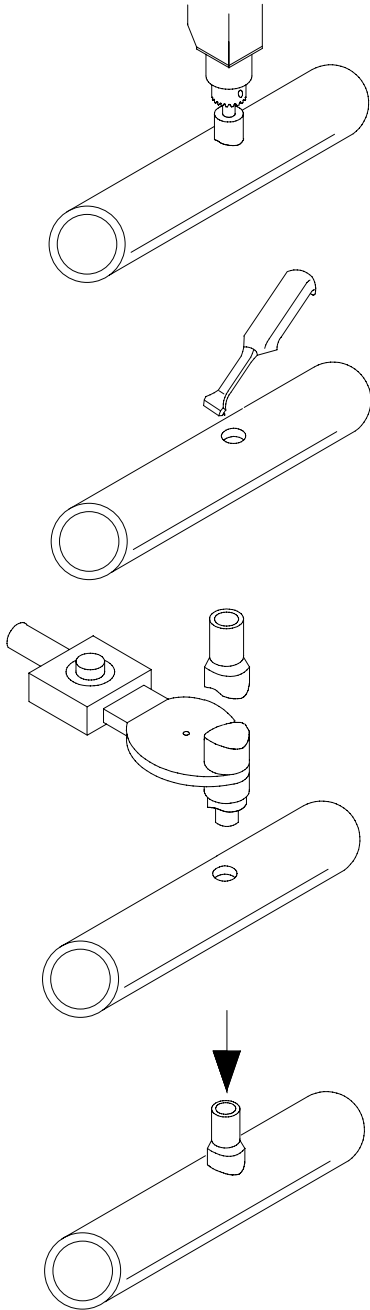


## INSTRUCTIONS FOR WELDING MKM TEE JOINTS ON SMALL DIAMETER PIPE USING A MANUAL WELDER



1. Install the appropriate welding bushes on the opposite surface of the polywelder ensure they are correctly aligned. Insert the teflon centering pin on the welding bush that will be used for melting the pipe. Set the temperature of the polywelder at 200° C. Drill a hole in the pipe at the designated point either using a piercing point, if the work is being carried out in a workshop, or with a milling cutter if working on site.
2. Clean the area around the hole, remove any ragged edges and scrape of the oxidised layer from the saddle of the fitting and from the pipe which is to be melted.
3. Position the polywelder on the pipe inserting the teflon pin in the hole that has been drilled. Check that the surface of the bush marries perfectly with the surface of the pipe, and at the same time, place the fitting on the opposite side of the bush so that the surfaces of the pipe and the fitting can be brought to fusion.
4. Make sure that both reach the required correct temperature and that there is a welding rim both on the pipe, and the fitting. Remove the polywelder as quickly as possible, and press the fitting onto the pipe making sure that the fitting is aligned to the impressions left on the pipe. Wait until the welding cools down maintaining adequate pressure on the two parts.

By following these simple MKM procedures we have created a simple, strong, safe and long lasting tee joint at the required position quickly and cost effectively.