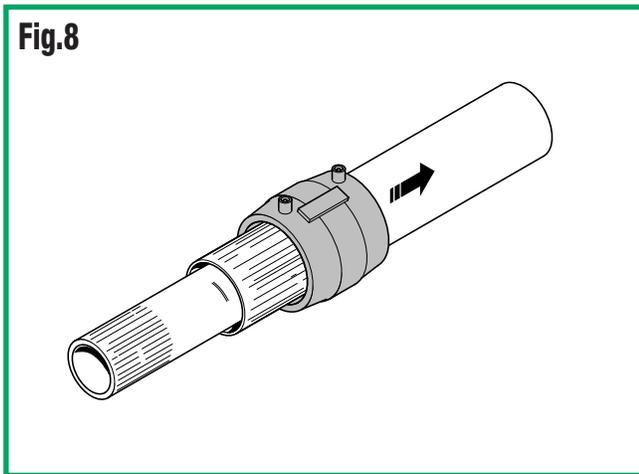
Fig.6



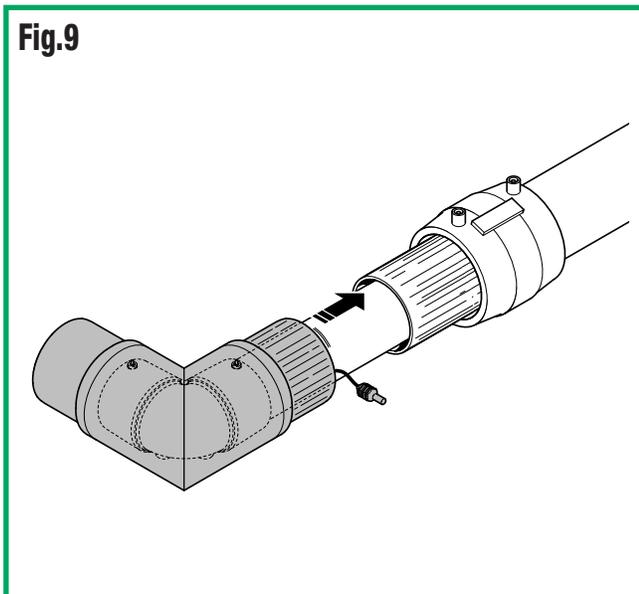
Scrape the secondary fitting spigot to the insertion length of the straight connector (about 100 mm).



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



Slide the straight connector on the secondary pipe to the whole length of the scraped part.

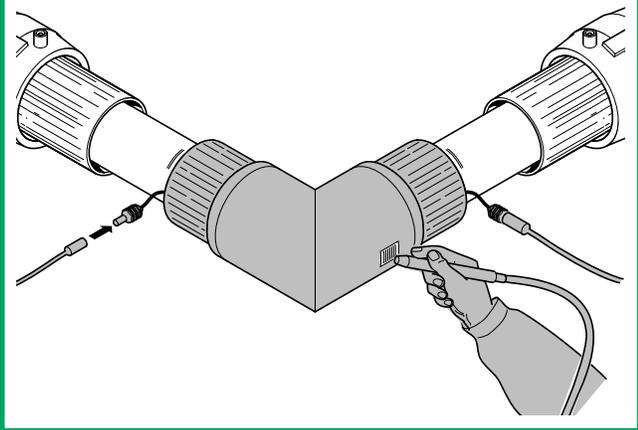


Insert the primary pipe inside the fitting to its complete stop inside the internal elbow. Check that the pipe reached the complete stop by placing one hand in the opposite end of the fitting and making sure that the insertion length mark has been reached.

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



Fig.10



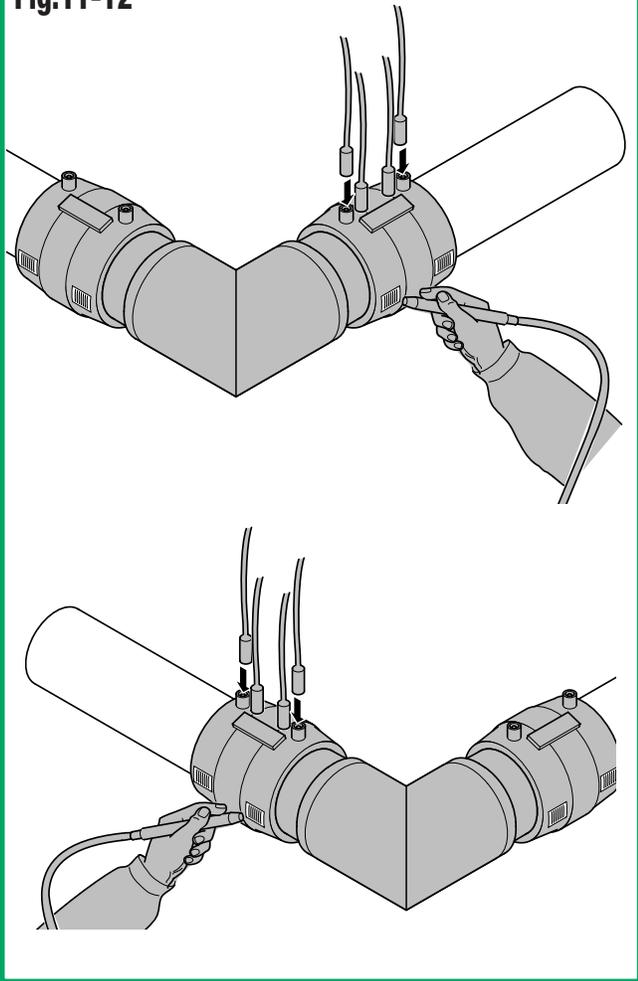
Repeat all the above mentioned steps for the other end of the fitting.

Weld the two primary pipes at the same time (the internal fitting is single-wire) by reading the barcode indicated on the secondary spigot elbow.

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.

Fig.11-12



Slide the electric straight connectors until their complete insertion on the secondary fitting spigot previously scraped and cleaned. Make sure that the insertion length indicated in figure 4 is reached.

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

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.