



Friatec Top Loading Technology Basic Instructions



Step 1: ensure pipe is clean prior to scraping and marking of fitting

Step 2: Mark fitting, firstly around Fusion Zone covered where the saddle is to go. 2nd mark the internal area of fusion zone.

Step 3: Scrap the fusion zone removing the oxide layer (min .15mm) where the saddle will be fused.

Step 4: Clean scraped area of pipe and fusion area of fitting with 99.8% Alcohol lint free wipes. Ensure fitting is kept in the bag until required. Once cleaned do not touch fusion areas with hands.

Step 5: Place fitting on pipe outlining witness marks as these would have been removed during scrapping.

Step 6: Choose correct adaptor for fitting and attach

Step 7: Attach Top Loading unit ensuring unit is straight on fitting and adaptor is correctly inserted into plastic housing.

Step 8: Attach Tension Belt around pipe and connect through ratchet rollers on the Twist Grip. Pull the belt tight and turn the Twist Grip Clockwise until stop. If necessary make final correction to saddle.

Step 9: Attach Pump to Valve and proceed to pump to 4bar (Pipes >315d require slow action Pumping allowing PE saddle to settle, low temperatures also require slow action Pumping) Pump 1bar at a time to ensure PE saddle is relaxing.

Step 10: Visual check, The Gap between Saddle and pipe must be completely closed by the pressure applied. (If gap is to big release pump and valve and repeat steps 8-10 tightening tension belt tighter before pumping again)

Step 11: Detach pump, ensure visual reading on tension number throughout process to check any fall of pressure.

Step 12: Fuse fitting in accordance with Friatec Fusing instructions.

Step 13: Document date, fusing time and Cooling time on pipe.

Step 14: After fusing has completed leave the Top Loading unit pressure on the fitting for another 15 minutes.

Step 15: Remove Top Loading unit and observe cooling times until moving fitting or pressurising system.

Please contact Friatec Technical Team Petr Sudoma +64274963700 or Ryan Kerr +64277064226 for further installation details

