AQUATHERM NORTH AMERICA

INSTALLER MANUAL

OCT2024

Owner

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Installer Number

Trainer Name

Trainer Contact Info.

Aquatherm Installer Manual

For the proper installation of PP-R and PP-RCT pipe
and fittings manufactured exclusively by Aquatherm

Required for the Aquatherm Installer
and Training Courses

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Chapter 3

Chapter 1 : **Welcome to Aquatherm**

This manual has been compiled to help ensure safe and consistent installation of Aquatherm piping materials. Please read all instructions before beginning installation. Installers must take the Aquatherm Installer Course from an authorized Aquatherm trainer before beginning installation.

This training is designed to teach you the proper techniques for fast, reliable heat-fusion connections and help you take full advantage of Aquatherm's many benefits.

Read and understand all manufacturer's instructions before attempting any installation activities. Manufacturer instructions and warnings are available at www.aquatherm.com. Always wear the proper safety equipment and take the appropriate precautions. Failure to follow manufacturer's instructions and warnings could result in personal injury, property damage, product damage or death.

The most current version of the Aquatherm Installer Manual can be found at www.aquatherm.com/literature/installer-manual. Please verify you are using the most current version of the Installer Manual before proceeding. See publication date on the back cover for edition date.

Getting started

Before you get started, you should know a little about the pipe you are installing. Aquatherm pipes and fittings are made from an engineered variation of polypropylene-random copolymer, PP-R or PP-RCT.

Aquatherm PP-R and PP-RCT offer many benefits over metals and other plastics, such as reliability, longevity, and chemical purity.

Aquatherm PP-R and PP-RCT pipes and fittings are produced in Germany and have been used around the world for decades.

The pipe and fittings are made to the highest international standards of quality, so you can trust the material every time you install it. If the pipe and fittings don't have Aquatherm labels, return them and don't install them. Only genuine Aquatherm products are protected by Aquatherm's comprehensive 10-year, multimillion-dollar warranty.

Working with PP-R and PP-RCT

Polypropylene is a thermoplastic, similar to polyethylene pipe. It is made from a petroleum by-product, so it naturally repels water. This makes it ideal for a piping material as it does not affect, and is not affected by, the water it carries.

Aquatherm PP-R and PP-RCT has a balance of polypropylene copolymerized (combined) with a small amount of ethylene. This combination, enhanced by Aquatherm's proprietary formula, gives the material a balance of durability, rigidity and flexibility. PP-R and PP-RCT are connected using heat fusion, which involves heating, pressure and cooling the pipe to join it to an identical material.

All of Aquatherm's pipes and fittings can be fused together without any strength loss; they have the same densities, durability and resistances.

Aquatherm PP-R and PP-RCT have been engineered for improved performance and should not be mixed with other types of Polypropylene. PP should never be fused to PVDF, PE, CPVC, or any other type of plastic. Never use solvent cements on Aquatherm, as they may damage the pipe and won't bind properly.

Material handling: Do

Inspect pipe upon receiving it. Aquatherm does not accept responsibility for damage that occurs after the pipe is shipped.

Keep fittings in bags until you are ready to use them. Bagged fittings are easier to identify and stay protected from contaminants.

Keep the pipe on a flat surface or close supports to avoid bowing. Use at least four supports for all pipes.

Keep the pipe in its protective wrap until you are ready for installation. The bag protects the pipe from dirt and scratches.

Handle the pipe carefully, especially in freezing temperatures.

Cover pipe stored outside with a light covered tarp. A dark tarp generates heat and can cause warping

Material handling: Don't

Be careful where you store the pipe. Running over pipe with a vehicle is the most common cause of pipe damage.

Don't risk damaging the pipe by handling roughly.

Don't insert sharp or unpadded objects into the ends of the pipe. This can gouge the inside of the pipe and create weak spots.

Don't store the pipe outside uncovered. The pipe should be stored in it's factory packaging and covered with a light tarp to avoid UV damage.

Don't fuse damaged pipe. Remove damaged sections and install the remaining pipe. Follow your distributor's policy for returns.

Don't use damaged pipe that is gouged deeper than 10% of the wall thickness on the outside or 5% on the inside.

Pipe sizes

Aquatherm pipe is made to metric sizes (millimeters).These charts provide matching metric and imperial sizes. Aquatherm pipes use standard dimension ratios (SDR) instead of schedules. This means the wall thickness is proportional to the pipe diameter, making the pipe pressure rating consistent through each size.

All pipe comes in 19 ft (5.8 meter) lengths.

