

**Polyethylene Socket Fusion Fittings**

<b>Poly Socket Fusion Fittings</b>				
<b>Description</b>	<b>Product Number</b>	<b>Pipe Size</b>	<b>Pk. Qty.</b>	<b>Approx. Wt. (lbs)</b>
<b>Socket Fusion Coupling</b>				
	SC010	1"	10	.11
	SC012	1-1/4"	10	.15
	SC015	1-1/2"	10	.19
	SC020	2"	10	.34
<b>Transition Fitting</b>				
	TF010	1"	25	1
	TF012	1-1/4"	16	1.5
	TF015	1-1/2"	12	2.5
	TF020	2"	16	3
<b>Socket Fusion Tee</b>				
	ST010	1"	15	.21
	ST012	1-1/4"	10	.38
	ST015	1-1/2"	5	.55
	ST020	2"	10	.99

**Socket Fusion Procedure**

1. Cut the pipe squarely with a pipe or tubing cutter. Chamfer pipe using a chamfering tool for pipe that is 1-1/4" or larger.
2. Clean pipe ends to remove any foreign substances.
3. Install the depth gauge and cold ring. Remove depth gauge once the cold ring is secured. Ensure pipe is sufficiently round once cold ring is installed.
4. Place a fitting puller on couplings, caps, and reducers 2" IPS through 4" IPS.
5. Check the heater adapter faces for proper joining temperature 500°F.
6. Place the fitting on the hot head tool and then the hot head tool on the pipe. Push the tool, pipe and fitting together with even pressure.
7. When the fitting is against the tool and the tool against the cold ring, begin the heating cycle shown in the table on page A-35.
8. When the heating cycle is complete, snap pipe and fitting from heating tool and quickly inspect the melt. If melt is not complete, cut off molten pipe and repeat steps 1-8 using a longer heating cycle and a new fitting.

9. If melt is satisfactory, quickly push fitting over the pipe end until leading edge is firm against cold ring. Hold firm pressure without twisting or rotating the fitting for the recommended cooling time shown in the table on page A-35.
10. Allow an additional 3 minute cooling time before removing the cold ring and inspecting the joint.
11. On completion of specified cooling time, remove the cold ring and inspect the joint for quality. Melt should be pressed against socket fitting with no voids or gaps. See photo of properly made socket fusion joint on page A-35.
12. Joint should cool for an additional 10 minutes before subjecting it to testing or stress.

<b>Socket Fusion Time Cycles</b>		
<b>IPS Pipe Size (in)</b>	<b>Heating Time (sec)</b>	<b>Holding Time (sec)</b>
3/4"	12 - 14	30
1"	15 - 17	40
1-1/4"	18 - 21	40
1-1/2"	20 - 23	40
2"	24 - 28	40
3"	28 - 32	50
4"	32 - 37	50