

Socket Fusion Fitting Installation Manuel

Features:

- Quick and easy installation
- Small size, saving lots of space
- Pressure resistance 25kgf/cm²
- Applicable pressure 10 kgf/cm²

Steps:

1



Install the welding head on the welding machine and heat it up to 220°C

2



Connect the pipe with the fitting and insert into the welding head. Apply pressure to reach a certain depth (as shown in the table below)

3



Quickly remove the heater and pressurize the two ends to be joined. After it is completed, check the appearance.

Reference guide

Step		(1)	(2)	(3)	(4)	(5)
Temperature 220 ^o c±10 ^o c	Size	Heat and pressurize to reach a certain depth (mm)	Heating time (sec)	Remove the heater (sec)	Pressurize and weld (sec)	Check
	20-25	15	10	Within 5 secs	At least 30 secs	At least 3 mins 45 secs
	30	15	15			At least 3 mins 50 secs
	40	20	20			At least 3 mins 55 secs
	50	20	26			At least 4 mins
	65-75	25	30			At least 4 mins 5 secs