Socket fusion

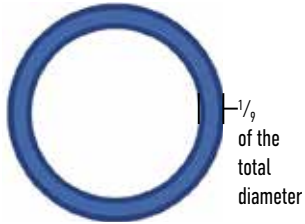
Factory metric OD	Nominal diameter
20 mm	½"
25 mm	¾"
32 mm	1"
40 mm	1 ¼"
50 mm	1 ½"
63 mm	2"
75 mm	2 ½"
90 mm	3"
110 mm	3 ½"
125 mm	4"

Butt Fusion

Factory metric OD	Nominal diameter
160 mm	6"
200 mm	8"
250 mm	10"
315 mm	12"
355 mm	14"
400 mm	16"
450 mm	18"
500 mm	20"
630 mm	24"

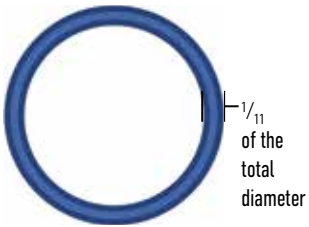
4" SDR 11, SDR 9, and SDR 17.6 may be butt fused.

Wall thickness



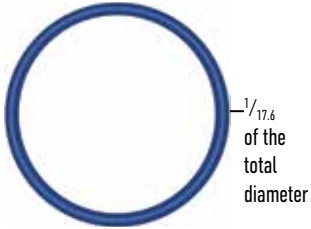
SDR 9

A heavy wall thickness provides increased temperature and pressure capabilites for high-stress applications, such as mechanical-heating hot-water systems.



SDR 11

A medium wall thickness provides higher flow rates while maintaining high pressures. Suitable for most applications.

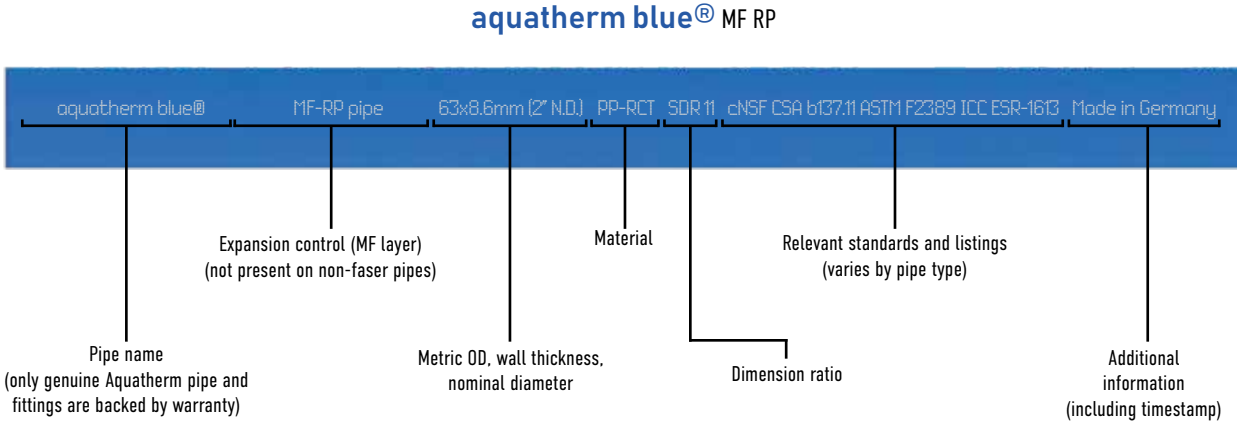


SDR 17.6

A thinner wall provides maximum flow rate while minimizing material weight, cost, and fusion times. Suitable for chilled, cooling, and condenser applications.

Identification

Aquatherm has several lines of pipe that are specifically engineered for certain applications. Refer to the print line to identify the product being used.



Temperature	aquatherm blue® SDR 17.6 MF RP	aquatherm blue® SDR 11 MF RP	aquatherm blue® SDR 9 MF RP
Permissible working pressure (psi)			
50 °F	185	305	385
80 °F	145	240	305
100 °F	120	205	255
120 °F	100	170	215
140 °F	85	140	180
160 °F	-	115	150
180 °F	-	95	125
200 °F	-	80	100

Heavy-wall aquatherm blue® MF RP

Color: Blue

Wall thickness: SDR 9

Size range: 1 - 14 in.

Multi-layer, faser-composite (MF) (expansion-controlled): Yes

Maximum operating pressure at 50°F: 385 psi

Maximum operating pressure at 180°F: 125 psi

Recommended applications: Heating and cooling distribution, chemical transport, swimming pools (verify treatment levels), and in-floor heating distribution

Acceptable applications: Irrigation and any other non-potable piping

Medium-wall aquatherm blue® MF RP

Color: Blue

Wall thickness: SDR 11, 7.4 (¾ in. or smaller only)

Size range: ½ - 18 in.

Multi-layer, faser-composite (MF) (expansion-controlled): Yes

Maximum operating pressure at 50°F: 305 psi

Maximum operating pressure at 180°F: 95 psi

Recommended applications: Heating and cooling distribution, chemical transport, swimming pools (verify treatment levels), and in-floor heating distribution

Acceptable applications: Irrigation and any other non-potable piping

Thin-wall aquatherm blue® MF RP

Color: Blue

Wall thickness: SDR 17.6

Size range: 4 - 24 in.

