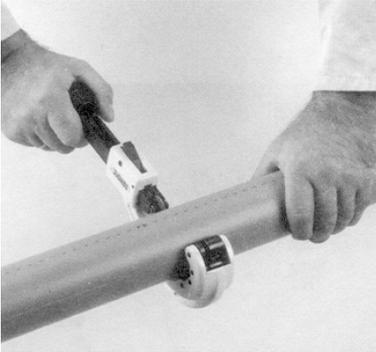


## **+GF+ Electro fusion welding**

***FLEXALEN - Pipe system  
with oxygen-barrier  
(PB pipes - red)***



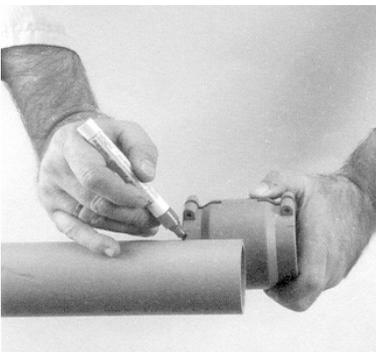
**ATTENTION:  
Assembly instruction only for  
T-SCRAPER25-90**



#### 1. Cut pipe to length

Cut off pipe with wheel cutter for plastic pipes.  
Only use wheel cutter.

Do not chamfer pipe ends.



#### 2. Mark insertion depth

Mark insertion depth on the pipe.  
Insert depth guides are marked on the fitting.

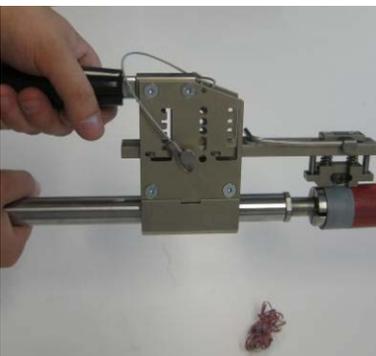
**Do not use wax pencil!**



#### 3. Insert gauge

Insert gauge until fence.

**For a detailed description of the scraping process please see:  
Installation instruction SCRAPER Type T-SCRAPER25-90A  
or T-SCRAPER16-25S.**



#### 4. Scrap the pipe end

Scrape by turning the scraper gently clockwise. Remove chips regularly.

When reached the marking, lift the knife arm and remove the scraper.

Remove gauge by lugging the slugging part against the stopper.

**For a detailed description of the scraping process please see:  
Installation instruction SCRAPER Types T-SCRAPER25-90A or  
T-SCRAPER16-25S.**

- 5. Clean the pipe end and the internal welding area of the fitting**  
Pipe ends and the internal welding areas of the fitting must be **clean and free from grease and oil.**

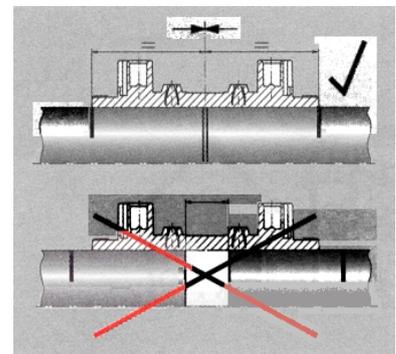
We recommend **Tangit cleaner for PB.**

In case of need mark the insertion depth on the pipe again.

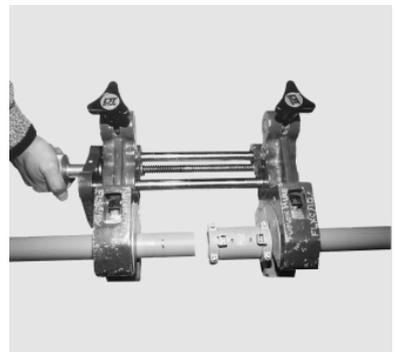


- 6. Insert one pipe end into fitting and fix it**  
Insert the pipe into fitting as far as the insertion mark.

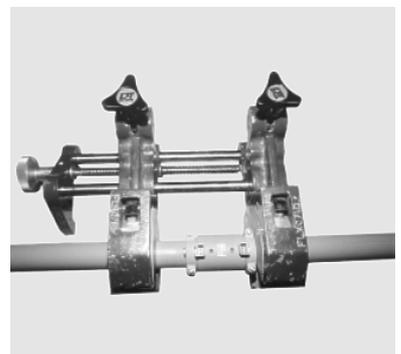
**DO NOT TIGHTEN THE FITTING BOLTS!!!!**

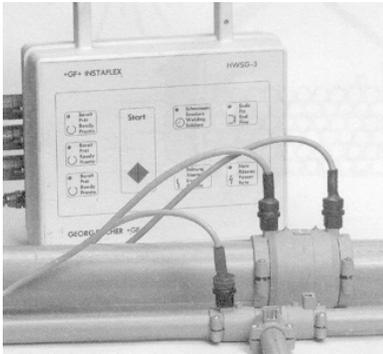


- 7. Fix and tighten alignment clamps**  
Fix and tighten alignment clamps.  
Ensure fitting is tight against one clamp face.



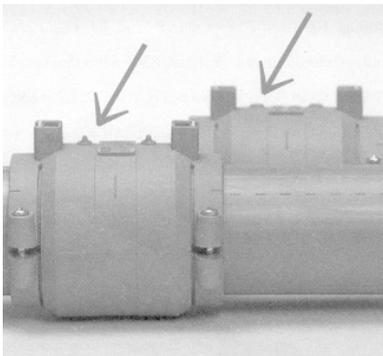
- 8. Wind clamps**  
Wind in the clamps, introducing the exposed pipe end into the fitting, up to the depth of insertion mark.





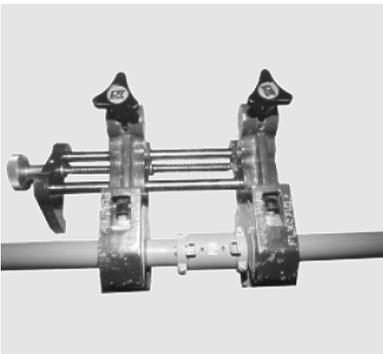
### 9. Execution of fusion

Connect the fusion unit to the main power supply.  
Insert fusion cable in the fitting or fittings.  
Start the fusion operation by pressing the **START**-button.  
Fusion process runs automatically.



### 10. Fusion check

The optical fusion check is verified by appearance of the welding indicators.



### 11. Allow fitting to cool

Allow fitting to cool according to the cooling time before removing the alignment clamp.

**max. ambient temperature: + 5° C up to +40 ° C**

Dimension OD [mm]	Insertion depth [mm] Socket	Insertion depth [mm] Elbows, Tees,...	Welding time [sec.]	Cooling time *) minimum [min.]
16	27	38	37	15
20	30	40	47	15
25	34	42	55	15
32	37	42	70	15
40	40	47	120	15
50	44	49	145	15
63	50	51	180	15
75	67	67	150	15
90	74	74	200	15
110	80	80	210	15

\*) The cooling time has to be increased to 20 minutes at temperatures over + 30° C.