

Technical Note PP 750-TN-03

COMPATIBILITY FUSION

BUTT FUSION OF DriscoPlex[®] PE 2406 PIPE & FITTINGS TO DRISCOPE[®] 7000 and DRISCOPE[®] 8000 PIPE

The compatibility fusion procedure recommended below was tested and qualified in accordance with D.O.T., Title 49 C.F.R., 192.283.

Refer to Performance Pipe Bulletin PP 750 for information on preparation and precautions.

HEATING SURFACE TEMPERATURE: 490° - 510° F

NOTE: The use of an insulated heat shield is recommended for this fusion.

1. **Clean And Secure The Pipe Ends.** Clean each pipe ends with a clean cotton cloth or paper towel. Remove all foreign matter. Install and secure the ends in the machine. The ends should protrude past the clamps enough so that facing will be complete. Tighten the clamps to prevent slippage of the pipe.
2. **Face And Align.** Place the facing tool into the unit between the ends and face them to establish smooth, clean parallel mating surfaces. Remove the facing tool and bring the ends together. *DO NOT TOUCH THE PIPE ENDS AFTER FACING.* Check alignment and adjust if needed. Always tighten the high side never loosen the low side. Ends should be squared and aligned with no gaps between the ends. Reface if adjustment is made.
3. **Melt.** Verify the heating tool is maintaining the correct temperature. Install the insulated heat shield between the PE 2406 end and the heating tool, bring the ends together against the heating tool and hold contact **without force**. After the Driscopipe[®] 8000 has achieved approximately ½ of the proper melt bead size, remove the insulated heat shield and bring the PE 2406 pipe into contact with the heating tool and continue heating for the proper melt bead size on the PE 2406 pipe.
4. **Joining And Inspection.** When the proper melt bead size is formed, quickly separate the ends and remove the heating tool. Quickly inspect (within approximately 3 seconds) the melted ends, which should be flat, smooth and completely melted. Bring the melted ends together and apply enough joining force* to roll the melted beads over to the pipe surface. **NOTE: The 8000 side of the bead may not roll completely down against the pipe surface.** The PE 2406 melt bead must be rolled completely down against the pipe surface.
5. **Cooling.** Allow the fusion joint to cool properly (until cool to the touch). Cool for about 30-90 seconds per inch of pipe diameter. *DO NOT TRY TO SHORTEN THE COOLING TIME BY APPLYING WATER, WET CLOTHS OR THE LIKE.*

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* **Note:** For hydraulic butt fusion machine use an **interface pressure 60–90 psi** to calculate hydraulic fusion joining pressure gauge settings.