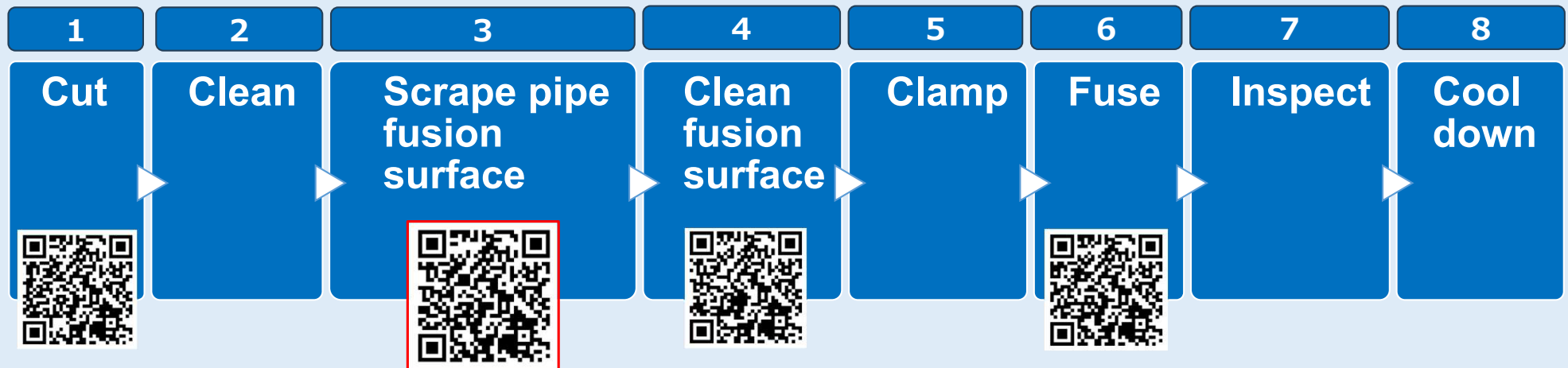


ESLON HYPER AW / EF Fittings

Work Instruction with Key Points



Clarify any unclear points as you proceed.

Check the pages you have been instructed on.

page	1	2	3	4	5	6	7	8
check ✓								

Cut

Clean

Scrape pipe
fusion
surface

Clean
fusion
surface

Clamp

Fuse

Inspect

Cool
down

Cut pipe



Cut perpendicular



90°



Cut angled



>5mm

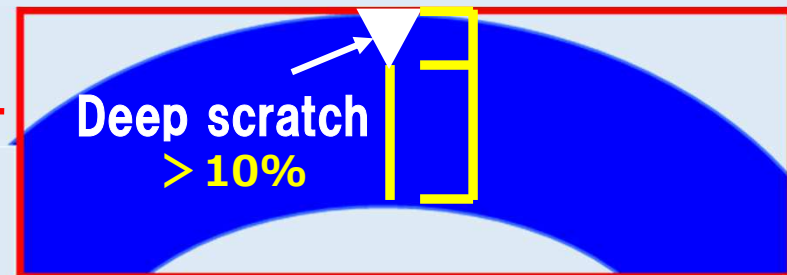
End-to-end difference must be within 5 mm.



Scratch



Do not use pipes with scratches exceeding 10% of the wall thickness.

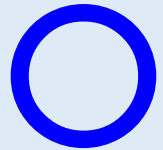


Wall thickness

☐



Clean pipe



Clean



Dirty

☐

Cut → Clean → **Scrape pipe fusion surface** → Clean fusion surface → Clamp → Fuse → Inspect → Cool down

Scrape pipe fusion surface

① Measure insertion depth



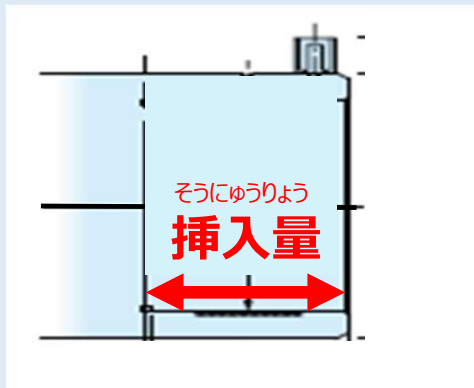
Insertion depth for each nominal diameter

