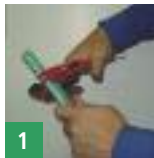




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IPS FUSION SYSTEM



1

Cut perpendicularly to the axis of the pipe. Remove any swarf or burrs. Pipes whose diameter is up to 32mm can be cut with a cutting tool, above that size use a saw.

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2

Clean and dry the pipe and fitting completely before welding.



3

Mark the welding depth of the nozzle on the pipe according to Table 1.



4

If MAXUM pipes are used, mark and cut the thermoplastic foam with a cutter before welding.



5

Introduce pipe and fitting simultaneously (thermoplastic welder at 260°C). Apply pressure (do not twist) until welding depth is

reached without exceeding the marks. Hold together and let it cool until cooling time in Table 1 has been met.



6

Insert the pipe into the fitting until the melt rings in each piece come together. Small adjustments can be made up to 3 seconds after pushing has finished.

Diameter	Penetration	Heating time
20 mm	1,20 cm	5 seconds
25 mm	1,30 cm	7 seconds
32 mm	1,45 cm	8 seconds
40 mm	1,60 cm	12 seconds
50 mm	1,80 cm	18 seconds
63 mm	2,40 cm	24 seconds
75 mm	2,60 cm	30 seconds
90 mm	2,90 cm	40 seconds
110 mm	3,40 cm	58 seconds

Table 1. Nozzle penetration depth and necessary heating time.