Multi-layer, faser-composite (MF) (expansion-controlled): Yes

Maximum operating pressure at 50°F: 185 psi

Maximum operating pressure at 140°F: 85 psi

Recommended applications: Geothermal, district cooling, low-pressure cooling distribution, and condenser water piping to cooling towers

Acceptable applications: Any non-potable, low pressure, and low temperature applications suitable for PP-R and PP-RCT

Molded fittings

- Single piece
- ½" - 4" fittings socket fused over the pipe wall
- 6"- 24" fittings butt fused in-line with the pipe
- Minimal markings on the fittings
- Full labeling on the bag
- Keep fittings in their bags until ready for use
- Pressure rating meets or exceeds the pressure rating of the pipe

Segmented fittings

- Usually 2 - 3 fused pieces
- Butt fused in-line with the pipe
- 6” - 24” (elbows & tees)
- Made from **aquatherm blue®** to match piping system
- Size and SDR marked on label
- Stamped on the side for traceability


aquatherm®

Chapter 2: Heat fusion

Aquatherm is a rigid piping system, similar to copper and steel. Proper training helps ensure proper connections. Your own care and attention to detail will yield impressive results, whereas sloppy workmanship will yield poor results. This chapter will cover the basic techniques for heat fusing pipe.

Once you learn how to heat fuse, it will be up to you to provide the quality labor that makes each installation a work of craftsmanship.

Certain procedures should be followed to work safely with Aquatherm pipe, including:

Take proper precautions around electrical equipment and follow all instructions.

Wear OSHA-approved safety steel-toe shoes.

Wear a properly rated hard hat at all times.

Wear safety glasses.

Wear heat-resistant gloves while handling fusion irons.

Be careful when handling hot irons.

Follow Aquatherm-specific guidelines for proper material installation. Take proper precautions when conducting pressure test.

Cutting the pipe: manual

These are recommended cutting methods, but you may use any method that doesn't damage the pipe. Cuts should be as square as possible (never more than 5° off) and without jagged edges. Check for cracks on the interior and exterior pipe wall after each cut.

✓ Use ratchet cutters with a sharp, pointed blade for smaller sizes. The pointed blade prevents the pipe from ovaling with the cut.

✗ Don't use ratchet cutters with a dull or flat blade. Dull or flat blades can oval the pipe and cause it to crack.

✓ Support the pipe while cutting to yield square ends and prevent bouncing or snapping.

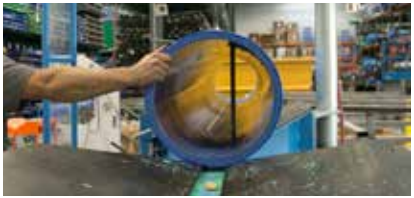
✓ Use tube cutters with a wheel taller than the pipe wall. Smaller wheels might not reach through the entire pipe wall.

✓ Hand saws are a safe alternative, even in cold weather.

Cutting the pipe: power

With powered saws, blades that are intended for hardwood will yield the best results. Avoid jagged or angled cuts, as these require additional prep to fuse.

✓ Use a circular hardwood blade (60-100T) with carbide teeth. This will produce a cut that needs little cleanup.



✓ Band & reciprocating saws are safe to use. The thinner blades leave a smooth cut, but you will also have shavings to clean up.

✗ A wide-toothed blade (24-40T) will produce a jagged cut that is rough and not desirable for socket fusion.

✗ A fine-toothed blade (180T) will overheat the pipe, as will cutting too slowly. Cut as quickly and squarely as possible.

Exercise care when using power cutters if the pipe is 40°F or colder. Cold pipe is more brittle and can crack or split during the cutting process.

Inspecting and cleaning the cut

After cutting the pipe, inspect the ends for cracks or damage on both the interior and exterior of the pipe. Mark and remove damaged sections, cutting at least 6 inches past the damage.

Remove any burrs and rough edges left from cutting the pipe. You may need to carefully cut them away with a blade, de-burring, or reaming tool.

Remove standing dirt and oil using an isopropyl alcohol-based cleaner (91% by volume or greater).

A good cut is smooth, square and has no cracks or stress marks inside or outside the pipe.

White stress marks and cracks indicate damage. Reassess any cutting tools that leave cracks. You may need to squeeze the end of the pipe to see small cracks.

During socket fusion, a fitting is fused over the outside of the pipe, leaving the inside open and unrestricted.

The fittings are sized to be too small to fit over the pipe unheated. This makes dry-fitting impossible, so connections cannot be accidentally left unfused. Also, the difference in diameter between the fitting and pipe creates the required pressure for fusion.

During socket fusion, the inside layer of the fitting is removed, as is the outside layer of the pipe.

The heating process allows the pipe to be inserted into the fitting. The inner wall of the fitting fuses to the outer wall of the pipe, forming a bond that is as strong as the pipe itself. The connection forms on the entire fused surface.

Fusion heads

Socket fusions are made using fusion heads. Fusion heads are specifically sized to match the pipe and fittings. Different fusion-head sets are required for each size of pipe. Only use heads from an approved tool manufacturer.