Nominal diameter	Insertion depth
20	40mm
25	42mm
30	46mm
40	46mm
50	52mm
65	60mm
75	65mm
100	80mm
125	90mm
150	100mm
200	140mm

② Mark insertion depth



③ Mark





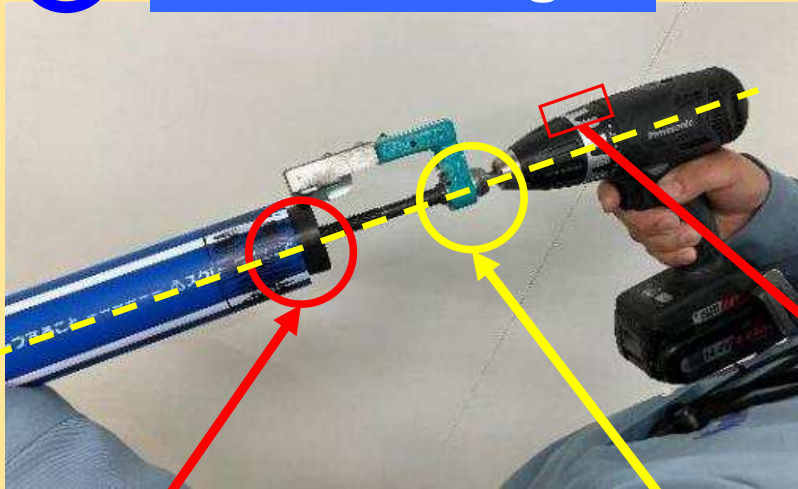
IMPORTANT

Scrape pipe fusion surface

Be sure to watch the video.



○ Insert straight

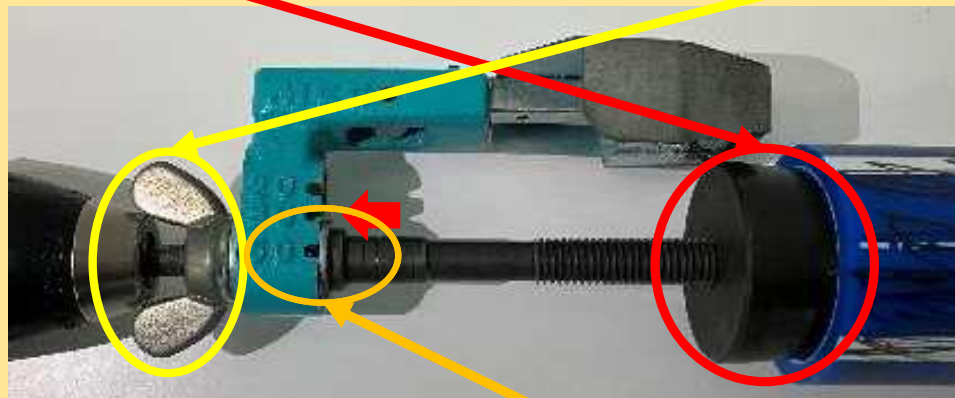


✗ Insert angled



○ Insert fully

○ Tighten firmly



○ Set the pin(JIS side)

Low speed

High speed



LOW



HIGH

Also scrape the spigot of the fitting socket (e.g., tee branch).

○ Scrape



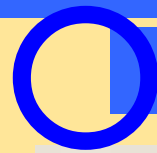
check

☐

Cut → Clean → **Scrape pipe fusion surface** → Clean fusion surface → Clamp → Fuse → Inspect → Cool down

IMPORTANT

Scrape pipe fusion surface



Proper scraping



No scraping



Uneven scraping

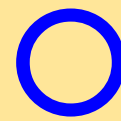
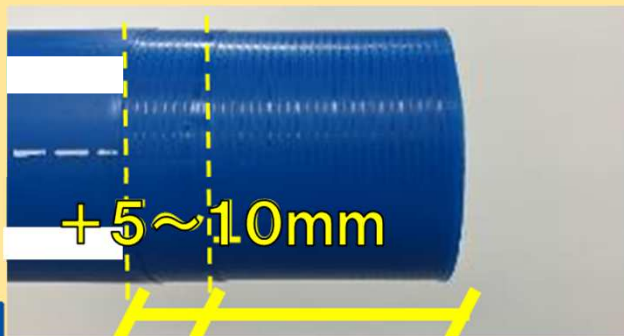


Do not scrape more than twice.

