

OM 858-1

Operating Manual for Plug Welding

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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 plugs can be used for corrugated PES.TEC pipes IP-1, PES.TEC pipes IP-2 and IP-3, PT Plugs, GTI and others and all kind of smooth ducts.

The plugs are available in

PP grey.

HDPE black or white. Other colours on request.

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

Please check the material you weld first!!

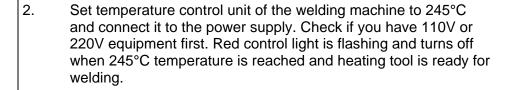


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1. Insert the drill tool to a standard drilling machine. Drill a hole of Ø 30mm (1,2"inch) into the pipe using the drill tool. Clean the surface of the hole from grouting liquid or dust.





3. Use block of wood to avoid burning other materials. Press the conical part of the plug into the hole of welding tool by hand. At the same time insert the welding equipment (still including the plug on top side) with very little pressure slowly into the drill hole and push until max. depth limited by integrated stop.



 10 seconds after the equipment has been fully insertet, remove the welding equipment without turning and also remove the plug out of the equipment.



Press plug by hand without turning into the drill hole as far as possible and hold with low pressure for perfect fixing for 5 seconds.
Welding is finalized.