Threaded bolt

Heads store inside each other to avoid scratches.

Pipe (female) side

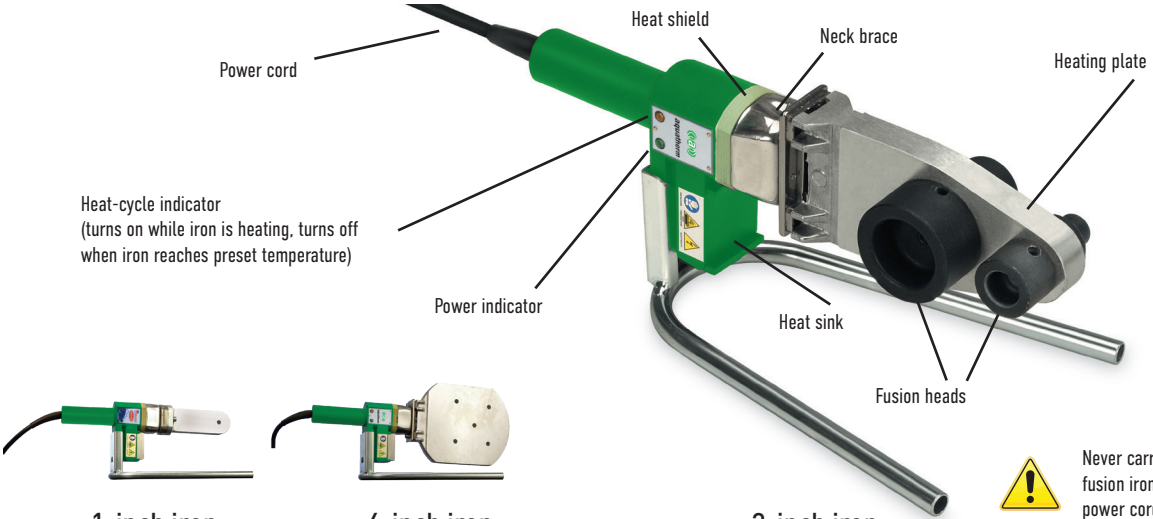
Fitting (male) side

Before setting up a fusion iron, clean the fusion heads with 91% isopropyl alcohol or a similar non-corrosive agent.

Fusion irons

The fusion heads can be interchangeably attached to a fusion iron, which provides heat for the fusions.

Note: Heat fusion requires a steady electrical supply, so please consult with your Aquatherm rep to ensure you have the proper power supply.



Never carry a fusion iron by its power cord!

Fusion-iron safety : Do

Compared with open flames or noxious glues, a fusion iron is fairly safe to use. However, the iron is hot enough to burn on contact and can remain hot for up to 30 minutes after it is unplugged. Never use water to cool an iron or head.

Wear heat-resistant gloves while handling the iron. Few gloves are heat-proof, so know the limitations of your gloves.

After use, allow the iron to cool, then return the iron to its case for storage.

Post a sign near irons to warn that they are hot. Irons can remain hot for up to 30 minutes after being turned off.

Be aware of where other people are at all times while fusing. Make sure they are clear before you move the hot iron around.

Keep the cord away from hot surfaces. Some cords are heat-resistant, but it's best to keep everything away from the heating surface.

Fusion-iron safety: Don't

Don't leave the iron unattended. Passers-by may not know if the iron is hot and could accidentally burn themselves.

Don't hold the iron by its cord. The cord is not intended to hold weight.

Don't touch the iron with bare hands unless you are certain the iron has cooled. Assume irons and heads are hot until tested.

Don't store multiple irons in a single box. Irons can damage each other easily and should be stored separately.

Don't let the iron touch flammable or meltable surfaces. This is a fire hazard and can damage the plate or heads.

Don't use the fusion iron if the plate or heads are dirty. Clean the plate with a soft wire wheel and the heads with a cloth.

Tool assembly

1. An iron will take 5-10 minutes to heat up. An extension cord with the appropriate amperage rating can be used to deliver power over long distances if needed. Be aware of other devices drawing power if you are using a limited power source, as this can cause fluctuations in temperature. A surge protector will protect the iron from on-site power surges.

2. Set fusion heads in place while the iron heats up. The plate will expand as it heats and will deform if the heads are to tight

3. When the iron is hot, tighten the fusion heads for full contact, which will ensure uniform heat.

4. Check the temperature on the inside of the fusion heads using a digital thermometer—at close range if using an infrared thermometer. The temperature for socket fusion should always be around 500°F (+/- 18°F). If the iron constantly cycles on and off, or if the heating phase takes a long time, there may be a power-supply issue. If the iron does not reach 500°F or exceeds it, the thermometer may be faulty. Use a contact thermometer if you are unsure.

