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## Series 415 Fusion Installation Guidelines

- Fusion equipment and tooling must be properly sized and in good working order. The surface of the tooling should be undamaged and clean. The heater equipment should operate at proper fusion temperature.
- The fusion operator must be trained in the operation of sidewall fusion equipment and procedures.
- Both surfaces of the HDPE pipe (convex side) and 415 series saddle (concave side) must be clean and prepared. It is recommended to use a 60 grit or coarser utility cloth or a mechanical scraper. **Do not use sandpaper.** Always brush away residue left behind from the utility cloth.
- Align the fitting on the main and tighten the clamp in the pivot head.
- Check surfaces of heater equipment to ensure that it is clean. Preheat heater equipment to the operating temperature for the installation:

PE 3408/3608	500-525 °F (260-274 °C)
PE 4710	490-510 °F (255-265 °C)
- Position the heater equipment between the main and the saddle. Apply adequate and uniform pressure until continuous melt bead can be seen on the main. A label on the fitting will provide the proper initial heat force, heat soak force, and fusion force. Example: 350/0/125
- When the melt bead is achieved, reduce the pressure to "0" for the duration of the heat soak time cycle.
- Once the heat soak cycle is complete, remove the heater equipment. Rapidly and smoothly bring the fitting to the HDPE pipe main. Apply the desired pressure until the proper fusion bead is formed. Maintain pressure until the joint is cooled. **Allow 30 minutes for cooling time before pressure testing.**

Reference information:

PPI Report TR41 and ASTM F2620-13: Section 9