

IMPORTANT NOTES

- The pipes must be within tolerance range according to standard.
- The fusible pipe series are shown in the SDR labeling on saddle.
- Installation technician must be trained and certified
- Fusion with other pipe materials such as PP, PVC etc. is not possible
- Installation can be done at ambient temperatures between 0°C and +45°C . If the ambient temperature is not within these limits, use of welding tent is required.

TOOLS AND EQUIPMENTS NECESSARY FOR INSTALLATION



Screwdriver



Marker



Scraper



Punch



Welding Machine



Cordless Screwdriver

- Cleaning agent (eg. isopropyl alcohol)
- Lint free towel/paper
- Welding tent

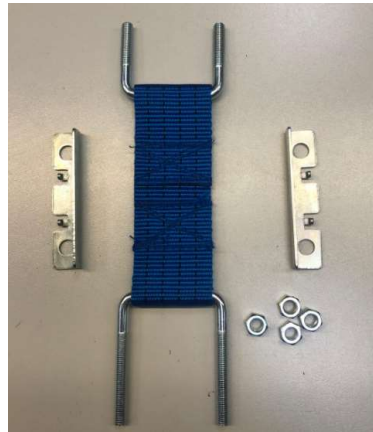
*Squeezing Strap should be at least 35 mm wide and has a capacity of 2.000 daN

EF SADDLE INSTALLATION INSTRUCTIONS

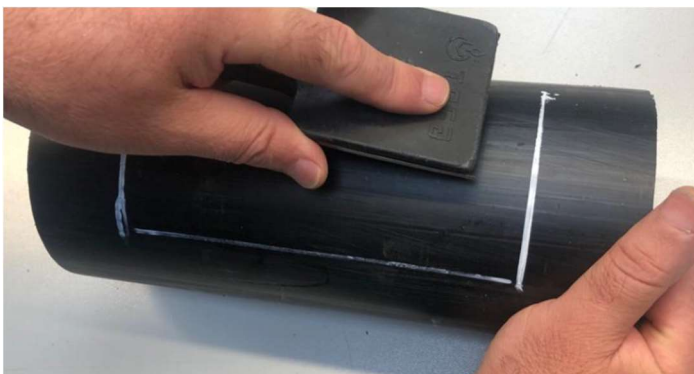
*** WITH BOTTOM CLAMP PE100 ***



1. EF Saddle and other installation tools are set up. Different from the couplers, in Saddle Fittings, Fusion Zone is the area where the resistance wire 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.



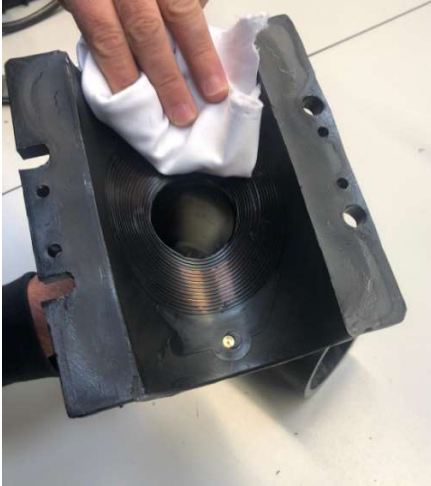
2. In order to remove the oxide layer, scrape carefully the whole circumference of the fusion zone using a hand scraper (Fig. below). This scraping operation must be carried out just before jointing. The prepared surface must be protected against unfavorable weather.



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4. The prepared pipe and internal face of fitting must be degreased with trichloroethane or alcohol (alcohol content must be at least 96% by volume), with a white absorbent and nonfibrous cloth.



5. After correct positioning is done on the prepared pipe, the fitting is closed and fully tightened with two bolts uniformly by a suitable wrench.

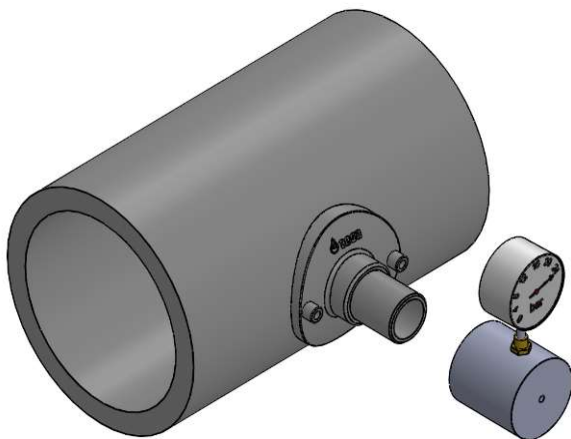




6. The contact terminals of the coupler must be easily accessible. The electrofusion control box is connected to the fitting and to the power source. Electric current is applied to the fitting as specified in the manufacturer's instructions. Read the barcode which is supplied with the electrofusion fitting. If barcode reader can not read the barcode automatically then the parameters can be entered to the machine manually. As a safety precaution, it is advised that people stay at least 1 m away from the fusion area. If the fusion process is interrupted for any reason (e.g. due to power failure) the fusion process can be repeated after the joint cooled adequately. The cooling times can be found on TEGA fittings' barcode labels.



TEST FOR SAFETY



Testing the fusion of saddle before drilling main pipe:

The fusion area must be tested before drilling the main pipe. Before doing this, service line should be connected to saddle. Apply test pressure and ensure that there is no leakage. The test is applied after cooling time is elapsed.

1-2 Bar/3 mins. with air. Controlling by foam.



7. After test, the saddle is drilled by using a punch or proper drilling machine and the branch is taken.