

Composition of the i20 kit:



- 1 HDPE muff to slit
- fusion grids

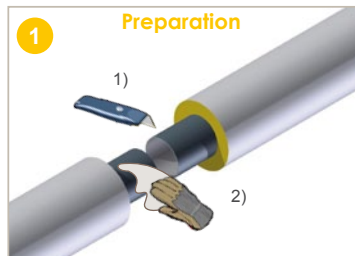


- 1 box of Polyol
- 1 box of Isocyanate
- 1 mixing spatula



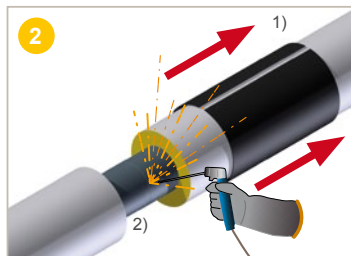
- 2 vent plugs
- 2 weld-on plugs





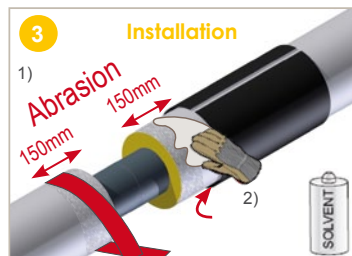
1) **Scrape** the PUR foam off the front (all signs of damp PUR foam must be removed from the ends).

2) **Clean** the ends of the pipes or parts with a cloth to remove any water, mud or sand.



1) **Slide** the previously slit HDPE muff onto one of the pipes, pushing it along a sufficient distance.

2) **Align** the pipes and **weld** the two steel pipes together according to professional standards.



1) **Roughen** the surface of the casing (150 mm on each side) and the inside of the muff with abrasive paper or a wire brush.

2) **Clean and degrease** the roughened surfaces with a cloth dipped in ethanol (min. 94 %).

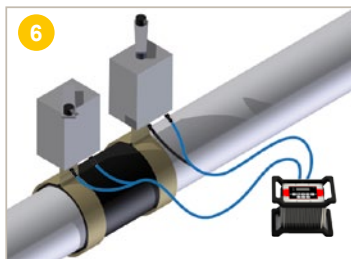


**Position** the fusion grids using the marking made previously and staple them into position.



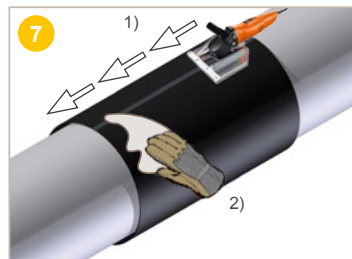
**Slide** the muff at the stripped area so that it covers the pipe casing by 5 to 10 cm on each end.

⚠ **Make sure to go past** the ends of the fusion grids of the muff slit.



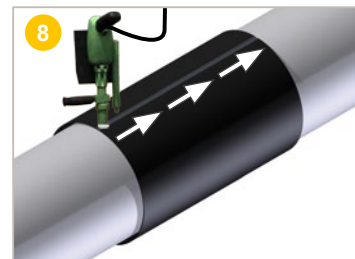
**Fit** the Kevlar tightening system and mount the welding tools on the muff.

**Weld** the muff on the casing by electrowelding in compliance with the generator procedure.



1) **Chamfer** the longitudinal cut in the muff to prepare for the PE extrusion operation.

2) **Thoroughly clean** the muff surface using a dry cloth to eliminate the PE residues produced during chamfering.



**Weld** the longitudinal cut of the muff using a PE extrusion gun.

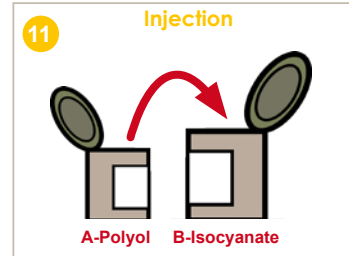


**Drill** a 1st hole in the muff with an electric drill, **taking care not to drill the weld of the longitudinal cut.**

⚠ Perform an airtightness test at 0.2 bar with a hand pump and pressure gauge to check that the junction is perfectly airtight.



