



## BUTT FUSION OF DRISCOPIPE 8000 PIPE, TUBING AND FITTINGS

1. Clean each pipe end with a clean cloth.\*
2. Square (face) the end of each pipe to be fused.
3. Check the line-up of the pipe fitting ends. Adjust high-low. Check the heater plate for the proper surface temperature, and clean the face of the heater with a clean cotton\* cloth.

**SURFACE** temperature: 475 degrees F - 500 degrees F

4. Insert the heater plate between the aligned ends and bring the ends firmly into contact with the plate, but **DO NOT APPLY PRESSURE** while achieving the melt pattern. Watch for proper melt. A melt bead of 1/16" to 1/8" is sufficient for 2" pipe. Smaller pipe or tubing sizes require less melted material for proper fusion while larger sizes benefit from slightly more melt.
5. Remove the heater plate after achieving the proper melt bead and quickly examine the heated ends for completeness of melt. If the ends are not properly melted, stop the procedure, remove the melted ends and start over at Step 1.
6. Bring the melted ends together rapidly. **DO NOT SLAM. Apply enough pressure to form a double roll-back bead.**
7. Allow the butt fusion joint to cool properly while maintaining pressure (until your finger can remain comfortably on the bead).

### REMEMBER

Install the proper inserts in the fusion unit for the pipe, tubing or fittings being joined. A quality butt fusion joint has double bead rolled back toward the body of the pipe.

Heater plates should be double checked with a tempilstik or pyrometer for the correct **SURFACE** temperature (475 degrees F - 500 degrees F).

- \* Avoid polyester type materials which melt and stick to heater plates.