Fusion is prohibited if scraping is omitted or uneven.



Always scrape 5–10 mm beyond the marked line.



Correct uneven scraping with a hand scraper.



はんどすくれーぱー
ハントスクレーパー

check

I have received explanation

Cut → Clean → Scrape pipe fusion surface → **Clean fusion surface** → Clamp → Fuse → Inspect → Cool down

Clean pipe

○ Clean inner surface of fitting



○ Clean pipe surface



Bare hands



ペーパータオル
あせとん

あせとん
アセトン

Use a new paper towel for each location.

✗ Do not rinse with water



うえす ぞうきん
ウエス・雑巾

ぐんて
軍手

Thoroughly confirm that no dirt or liquid sealant adheres to the fusion surface.

☐

Cut → Clean → Scrape pipe fusion surface → Clean fusion surface → **Clamp** → Fuse → Inspect → Cool down

Clamp pipe

Mark insertion reference line



Do not apply paint marker ink to the fusion surface.

くらんぷ
クランプ



Insert to the reference line and clamp

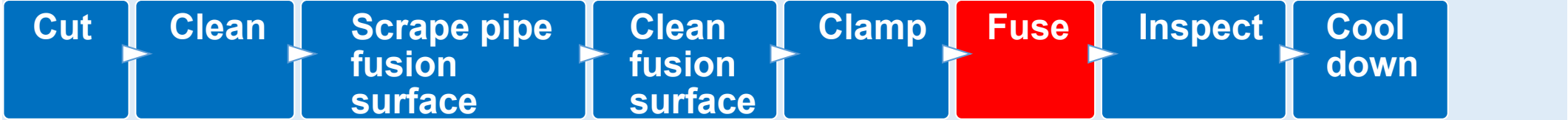


Insert fully

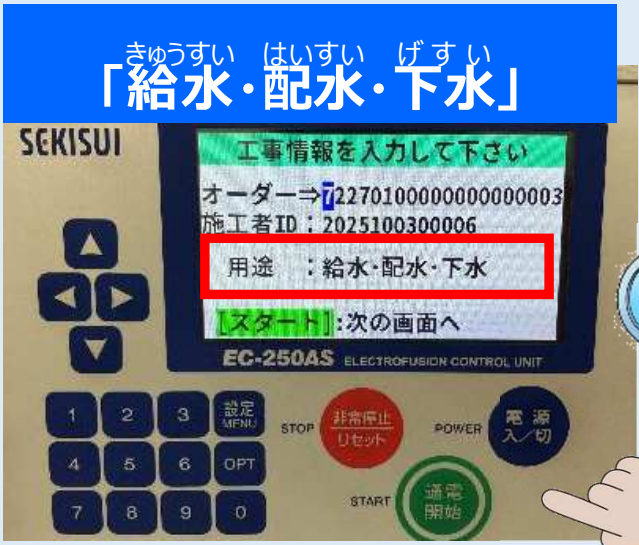
I have received explanation

check

☐



