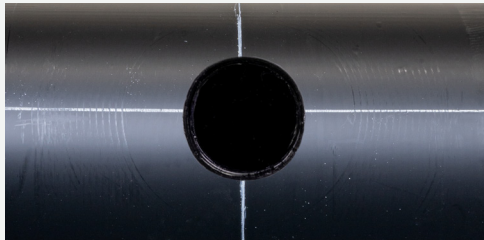


## Installation Instructions for PLASSON Electrofusion Large Repair Saddle

- Install only with PLASSON clamping tools for large bore saddle, outlet 400mm:
  - Tensioning tool kit (straps & ratchets & torque wrench) for large branch saddles, outlet  $\geq 180$ , item no. (2914) 4.4701.009
  - Clamping kit (splitable & pressing plate) for 355/400mm outlet – item no. (2914) 4.4701.400
- Maximal damaged area length/diameter: 230mm

1



Mark the position of the saddle by two long lines across the center of the damaged area.

2



- Keep saddle inside the bag
- Place the saddle over the damaged area, Mark the area to be scraped 10mm larger than the perimeter of the saddle
- Scrape and clean the pipe
- Scrape twice if manual scraper is used

3



Disassemble the strap from the "pressing plate"

4



- Place the saddle on the pipe
- The center of the saddle should be positioned over the center of the cross
- Place the clamping plate for 355/400mm outlet over the saddle
- Fit two straps and tighten

5



- Fit the strap disassembled in step 3 and place it over the center of the saddle
- Tighten all straps gradually, first by spanner, then use the torque wrench, set to 400N X m to apply correct tension
- Weld the saddle

400 N x m

6



- Remove the straps only after cooling time has elapsed
- To release, slightly tighten the strap using the torque wrench, and with the other hand, lift the stopper plate using the special tool provided and release tension gradually
- Wait 3 X cooling time to apply pressure

Ambient Temp		Welding Parameters for Manual Input	
F°	C°	Time (Sec)	Voltage (Volt)
14-32	-10-0	1300	40V
33-50	1-10	1200	
51-68	11-20	1100	
69-113	21-45	1050	