



TECHNICAL NOTE

Aldyl-A TAP TEE REPAIR SCRAPER KIT OPERATION PROCEDURES

FAMILY:	ELECTROFUSION
PRODUCT:	10001385/10007584
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SCOPE:

The following operation procedure is intended to be used in conjunction with the Electrofusion Repair Scraper Kit designed specifically for Aldyl-A Tapping Tees or Service Punch Tees that utilize the "black shank thread" cap. Only

BACKGROUND:

Customer requests have indicated a need for an electrofusion repair kit for these tees with damaged internal cap threads. The kit is to be used to repair or retire tees. Fusions have been qualified to the requirements of DOT Title 49 of the Code of Federal Regulations, Section 192.283. Long -term testing on the performance of the tees could not be verified due to premature failures of the tees or saddle fusions in a manner not related to the repair kit. This document is a guide only and should not be used in place of training and qualification by an authorized electrofusion instructor. Installers should be qualified under the requirements of DOT Title 49 CFR Section 192.285.

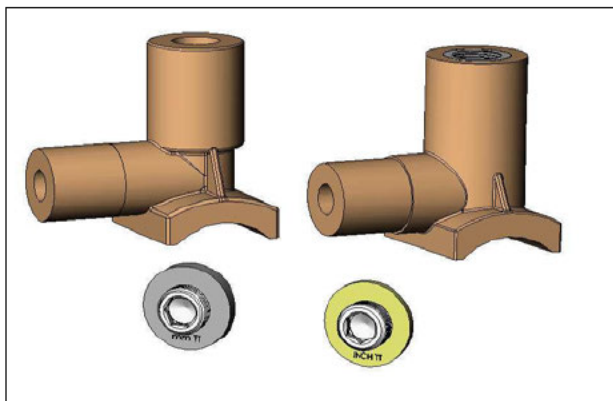
REQUIRED MATERIALS:

Repair Kit:	10001385 (PE2406)
	1 1/4" x 40mm EF Reducer Coupling
	1 1/4" Purge Point
	Lint Free Cloth
	Isopropyl Alcohol

Tools: **10007584 KIT, ALDYL-A TT REFURBISH TOOL; 1.25,IPS,40,ISO**

FUSION PROCEDURE:

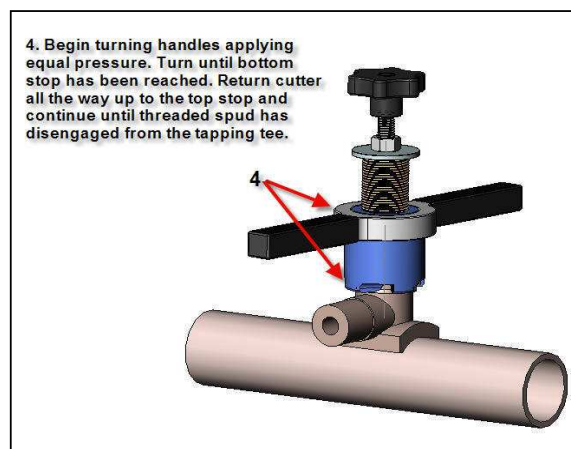
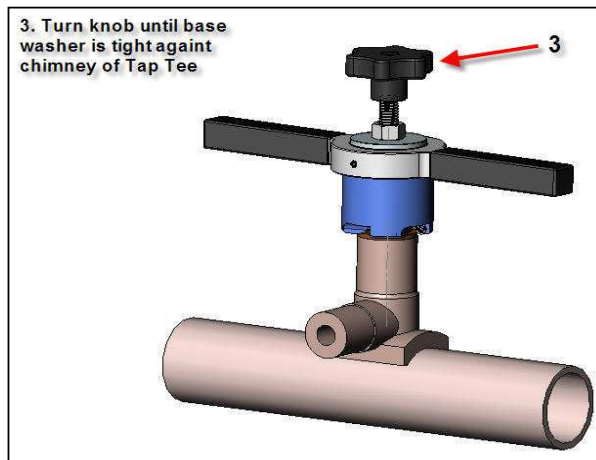
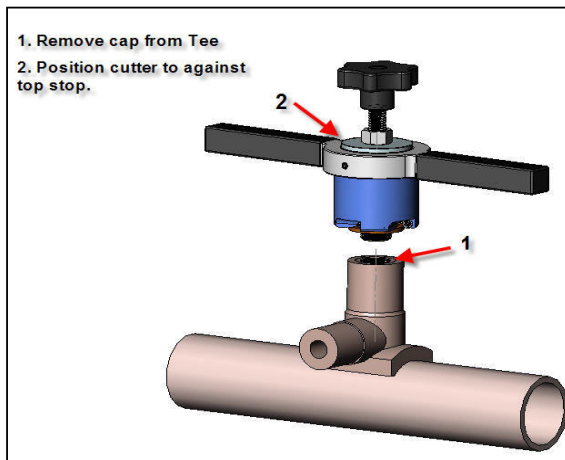
- A Ensure that no gas flow is present through the fitting chimney. If gas flow shut-off cannot be accomplished by threading the punch down into the tap hole, further methods, such as squeeze-off, should be considered. All safety precautions regarding grounding and fusions to live mains should be
- B Determine the correct adapter to install in the cutting tool base. There are two different body styles of the Uponor Aldyl A tap tees. Each body style requires a different adapter. The illustration below shows which adapter works with which body style. The body style on the left requires the adapter with the thicker washer. The body style on the right requires the adapter with the thin washer.



- C Clean the fusion area of the fitting chimney with a lint-free cloth and isopropyl alcohol to remove any contaminants that may be spread during the scraping operation.



- D Follow instructions in illustrations



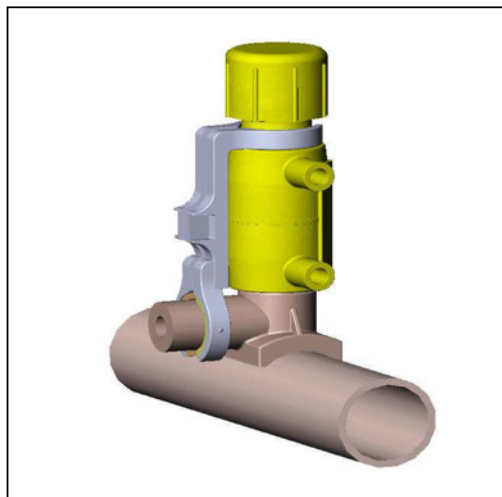
- E Push the 40 mm end of the coupling down over the fitting chimney until the end of the coupling is in contact with the fitting outlet. A small distance between the top of the fitting chimney and the center stop of the coupling may be observed.



- F Ensure that the purge point is inserted only to the center of the 1 1/4" end of the coupling.



- G Place the locking plier clamps so that a grip is achieved on



- H Connect the control box leads to the coupling terminal pins and fuse with normal fusion procedures.
- I Allow the fusion to cool completely before exposing to back-fill or pressure tests. If service is to be restored, remove the plug from the purge point to access the punch. Return the tee punch to the original position. Replace and tighten the purge point cap by hand until it bottoms out.

Note: This document supersedes all previous Technical Notes and is subject to change without notice.

Approved By:



Roger Rutherford

M&I Product Manager