

USER'S INSTRUCTION OF HEAT FUSION LINING PROCEDURES

JOINING PROCEDURE

1. Set-Up parameters

Heating Tool Surface Temperature. Heating tool surfaces must be up to temperature before fusion begins.

2. Secure

Clean the inside and outside of the component (pipe or fitting) ends by wiping with a clean, dry, lint-free cloth or paper towel.

3. Face

Place the facing tool between the component ends, and face them to establish smooth, clean, parallel mating surfaces.

4. Align

Bring the component ends together, check alignment and check for slippage against fusion pressure.

5. Melt

Place the heating tool between the component ends, and move the ends against the heating tool.

6. Join

Immediately after the heating tool is removed, quickly inspect the melted ends. If the melt surfaces are acceptable, bring the ends together and apply the correct joining force.

7. Hold

Maintain fusion gauge pressure until the joint is cool.

8. Inspect

On both sides, the double bead should be rolled over to the surface, and be uniformly rounded and consistent in size all around the joint.

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WARNING

- Check processor Operation Manual for electrical requirements & operating instructions.
- Make sure processor is grounded properly prior to use.
- Check all markings on pipe to make sure it is certified to industry standards prior to performing heat fusion.
- Clamping device must remain in place during the recommended (clamp) cooling time in training manual.

NOTICE

To assure the joint quality of this Heat fusion fitting, the operator must follow established joining procedures. Complete and total instructions for procedures can be found in the COSMOIND Training and Qualification manual. As a qualified Heat fusion Operator, you should have one of these manuals in your possession and be totally familiar with the instructions. For additional copies of the manual, contact COSMOIND. For assistance call COSMOIND at (336) 270-4333 or www.cosmoindusa.com

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