






The Steel Grout Port Fixing operation manual is provided to fix HDPE Grout Ports to corrugated PT steel duct. The fixing device consists in 3 parts (welding machine, drill tool and spread tool). In addition you might use a wood block for intermediate storage of heated welding equipment.

1.	Insert the drill tool to a standard drilling-machine and drill a hole into the steel.	
2.	Set Temperature Control Unit of the welding machine to 260°C and connect it to the power supply. Check if you have 110V or 220 V equipment first. Red control light is flashing and turns off when 260°C Temperature is reached and heating tool is ready for welding. Fix welding machine or use wood block to avoid burning other materials.	
3.	Press the PE Grout Port by hand into the female tool part by part up to the marking and rest for 60 seconds in total.	
4.	Remove the Grout Port out of the tool and press by hand without turning into the drill hole up to the marking. Keep it fixed by hand and push spread tool through the grout port hole in full depth and hold on with low pressure for 10 seconds for perfect fixing. Fixing is finalized	