After conducting the airtightness test and demonstrating that the junction is airtight, **drill** the 2nd hole in the muff.

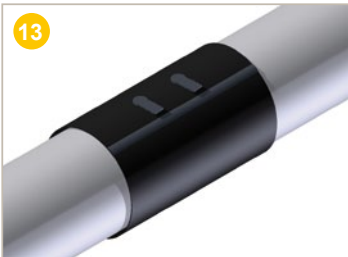


Take components **A** and **B** out of the kit boxes and check the diameters.

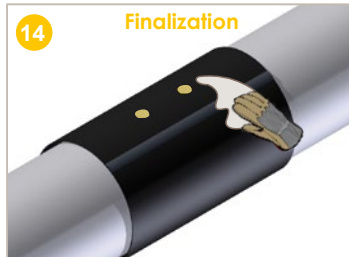
⚠ Check the kit use-by date. Pour component **A** into component **B**, **mix** together using the spatula supplied. The mixture is ready when it is homogeneous, with no signs of different colours.



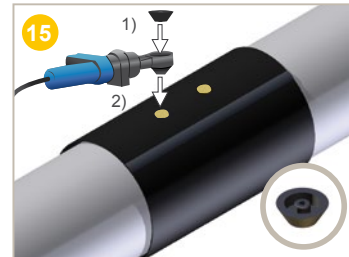
**Pour** the mixture into one of the 26 mm diameter HDPE muff injection holes. Make sure all of the mixture is removed, using the spatula supplied.



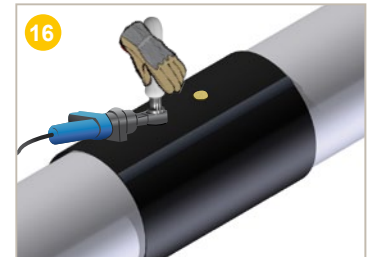
1) **Push** the 2 vent plugs fully into the 2 injection holes.  
2) As soon as the expanded mixture has hardened, remove the plugs using the 2 tabs provided.  
**Clean** off any excess PUR foam.



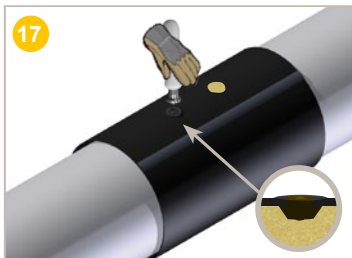
**Clean** the surface to remove any polyethylene or sand particles with a dry cloth (or blow off with the flame).



1) Use a suitable tool to place the 1st weld-on closure plug in the base of the welding machine to heat it up.  
2) At the same time, push the end of the welding machine into the injection hole to heat up the edges.

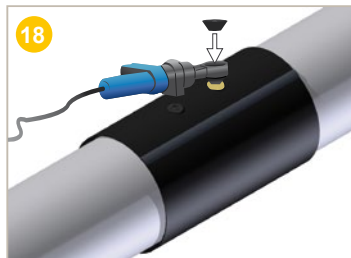


Use a punch to remove the weld-on closure plug previously heated in the welding machine.

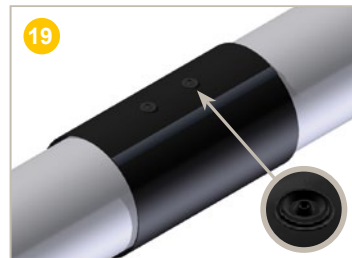


Position the weld-on closure plug in the injection hole and press gently for about 1 minute.

⚠ Do not remove the tool until the plug surface has become warm again.



Repeat operation 15 to 17 with the 2nd weld-on closure plug.



The system is correctly installed when 2 homogeneous weld beads are visible around the entire circumference of the weld-on plugs.