

## User guide for “Electrofusion jointing procedure for tapping saddles”

**Important : This guide is given as an "illustration only" of the equipment being used, and locally enforced operating procedures should always be used.**

Leave the fitting in its protective polythene bag and place it onto the pipe, in the position where it is to be welded. Mark its outline on the pipe using a felt tip pen.

Remove the fitting and place it in a safe place. Scrape the surface of the pipe within the marked area to completely remove the surface layer.

Prepare the clamp by rotating the handle anti-clockwise to screw the loading cell up to the arm/body of the tool. This will allow the maximum amount of thread to load the fitting.

Remove the tapping saddle from its bag, and remove all of the packaging. Unscrew the threaded cap from the top of the stack. Check that the cutter head is sitting flush with the top of the stack.

Press the hexagonal locating pin on the underside of the loading cell into the hexagonal hole in the top of the saddle cutter. Push it fully home.

Lower the fitting down on to the prepared area of the pipe.

**Strap Clamp:** Guide the straps under the pipe and back up through the clamping slots in the body of the tool. Pull the straps tight and lock up the clasps to grip the straps. Turn the main handle clockwise and the fitting will start to be pushed onto the pipe. The straps will tighten fully and the load cell will start to compress.

**Pillar Clamp:** Move the arm of the tool down the pillar until the fitting is touching the pipe. The vee shaped base will rotate to allow the tool to twist on the pipe and take up less width in the trench. Turn the main handle clockwise and the fitting will start to be pushed onto the pipe. The arm will tilt backwards and lock onto the pillar. The load cell will now start to compress.

Continue to turn the handle clockwise until the locating peg in the middle of the handle moves up and flush with the surface of the handle. The saddle is now loaded at the correct pressure (1500 Nm).

Carry out the electrofusion process as normal.

To remove the tool, turn the handle anti-clockwise to release the pressure. Either pull the arm upwards or release the strap catches and pull the straps through the tool.

When the clamp has been removed, the service pipe can be welded to the saddle outlet.