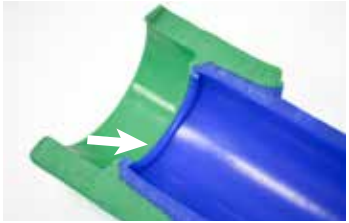
Marking the pipe

The marking guides help ensure proper insertion depth. The green marking guide is ideal for smaller pipes (½ - 4 in.) and the blue marking guide is designed for larger pipes (2 - 4 in.). Marking on several sides can help you line up the connection.

When using the blue marking guide, insert the fitting to the beginning of the mark, not the middle. The bead may roll over the initial mark during fusion, so the tail shows that the pipe was marked properly upon inspection.

If the cut is slightly angled (but not enough to prohibit fusion), make only one mark on the long side. Use this mark to prevent over-insertion. Inserting to a mark on the shorter side will leave a partial bead in the pipe. Inserting to the long side will leave a slight internal gap, but this will not affect the connection strength.

Under-inserting will weaken the connection by reducing the amount of fusing surface.



Over-inserting will form a bead inside the fitting, causing a restriction in the pipe.

Socket fusion heating and cooling times

Column A: Nominal diameter in inches
Size of standard pipe that the Aquatherm pipe normally replaces. In some cases, it may be possible to use a smaller-diameter Aquatherm pipe based on flow rate.

Column B: Metric OD in mm
The manufactured pipe size.

Column C: Actual OD in inches
The actual size of Aquatherm pipe in inches. Use this for sizing clamps and penetrations.

Column D: Fusion depth in inches
The depth the pipe should be inserted into the socket fitting. Use this for planning the length of a cut and if no marker is available.

Column E: Heating time for warm weather
Usually 40-100°F. Reduce heating time slightly if working in extreme ambient heat (100 °F+). Never use less than 80% of the heat time in these circumstances.

Additionally, when using SDR 11 non-faser pipe in small sizes (½ in. & ¾ in.), reduce the observed time by 1 sec. to avoid overheating and collapsing the pipe wall. Insert the pipe into the fitting as quickly as possible.

Column F: Heating time for cold weather
Use the times in Column F when the ambient temperature is 40°F or colder. You may also use these times if you are having difficulty inserting the pipe all the way into the fitting within the fusion time (G), but be careful not to overheat the pipe.

Column G: Transition time
The window of time between removing the PP-R from the fusion iron and inserting the pipe completely into the fitting before it cools. If you exceed this time, you risk having the connection cool off, which could cause an incomplete fusion. If you cannot fully insert the pipe into the fitting within this time limit, get another installer or a fusion machine to help you.

Column H: Cooling time
Pipe should not be pressurized or stressed during cooling time. You will need to fully immobilize the pipe for up to a quarter of this time while the connection sets.

Socket fusion heating and cooling times

Pipe diameter			Fusion depth	Heating time in sec.		Transition time	Cooling time
ND	OD	Actual OD	inch	above 40 °F	below 40 °F	sec.	min.
A	B	C	D	E	F	G	H
½"	20 mm	0.79"	9/16" (14.5 mm)	5	8	4	2
¾"	25 mm	0.98"	5/8" (16 mm)	7	11	4	2
1"	32 mm	1.26"	11/16" (18 mm)	8	12	6	4
1¼"	40 mm	1.57"	13/16" (20.5 mm)	12	18	6	4
1½"	50 mm	1.97"	15/16" (23.5 mm)	18	27	6	4
2"	63 mm	2.48"	1 1/16" (27.5 mm)	24	36	8	6
2½"	75 mm	2.95"	1 3/16" (30 mm)	30	45	8	8
3"	90 mm	3.54"	1 5/16" (33 mm)	40	60	8	8
3½"	110 mm	4.33"	1 7/16" (37 mm)	50	75	10	8
4"	125 mm	4.92"	1 9/16" (40 mm)	60	90	10	8

Socket fusion instructions

(page 1 of 2)

Socket fusion heats the outside of the pipe and fuses it to the inside of the fitting. This creates a large joining surface with no leak path.

The fusion area on the pipe and socket must be kept clean and free of contaminants and moisture during the fusion process. You must use the properly sized fusion heads for a proper fusion. These heads are available through Aquatherm and approved tool manufacturers.

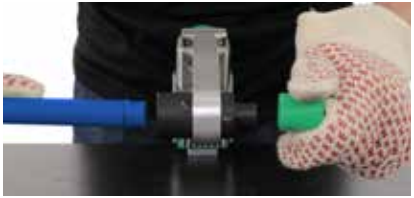
The heating times (column E or F) begin when the pipe and fitting are fully inserted onto the fusion head.

1. Clean the pipe and insert the pipe and fitting onto the fusion head. Pushing both sides at the same time helps hold the iron steady.

2. Stop pushing the pipe when you hit the mark (column D). Over-insertion will cause a restriction in the pipe and lower performance.

3. Stop pushing the fitting when you reach the stopline. Tapered heads will offer little resistance until just before the stop. (see page 2.7)

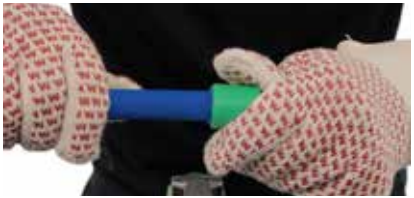
4. Observe the heating time (column E or F). A bead will form and become shiny as the fusion nears readiness.