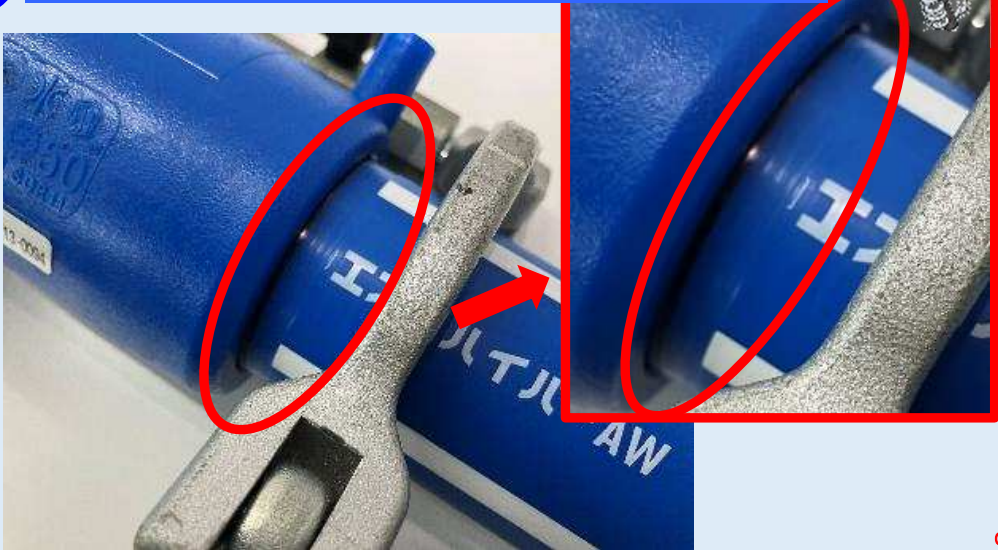
Fuse



Scraping confirmation screen



Be sure to confirm scraping marks.



SEKISUI

I have received explanation

check

☐

Cut → Clean → Scrape pipe fusion surface → Clean fusion surface → Clamp → **Fuse** → Inspect → Cool down

Fuse

Connector connection screen



○ Connect fully



Barcode reading screen



○ Read fitting barcode



Cut → Clean → Scrape pipe fusion surface → Clean fusion surface → Clamp → **Fuse** → Inspect → Cool down

Fuse

Start



Countdown



Do not apply external force to pipes or fittings during energizing.

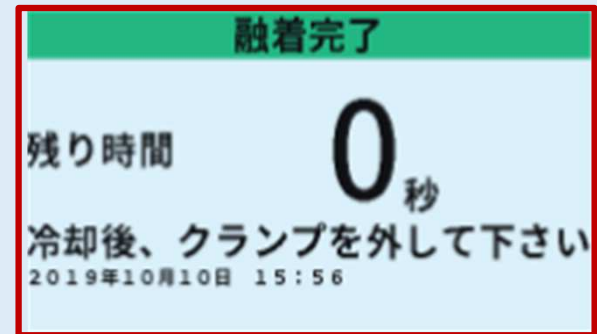




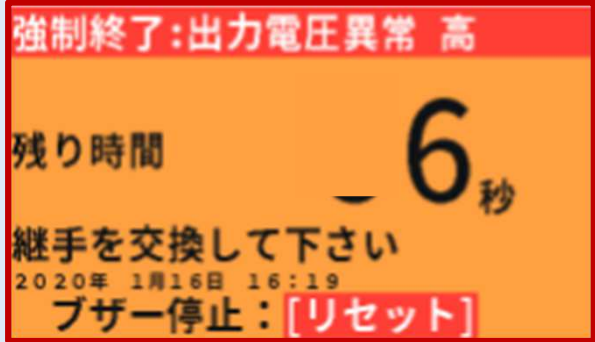
Inspect

Confirm normal completion

○ Normal completion



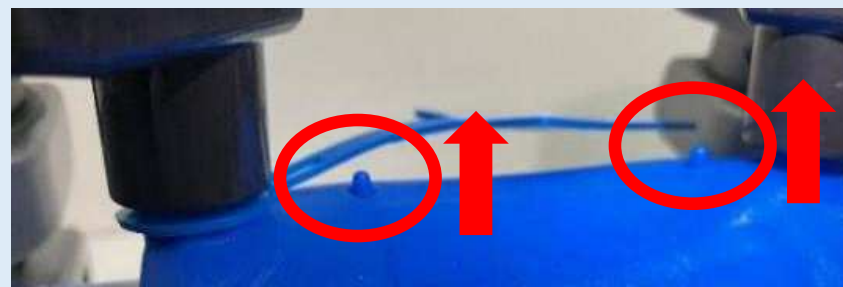
Error



Replace the fitting

Check the indicators

○ Raised



✗ Not raised



Replace the fitting



Cool down

○ Mark cooling completion time



Nominal diameter	Cooling time
20~50	5分以上
65以上	10分以上

During cooling, do not remove clamps or apply external force