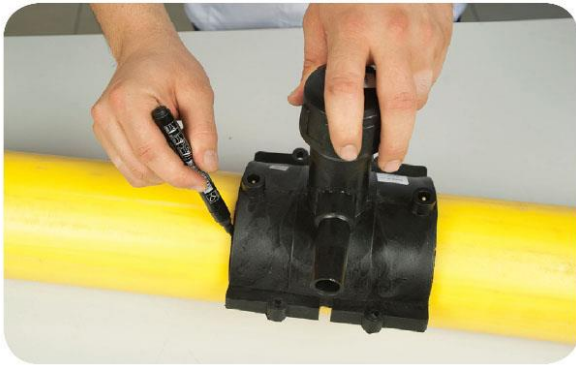


## EF ROTATABLE TAPPING TEE INSTALLATION INSTRUCTION

### 1. The marking of welding zone on the pipe and cleaning the of oxidised pipe surface:

Welding zone: Different from the couplers, in Tapping Fittings, Fusion Zone is the area where the resistance wires exists and which is located to the upper side of the fitting Before scraping, fusion zone must be marked with a marker on the pipe(Fig.1)



(Fig. 1)



(Fig. 2)

In order to remove the oxide layer, scrape carefully the whole circumference of the fusion zone using a hand scraper (Fig.2). This scraping operation must be carried out just before jointing.



**Attention**

In order to remove the oxide layer completely, the pipe must be scraped so that shavings are formed and marking line is removed. This operation ensures removal of oxide layer, which may cause unsuitability for the jointing. The prepared surface must be protected against unfavorable weather conditions.

### 2. Degreasing of the Fusion Zone:

The prepared pipe and internal face of fitting must be degreased with a suitable cleaning agent and a white absorbent and nonfibrous paper. (Fig.3)

As a cleaning agent, isopropyl alcohol can be used. (The alcohol content mustn't be less than 96% by volume).



(Fig. 3)



Degreased surfaces must be protected against dirt or unfavorable weather conditions.

### 3. Attaching Tapping Tees:

After correct positioning is done on the prepared pipe, fitting is closed and fully tighten four screws uniformly by using a suitable screwdriver (Fig.4)



(Fig. 4)

**4. Fusion:** Provided that the information given in the operating instructions are followed step by step and there is no problem, the fusion process can be started after fusion data of the tapping fittings is set to the fusion control unit by manually or by means of bar-code reader (Fig.5).



(Fig. 5)

## EF ROTATABLE TAPPING TEE INSTALLATION INSTRUCTION



### Attention

Please use an universal welding machine. If any error occurs during the welding operation, the melt PE material can slosh into the operation area. Because of this reason, please be careful about standing at least 1 meter far away from the welding area. The cooling times must be waited before the drilling of the branch ducts of Tapping Tee. The cooling times are shown on the barcode labels those are attached on Tapping Tee.

### 5. The EF fusion of rotatable tapping tee:

- a. The branch duct of tapping tee which has no socket pin but with a wire connection on the body, the socket connection is done as seen the picture below (Fig. 6)



Fig. 6

- b. After branch duct rotation is fixed, apply a pressure on tapping tee with minimum 15 kgs weight (Fig. 7)



Fig. 7

- c. The EF welding is done by reading the barcode as per described in step no. 4 above. (Fig. 5)



(Fig. 5)

## EF ROTATABLE TAPPING TEE INSTALLATION INSTRUCTION



### Attention

Please use an universal welding machine. If any error occurs during the welding operation, the melt PE material can slosh into the operation area. Because of this reason, please be careful about standing at least 1 meter far away from the welding area. The cooling times must be waited before the drilling of the branch ducts of Tapping Tee. The cooling times are shown on the barcode labels those are attached on Tapping Tee.

### 6. Carrying out the tapping operation:

The cap on the tapping fitting is first unscrewed and put somewhere it cannot become soiled. After that, by means of a suitable hexagon wrench, the integral cutter is screwed down. **(Fig. 9)**



[Fig. 9]