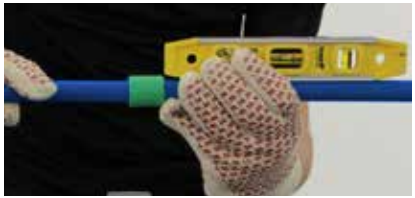
5. Remove fitting and pipe from the fusion heads. Use a clamped stand or an extra hand to hold the iron in place.

6. Immediately insert the pipe into the fitting up to the insertion depth mark. The full insertion must be completed within the transition time (column G).

✗ Do not touch the face of the pipe to the edge of the fitting. This flattens the beads and can cause an improper connection.



7. Once the bead rings meet, you will have 5-10 sec. to make adjustments to the alignment, depending on pipe size. Do not twist during adjustment, alignment, or insertion.



8. Align the pipe. Observe the cooling time (column H). Provide full support for at least a 25% of the cooling time. Full cool down must be observed before pressure testing or operation.

*You normally will have 5-10 sec. to begin joining the connection after you remove it from the iron. The time will vary with pipe size and ambient conditions. Waiting too long will let the pipe surface cool and make fusion impossible.

Cold ring and chamfer tools

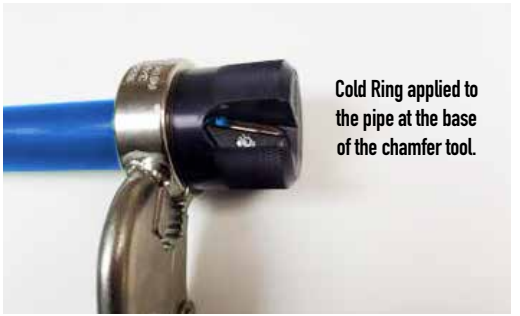
Cold ring and chamfer tools may be used when socket fusing Aquatherm pipe and fittings. Tools are generally available for 20-50mm (½-1½ inch) sizes. Note that the tools must be sized correctly for metric OD PP piping.

The chamfer tools must also be sized correctly for the PP fitting socket depths to properly locate the cold ring tool for the correct insertion depth when doing the socket fusion.

Refer to Aquatherm Technical Bulletin 201603B-AQTTB and the tool manufacturer's instructions for proper use of the chamfer and cold ring tools.

Chamfer Tool

Chamfer Tool in Action



Cold Ring applied to the pipe at the base of the chamfer tool.

Fusing pipe larger than 2 in. is difficult without help. There are several tips for assisted (two-man) fusions:

Increase the heating time by up to 50% if needed. It can take longer to fuse the pipe and fitting by hand, additional heat time makes the connection easier and prevents it from sticking mid-fusion. The ideal amount of additional heating depends on the ambient temperature, pipe size, and installer strength. Use your best judgment to prevent the pipe from becoming too soft.

Don't waste time. Once the pipe and fitting are removed from the iron, push them together immediately.

Polypropylene doesn't burn while heating, so you can put the pipe and fitting back on the fusion heads and start again if the connection is underheated. After the initial heating, pipes and fittings may be reheated safely only once.

Ensure the pipe end is cut square and mark the pipe on several sides; this will help you line up the fitting. If you can't push the pipe or fitting all the way onto the iron, allow the heat to melt the polypropylene and then continue.

Remember that the fitting fusion heads are tapered; they will not offer much resistance until the fitting is almost entirely on.

Mechanically assisted fusions

For benchtop fabrication, it is generally faster and more accurate to use a fusion machine. Fusion machines act as an additional set of hands during the fusion, aligning the pipe and fitting while providing a mechanical advantage.

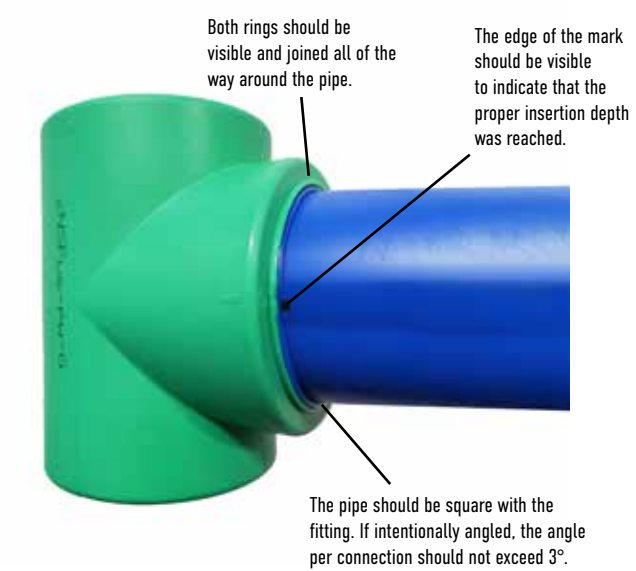
There are many different types of fusion machines. Some lighter machines are easier to operate overhead, but may not offer additional support or have a fixed heating iron. Heavier bench-style machines offer increased stability and accuracy, but are less mobile. Other fusion processes, such as butt fusion and electrofusion, require special tools.

