

An instruction of proper preparation of the PUR foam:

1. Component A (smaller bottle with bright colour liquid) shall be carefully decanted to a bottle with component B (bigger bottle with dark colour liquid).
2. This bigger bottle with both components inside, shall be carefully twisted up and strongly mixed by shaking for ca. 15 seconds. The mixture shall be homogenous without any layers and smudges.
3. After mixing the liquid shall be filled into one of the filling hole into the joint.
4. Immediately after filling the PUR into the joint, the holes shall be bunged by impaling the venting plugs. The plugs shall be placed in a way that their "tales" are perpendicularly to the axis of the pipe.
5. After degassing and cooling down of the PUR foam and the joint (min 10-15 minutes), the venting plugs shall be removed, than if needed the filling holes shall be reamed up to 24mm and cleaned, than the welding or expanding plugs shall be installed.

Caution: In case of big size of the joints when sets of 2xA + 2xB components need to be used, their mixing and filling them into both holes of the joint shall be performed simultaneously.

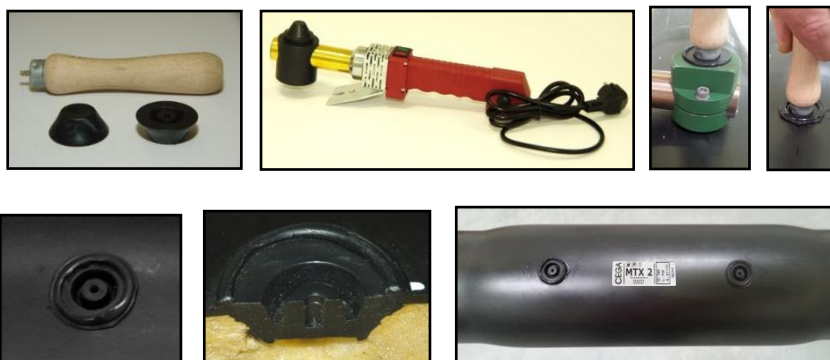


Installation of the welding plugs.

The welding plugs shall be installed according to the welding unit instruction.

The filling holes shall be cleaned before welding.

Parallel heating up of one of the filling hole and one of the plug for 30 sec with 230°C of the heater, and later regular pressing of the plug up to the cooling down of this joint is recommended. Repeat above operation with the second filling hole and the plug.



Installation of the expanding plugs.

The expanding plugs consist of two elements, the bigger one with inner hole and with sealing mastic on its external surface, and the smaller one to be put inside the bigger one for its expansion in the filling hole of the joint. After cleaning of the filling hole the bigger element shall be impaled into the hole and later the smaller element shall be impaled into the bigger element so the entire plug shall close the hole of the joint.

