

Socket Fusion installation quick reference guide



Socket Fusion excluding OT & UV Piping

- 1 Cut pipe end square with shears, wheel cutter or wood/plastic saw.
- 2 Wipe tube and fitting with cleaning wipe if greasy
- 3 Mark insertion depth using depth gauge provided.
- 4 Check hand tool is at temperature (flashing light). Use surface temperature gauge for accurate reading if required.
- 5 Insert tube and fitting onto heating bushes, **without twisting**.
- 6 Start timing **only once both pipe and fitting are fully inserted onto heat bush**.
- 7 Pull **straight** off bushes after heating time and push **straight** together, **without twisting**.
- 8 Align & straighten within the first 10 seconds of making the joint.
- 9 Full system pressure can be applied after 5 minutes for up to 32mm and 15 minutes for all larger sizes

Socket Fusion heating times

Pipe size(mm)	Minimum(secs)	Maximum(secs)
16	5	8
20	5	8
25	7	11
32	8	12
40	12	18
50	18	27
63	24	36
75	30	45
90	40	60
110	50	75
125	60	90

If in doubt please call - 01444 250 500

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Golden Rules

Expansion

- 1) All clips on **HWS** & **HTG** must be Sliding Points unless otherwise specified as Anchor Points.
- 2) Use an Anchor Point, Expansion Loop or Length of Bending Side (LBS) to control expansion.
- 3) Only use Aquatherm Siliconised green lined clips on **HWS** & **HTG**. **CHWS** & **CWS** can be any make lined clips.
- 4) If you change materials from Aquatherm to a metal system, always remember this will act as a fixed point. If a change of direction is not built in, the smaller size tubes will bend with the expansion.
- 5) At all branches from horizontal mains give the branch pipe space to flex (LBS) before going through a wall.

General

Aquatherm is easy to work with, **but don't treat it as too easy**. It is still a high pressure system! Stick to the rules and you will not be disappointed with the quality of jointing. Always remember the tube will enter the heating bush easily if you take your time, there is no panic, mark the insertion depth with the gauge, and **DON'T** screw the tube into the heat bush.

IF YOU DO YOU MAY BLOCK THE PIPE END!

DON'T BLAME THE SYSTEM!

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