These, as well as the tools for socket fusion, are available from Aquatherm's approved tool manufacturers. These manufacturers supply properly sized tools for Aquatherm's piping systems and have an established history of providing excellent support to Aquatherm installers.

A complete list of these manufacturers can be found starting on page 2.48. Do not use fusion tools from an unapproved manufacturer.

Specific indicators confirm your connections have been performed properly. However, you still will need to perform a pressure test to help ensure the joint's integrity. (Information on the pressure test can be found beginning on page 3.38.)

Certain fusion-assistance machines have integrated depth controls. These controls should be used for their accuracy, but it is best to mark the pipe for inspection. Some machines will not bring rings completely together, but this is acceptable as long as the gap is consistent and the pipe is inserted to the proper insertion depth.



Avoiding improper fusions

Don't twist

Never twist a fusion connection. Twisting prevents proper fusion of the material and will lead to a weakened connection. You may make some minor adjustments early in the cooling process, but avoid turning the fitting or pipe more than 2°.

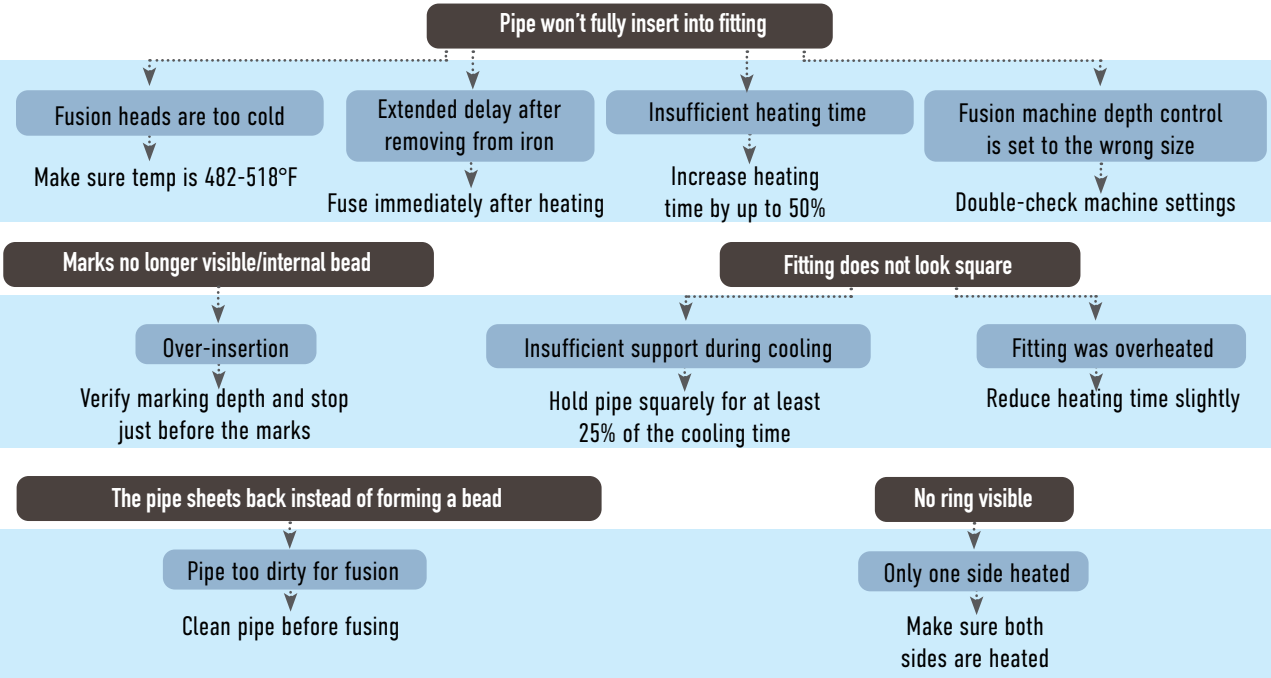
Prevent water contact

Like oil, polypropylene is hydrophobic and repels water. Any water contact on the fusion area will interfere with proper fusion and create a potential leak path. Make sure the pipe is dry before beginning the fusion.

Use enough heat

If the iron is too cold, the fitting or pipe experience an extended delay after they're removed from the iron, or the heat time is insufficent, you will not have enough heat to create a full connection. Insufficient heat will also result in potential leak paths in the joint.

Troubleshooting bad connections



Ovaling in machine-assisted fusions

Fusion heads are designed to operate under very specific tolerances, and compressing the end of a fitting can prevent proper contact and, thus, proper fusion. This is referred to as ovaling.

Ovaling occurs when a fusion machine's clamps exert too much force on the socket entrance and bend it out of round. To prevent the problem, avoid over-tightening the clamp that holds the front of the fitting. The clamps should be snug, but not so tight that they distort the fitting.

