

- 1 Mark the welding area on the main pipe with a wax crayon or marker.
- 2 Scrape carefully the surface of the pipe and the spigot of the outlet to remove the oxidized PE layer.
- 3 Clean the external surface of the pipe, the spigot of the outlet and the welding area of the saddle with the appropriate cleaning solvent and a soft wiping cloth. Wait until the clean parts are completely dry; mark the insertion depth on the spigot of the outlet.
- 4 Apply the tapping tee on to the pipe watching out not to dirty the previously cleaned surfaces (see fig.1).
- 5 Fasten the tapping tee on the pipe using the **QUICK-COUPLING RIGID UNDERCLAMP**: hook the square holes of the underclamp to the teeth on the upper part; line up the metal spacer and use a wrench to tighten the two screws until they are in position A in the lower part (feel the screws sticking out of the bottom - see fig.2)
- 6 Connect the service line at the spigot of the outlet, following the installation instructions for that specific fitting.
- 7 Connect the two cables of the electrofusion machine to the connectors of the tapping tee (see fig.3). Scan the bar code (see fig.6) with the bar code scanner or enter the welding parameters manually (see fig.5). **ALWAYS CHECK THE WELDING PARAMETERS!**

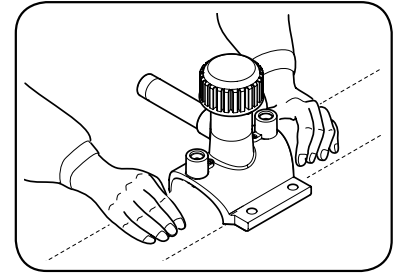


FIG.1

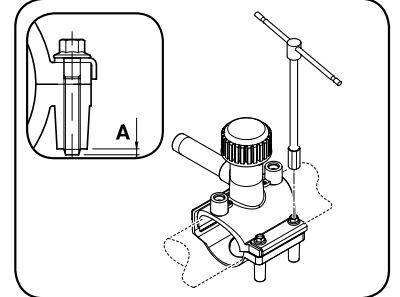


FIG.2

For automatic welding units, always check the welding parameters on the barcode (see fig.6). For manual welding please use the time and voltage indicated on the barcode. If the welding unit does not perform welding time compensation according to ambient temperature, use the parameters in the label affixed on the bag (see fig.5). Keep at a safe distance during welding. The company is not responsible for any damage to persons or property if safety rules are not observed.

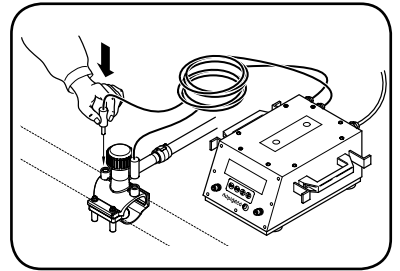


FIG.3

- 8 After completing the welding process, verify that no material has leaked out of the joint between the pipe and the fitting and wait for the completion of the cooling time (20 minutes).
- 9 At the end of the cooling time it's possible to start the pressure test with the Pressure Sensor. In the following table (TABLE 1) you find the recommended waiting time in MINUTES before starting the test.
- 10 When the pressure test is over, remove the top cap and start the perforation of the pipe using the cutter installed in the tapping tee; The CUTTER is designed to keep the coupon inside. Use an appropriate tool (*) to screw down manually the cutter (turn clockwise) until the pipe is drilled, then move back the cutter to the upper position (turn counter clockwise).
 - KEEP THE BODY CLEAR OF THE FITTING DURING THIS OPERATION.
 - DO NOT USE AUTOMATIC DRILLS.
 - DO NOT REMOVE THE UPPER STOPPER.
- 11 After the perforation is complete, replace the top cap and tighten down to the stopper (by tool). The underclamp may be removed or left on permanently.

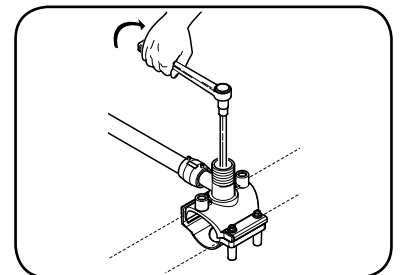


FIG.4

(*) T-KEY WITH HEXAGONAL MALE ENDS OR HEXAGONAL BAR WITH RATCHET WRENCH.

FIG.6 WELDING PARAMETERS

TABLE 1

RECOMMENDED		
WAITING TIME BEFORE PRESSURE TEST START		
Dn pipe inch	P <= 87 PSI	P <= 348 PSI
1" 1/4 - 2"	cooling + 20'	cooling + 30'
2" 1/2 - 12"	cooling + 20'	cooling + 60'

FIG.5 MANUAL WELDING PARAMETERS

EIOFIT MADE IN ITALY 21/10/2011

12.....

00 V - 000s
Cooling time 00 min.
Branch Saddle

< 5°C	>= 5°C < 15°C
... S	... S
>= 15°C < 30°C	> 30°C
... S	... S

00000000000000000000000000000000

U-00000

XXX000 - 00v - 000s - c.t. 00 min

950512154003400646919554

Traceability code
A 035662

3503315001706017060503398

XXX00:	FITTING CODE
00v:	TENSION
000s:	WELDING TIME
c.t. 00 m:	COOLING TIME

ATTENTION! NEVER PERFORATE THE PIPE BEFORE COMPLETING WELDING.

RECOMMENDATIONS FOR THEIR DISPOSAL: POLYETHYLENE USED FOR THIS ACCESSORY IS RECYCLABLE: DISPOSE THROUGH AUTHORISED CENTRES. DO NOT DISPERSE WRAPPING AND PACKAGING OF THE PRODUCT, RECYCLE THROUGH COLLECTION.