ELECTROFUSION SADDLE WITH FEMALE NPT NO LEAD BRASS THREADED OUTLET INSTALLATION INSTRUCTIONS

IMPORTANT NOTES

- PPI MAB requires the use of re-rounding clamps to remove pipe ovality.
- EF fusibility to pipe series as indicated on the barcode label.
- Installation technician must be trained and certified in electrofusion.
- Installation can be done at ambient temperatures between 32°F (0°C) & 107.6°F (45°C) . Use of welding tent may be necessary.

TOOLS AND EQUIPMENT FOR INSTALLATION

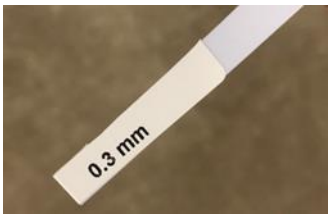
Saw

Marker

Pipe Peeler

Drill

Installation Cable

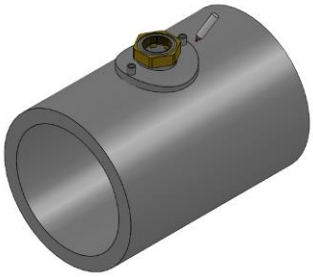


0.3mm thickness Gap Gauge

Re-Rounding Clamp

- Isopropyl alcohol 96% alcohol minimum
- Lint free cloth or paper towel
- Welding tent

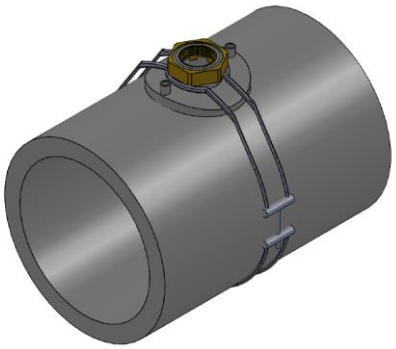
ELECTROFUSION SADDLE WITH FEMALE NPT NO LEAD BRASS THREADED OUTLET INSTALLATION INSTRUCTIONS

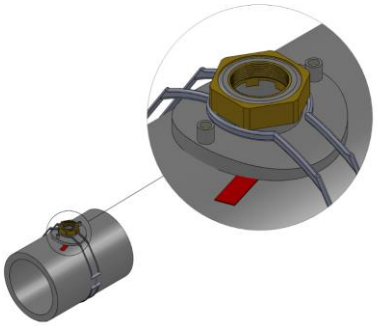


1. Place the EF Saddle on the welding point of pipe and mark exterior circle.

2. Scrape the pipe inside the circle to remove the oxidized layer on the pipe. Clean the area after scraping with isopropyl alcohol containing a minimum concentration of 96% alcohol. Saddle fusion pad must also be cleaned with isopropyl alcohol containing a minimum concertation of 96% alcohol prior to installation. Attach the EF saddle on the pipe (as seen in the picture). Tighten the saddle onto the pipe by using installation cable. Be sure that the internal diameter of EF saddle is on the top of the hole in the pipe.

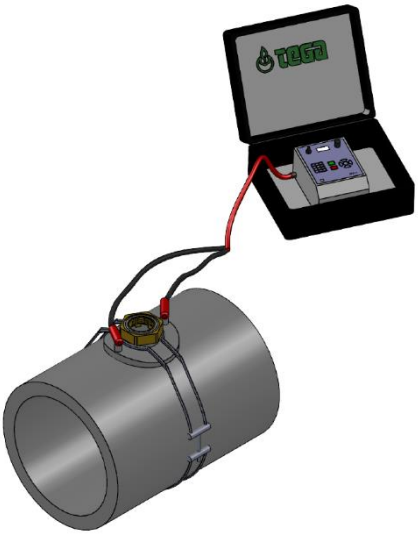
Check the gap between pipe and saddle by using a gap gauge. The gap should be no more than 0.3mm.





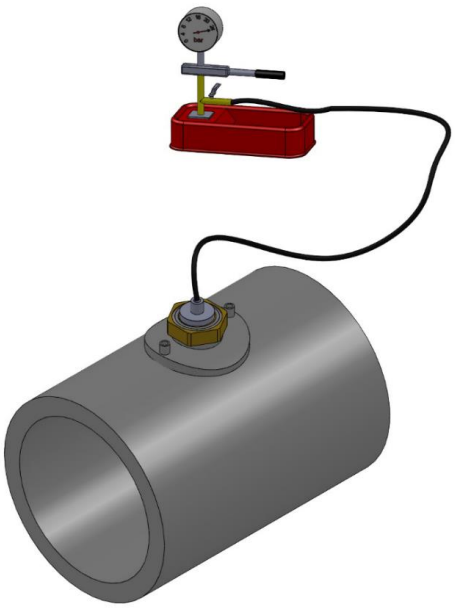
3. Attach the leads from the EF Processor and scan the barcode. After electrofusion welding is completed, do not move the pipe assembly or strap system until the cooling time has elapsed..

   You can remove the strap system after the complete cooling time has elapsed.



ELECTROFUSION SADDLE WITH FEMALE NPT NO LEAD BRASS THREADED OUTLET INSTALLATION INSTRUCTIONS

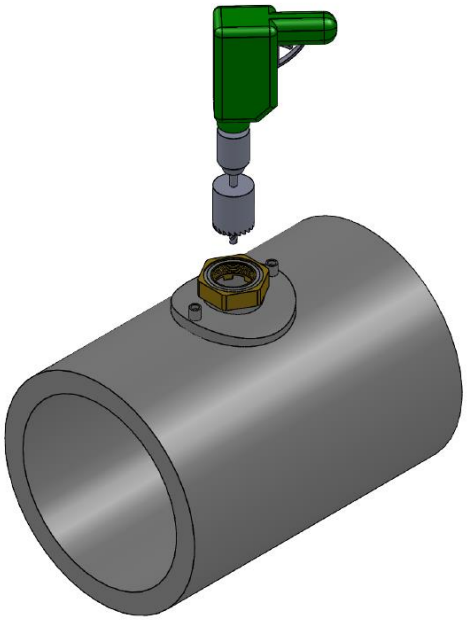
TEST FOR SAFETY



Test the fusion joint of the saddle prior to drilling into the pipe:

The fusion joint must be tested before drilling into the pipe. Apply test pressure and ensure that there are no leaks. ***2x the cooling time period must elapse prior to performing the pressure test. Use Teflon tape to attach the test pump kit to the threaded outlet of the saddle and continue tightening with a wrench until sealed.***
The test pressure is calculated as – operating pressure (main pipe pressure – not to exceed the maximum operating pressure of the saddle) x 1.5 for 10 minutes.

4. After test, the saddle is drilled by using a punch or proper drilling machine and the coupon is removed.



Note : The hole can only be drilled after cooling time and pressure test have been completed. Use extreme caution so as to not cause damage to the saddle.