



Flying W Plastics Recommended Socket Fusion Procedure

The following are general instructions recommended by Flying W Plastics and are not intended to replace or supersede the specific instructions furnished by the manufacturer of the socket fusion equipment.

1. Preheat heating tool to (490 – 510) Deg. F. Surface temperature should be checked and adjusted with a surface pyrometer.
2. Chamfer pipe ends and clean pipe ends with a clean rag.
3. Place cold ring on the pipe and utilize depth gauge to set stab depth.
4. Push fitting on the heater and push pipe in the heater socket, keeping both in place for the prescribed heating cycle. Ensure both are fully inserted.
5. At the completion of the heat cycle, “briskly” pull the pipe & fitting from the tool; Do not twist.
6. Push the fitting on the pipe until the cold ring is flush with the fitting. Push smoothly and straight; Do not twist. Melt bead must be pressed evenly against a minimum of 50% of the fitting face. Push smoothly and straight; Do not twist.
7. Hold together for the prescribed cool-down time.

Socket Fusion Time Cycles

<u>Pipe Size</u>	<u>Heating Time</u>	<u>Cold Weather Time</u>	<u>Cooling time</u>	<u>Cooling Time to Tie-in</u>
1/2"	10 seconds	12 seconds	30 seconds	10 minutes
3/4"	13 seconds	16 seconds	30 seconds	10 minutes
1"	15 seconds	18 seconds	30 seconds	10 minutes
1-1/4"	18 seconds	21 seconds	60 seconds	15 minutes
1-1/2"	18 seconds	21 seconds	60 seconds	15 minutes
2"	24 seconds	28 seconds	60 seconds	15 minutes

For CTS reduce by 10%