

TECHNICAL DOCUMENT JOINING METHODS

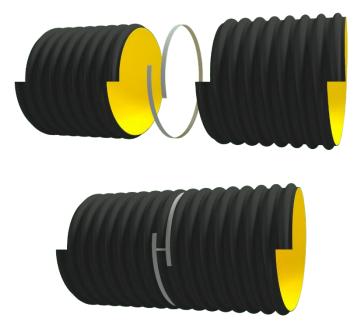
ELECTROFUSION BAND WELDING INSTRUCTION



TECHNICAL DOCUMENT

JOINING METHODS ELECTROFUSION BAND WELDING INSTRUCTION

ELECTROFUSION BAND WELDING MANUAL



Electrofusion band welding joining is a welding method formed by melting-cooling of outer surface of spiral corrugated pipe and inner surface of EF band at the connection line by PE band with on resistance and electrofusion welding machine.

Required Equipment



1. Reciprocating Saw



2. Electrofusion Welding Machine



NEOPLAST

TECHNICAL DOCUMENT

JOINING METHODS ELECTROFUSION BAND WELDING INSTRUCTION

General Conditions

- Worker safety precautions should be taken during the operation.
- The ambient temperature of assembly area should be 0°C- 45°C. If the ambient temperature is not within limits, use a welding tent
- Welding area should be protected from sunlight and dirt. The ambient temperature of the welding should be 0°C and above. Welding is not recommended at below 0°C ambient temperature.
- Welding is not recommended in rainy weather.
- PE material should be used in the application.
- Pipe parts and electrofusion band surfaces should be clean.
- Inner metal hoop should be used in the pipe welding.
- Outer metal belt tension should be checked during pipe welding.
- Welding machine values should be set before starting welding.
- The connections between the EF band cable lug and electrofusion machine cable alligator clips should be connected carefully. The connection should not be broken during welding.

Application

1. The end of pipes are cut to fit each other by reciprocating saw.



2. EF band and pipe surfaces are cleaned before starting the welding.

NEOPLAST

TECHNICAL DOCUMENT

JOINING METHODS ELECTROFUSION BAND WELDING INSTRUCTION

3. Inner metal hoop is placed to inside joint of the two pipes and is fixed. Centering is done.



4. The pipes are rotated until the to pipes ends come together.



5. Electrofusion band is wrapped around connection line of the two pipes with outer metal belt.a. EF band is wrapped around pipes between the rips.



b. Outer metal belt is wrapped over EF band.





TECHNICAL DOCUMENT

JOINING METHODS ELECTROFUSION BAND WELDING INSTRUCTION

c. Outer metal belt is stretched by ratchet strap.



6. Welding machine cable alligator clips are connected to electrofusion band cable lug. Electricity is supplied by preset welding machine.



- 7. Welding period is visually checked.
- 8. When the welding time is finished, the welding machine cable connections are disconnected.
- **9.** The hand extruder is heated. Ø4 mm PE welding rod is placed into slot. Joint gaps is filled by the hand extruder.



10. Inner metal hoop is removed from the pipes.

NEOPLAST

TECHNICAL DOCUMENT

JOINING METHODS ELECTROFUSION BAND WELDING INSTRUCTION

- **11.** The joint gaps of inner the pipe is filled by hand extruder.
- **12.** The welding area is visually inspected. If joint gap is detected, it is filled by hand extruder.
- **13.** After welding and filling process is completed, wait min. 30 minutes for cooling.

*Welding times values are given by calculating the average, it can change completely with weather conditions. *The information provided is for informational purposes only. Unapproved applications are not the responsibility of our company.

NEOPLAST

© 2020 NEOPLAST GRUP BORU ve PLASTİK SANAYİ TİCARET LTD. ŞTİ. The user may reproduce, distribute or transmit this copyrighted document, document titles, footers, legal notices and all other information provided that they are complete and not modified. Publishing this document on a web page is strictly prohibited. NEOPLAST does not guarantee typical values. The information in this document relates only to the named product, although it is not mixed with different materials. This document has been prepared on the basis of data believed to be reliable at the time of its preparation. NEOPLAST can update the data in this document, add new information to the document or extract information from the document at any time without warning users. NEOPLAST expressly declares that it will not accept any liability for any loss, damage, indirect or consequential injuries that may arise or result from relying on or relying on information in this document.