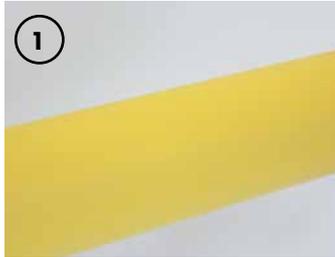


Top loading tapping tee jointing guidance using solid wall PE pipe for water and gas

Radius Systems' tapping tee products, including PurgeTee™ and Anaconda® are supplied with an integral cutter within the body of the tapping tee. This is a 'non-captive cutter'. During the commissioning of the tapping tee product, some let-by of gas or water past the cutter threads may occur. This is normal and consistent with the design functionality of the tapping tee and will cease once the commissioning operation is complete. It is essential that the following tapping tee installation guidance is adhered to.



1 Inspect the pipe and ensure it is free from damage and the pipe surface is clean and dry.



2 Using the saddle fitting as a guide, mark the outline area of the pipe to prepare for electrofusion jointing, using an approved marker pen.



3 Mark the area as shown using a cross hatch pattern to indicate the area to be prepared.



4 Prepare the pipe surface using an industry approved hand scraping tool.



5 Inspect the pipe surface and ensure it is clean and free from contamination.



6 Using an approved calibrated clamp, secure the saddle fitting in place. Ensure the correct clamping force is applied (check clamp indicator).



7 Connect the electrofusion control box terminal leads to the fitting and follow the instructions on the control box.



8 Melt indicators show that the fusion process has taken place. It is not confirmation of a quality joint. Clamps must remain in place during the full cooling period.



9 Prepare the outlet of the tapping tee and place the socket fitting onto the outlet. Prepare the service pipe and make the socket joint following the socket fitting jointing procedure within this brochure.



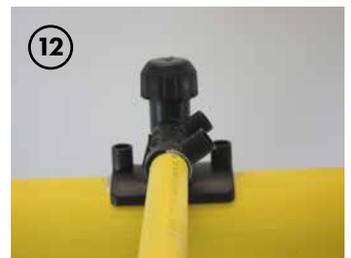
10 Tapping the main
Use a 12 mm hexagonal T key and turn in a clockwise direction until the cutter cuts through the top of the main

Retracting the cutter
Turn the T key in an anti-clockwise direction until the top of the cutter is flush with the top of the stack.



11 Do not remove the cutter from the stack. Ensure the top of the cutter is flush with the top of the stack.

Removal of the cutter will result in an uncontrolled release of fluid from the pipeline.



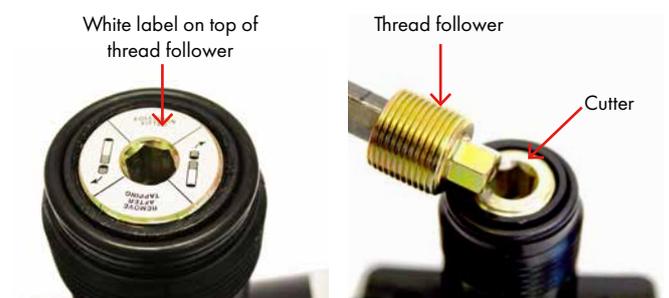
12 Check the O-ring seal is in place at the top of the stack and adequately tighten the cap. Check for leakage using industry best practice. The connection and commissioning are now complete.

Pressure test the service before commissioning.

IMPORTANT NOTE

A thread follower is supplied with our range of large diameter tapping tees in sizes 200mm and above. Where a thread follower is included, a white label will be visible when the tapping tee cap is removed.

Thread followers ensure that the threads within the body of the tapping tee products are not overstressed when tapping the main. The follower should be retracted and removed when the tapping operation is complete. Do not remove the cutter from the stack. Ensure the top of the cutter is flush with the top of the stack.

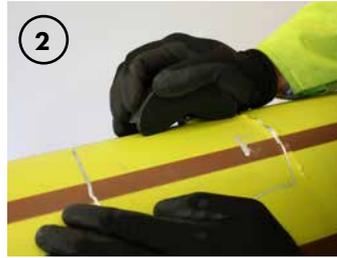


Electrofusion jointing guidance

Top loading tapping tees jointing guidance using ProFuse® peelable pipe for water and gas



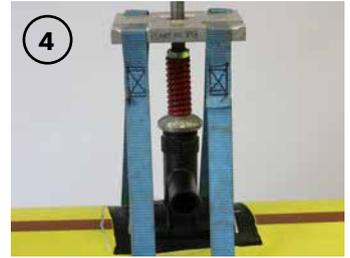
Using the tapping tee as a guide, mark the outline area of the pipe to prepare for electrofusion jointing, using an approved marker pen.



Using the ProFuse® PET, score and cut the outer skin around the perimeter of the marked area. **DO NOT USE** open bladed knives.



Lift and pull the edge of the outer skin away from the core pipe and peel the skin. Take care not to contaminate the pipe surface.



Once the outer skin is removed, follow steps from the 'Top loading tapping tee jointing guidance' section within this brochure to complete the connection.

Note: If the exposed pipe surface becomes contaminated during the skin removal process, the core pipe should be treated as a solid wall pipe and prepared using an approved pipe surface preparation tool

40 x 32 mm under-clamp saddle fitting jointing guidance



The 40 x 32 mm under-clamp tapping tee is supplied with a separate underpart.



