



The welding equipment consists of 2 parts (welding machine and drill tool). You might use a block of wood for intermediate storage of heated welding equipment.

The grout ports can be used for

- corrugated PES.TEC pipes IP-1, IP-2, IP-3, IP-4, PT Plugs, GTI and others
- corrugated anchor duct PESTEC CIC 1, CIC 2, CIC 3, CIC 4, CIC, CIC 6, SIC, SPC
- smooth PESTEC EP 1 and all other of smooth ducts.





The grout ports are available in HDPE and PP material with 21/28 vent pipe thread as well with NPT thread.

PP Grout Ports are grey.

HDPE Grout Ports are black.

HDPE and PP parts / pipes are not weldable to each other!!

Please check the material you weld first!!

1.	Insert the drill tool to a standard drilling machine. Drill a hole of Ø 25mm (1,0"inch) into the pipe using the drill tool.	
2.	Set temperature control unit of the welding machine to 245°C and connect it to the power supply. Check if you have 110V or 220V equipment first. Red control light is flashing and turns off when 245°C temperature is reached and heating tool is ready for welding.	
3.	Use block of wood to avoid burning other materials. Press the conical part of the grout port by hand into the hole of welding tool, part by part during heating up of the conical part until max. depth limited by integrated stop. Duration is approx. 20 seconds only. REMARK: (for welding PES IP1 Duct 158mm only) Take special care that conical part is completely heated to the integrated stop to ensure tightness because of big duct corrugation. Duration might be extend to approx. 25 seconds.	
4.	After 20 (25) seconds insert the welding machine (still including the grout port in the hole of welding tool), with very low pressure slowly into the drilled pipe hole until the white PTFE stop limits the inserting depth. Fully insert the welding machine for 5 seconds only and remove it without turning. Remove the grout port at the same time out of the tool hole.	
5.	Press grout port by hand without turning into the drill hole as far as possible until the limited stop contact the corrugations / smooth pipe and hold with low pressure for perfect fixing for 10 seconds. Welding is finalized.	