



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!!

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



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 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.



4. 10 seconds after the equipment has been fully inserted, remove the welding equipment without turning and also remove the plug out of the equipment.

5. 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.



6. If requested remove welding seam carefully with a knife while it is still in warm condition and cut of the stick of the plug.