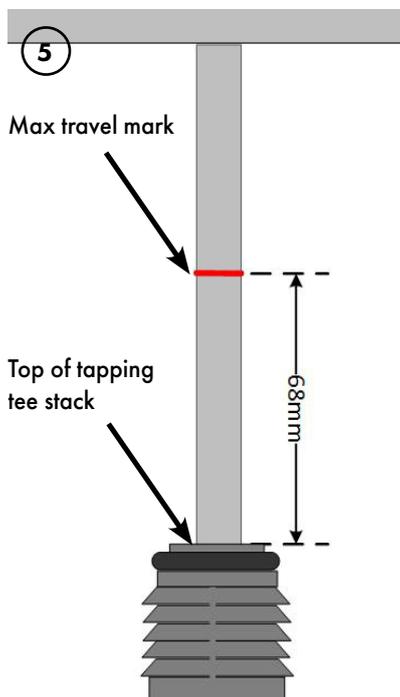
Prepare the pipe surface following the 'Top loading tapping tee jointing guidance' within this brochure. Place the fitting on the pipe. Position and slide the underpart in the groove of the upper saddle as shown.



Hold the upper saddle firmly while tapping the underpart with a suitable soft-blow hammer to fully engage the underpart.



Follow steps from the 'Top loading tapping tee jointing guidance' section within this brochure to complete the connection.



Tapping the main

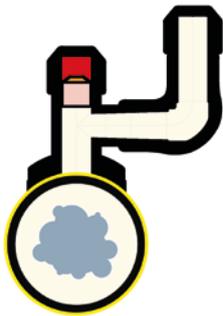
- Remove the cap
- Ensure the top of the cutter is at the top of the tapping tee stack
- Insert the 12 mm hexagonal T key into the cutter
- Mark the T key to indicate the maximum length of travel required = 68 mm
- Turn the T key clockwise until the maximum travel mark is flush with the top of the stack. The top of the pipe has now been cut through
- Retract the cutter by turning the T key anti-clockwise until the top of the cutter is flush with the top of the stack
- Do not remove the cutter from the stack
- Remove the T key, replace the cap and fully tighten
- Check for leakage using industry best practice. The connection is complete

Cutter position at the top of stack before and after pipe cut through



PurgeTee™ for gas applications - Principle of operation

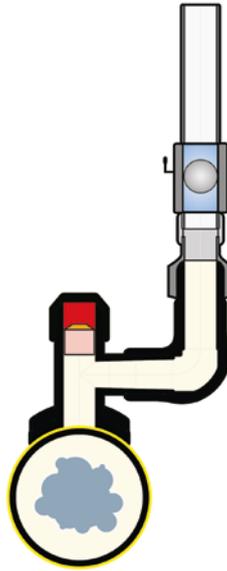
1



Fuse the PurgeTee™ onto the PE main, using the same procedure for saddle fittings in this document.

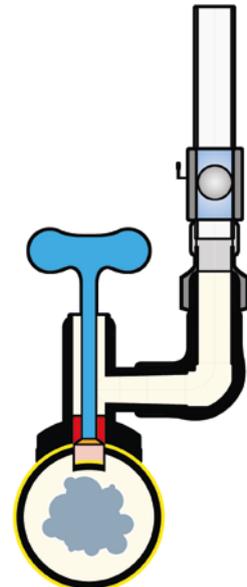
Remove the outlet cap and carry out a pressure test to prove weld integrity.

2



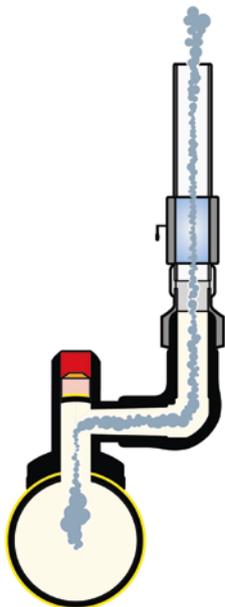
Fit the purge tube to the PurgeTee's elbow outlet using the reusable thread adaptor (product code FT0655 or FT0656).

3



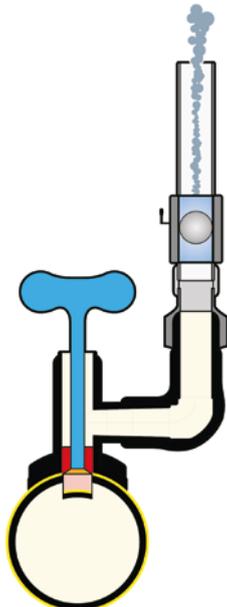
Using a short arm T key, tap the PE main. Retract the cutter to the top of the stack. Do not remove the cutter. (Follow tapping the main instructions for saddle fittings within this brochure)

4



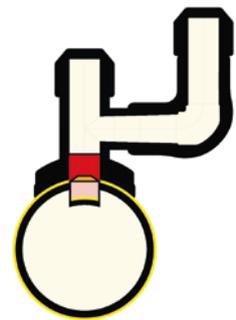
Open the valve on the purge tube to allow the gas / air to escape through the PurgeTee™.

5



When the purging operation is complete, close the valve and wind the cutter down, so that it plugs the cut hole in the crown of the PE pipe.

6



Now that the flow of gas is controlled, remove the purge tube and adaptor. Check the O-ring seal is in place at the top of the stack and adequately tighten the cap. Check for leakage using industry best practice procedures.

For complete jointing guidance and jointing videos, please visit our website www.radius-systems.com.
For further jointing advice, please contact our technical support team on: t: +44 (0)1773 811112,
e: techsupport@radius-systems.com.