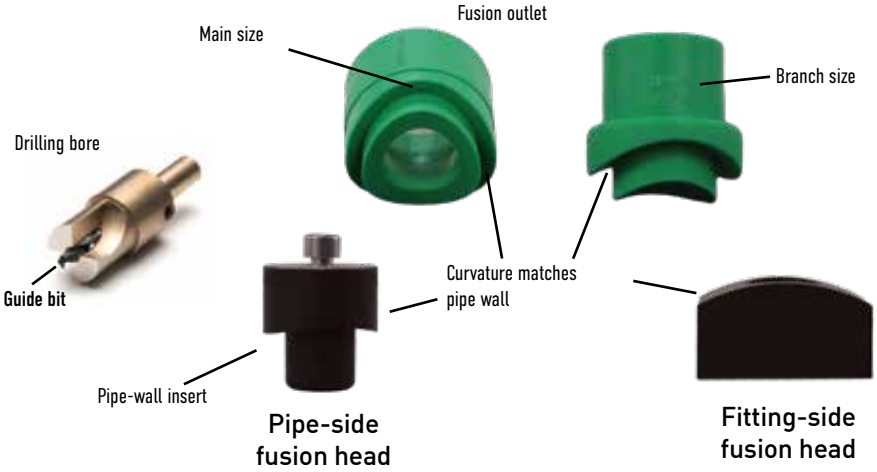
To prevent the fitting from slipping, use a backstop or support the fitting with your hand during insertion. Giving the iron time to heat the pipe and fitting also can reduce the chances of slippage.

To determine if your machine or technique are causing ovaling, look for two complete beads all of the way around the finished connection. If beads are present on two sides but absent on the other two sides, the fitting most likely was ovaled during fusion. Ovaled fittings are not fully functional and may leak.

Fusion outlets

Using a technique similar to socket fusion, branches and outlets can be added to pipe walls easily. This technique helps save time and money while providing flexibility for expansion following installation.

Alignment tools are available to aid in drilling the hole perpendicular to the pipe wall, and aligning the outlet fitting squarely with the pipe. Aquatherm does not require the use of these tools, but they can be very helpful in applying even pressure while heating, and properly aligning the fitting.



Fusion-outlet instructions

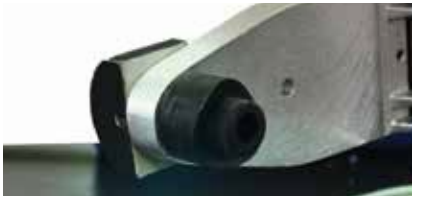
(page 1 of 3)

When drilling out a fusion-outlet hole, remember two important things:

Make sure to remove the material from the hole so it will not clog the main line.

The hole needs to be 1/24 in. - 1/8 in. (1-3 mm) smaller than the OD of the branch line.

Aquatherm's boring tools are sized properly and designed to remove any shavings. The boring tools use a hand-held drill with a 1/2 in. chuck. You may also use hole solutions provided by other manufacturers as long as they can cut a smooth, even, and properly-sized hole. Getting a properly sized hole is critical. An oversized hole will result in an incomplete fusion and cause leaks. An undersized hole will make it difficult to insert the fusion head and can create a larger internal bead, reducing flow performance.

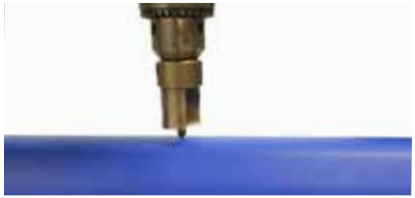


The fusion head should not stick out past the iron. This will lead to uneven heat transfer and can prevent proper fusion.

1. Set up the fusion iron following normal socket procedures, found on page 2.15.

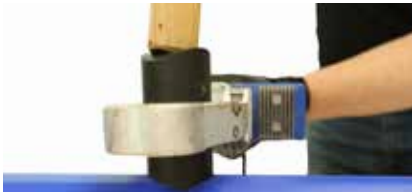
2. Don't forget to tighten the fusion heads after the plate is hot and check the temperature before starting.

3. Mark the pipe where you want the outlet. Use a center punch to make an indent on your mark to help the guide bit stay in place while drilling.

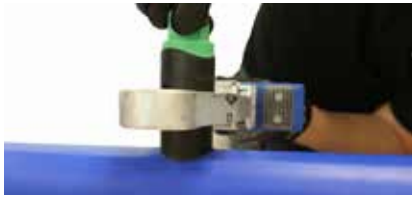


4. Use the guide bit to start the hole and ensure accurate positioning. Drill at a right angle to the pipe. Quickly drill out the hole.

5. The bore should pull the shavings out so they don't fall into the pipe. Clear away any excess debris. Flush any leftover shavings.



6. Rather than putting excessive force on the iron's neck, you can use a hardwood dowel to help push the iron into the pipe.



7. Insert the fusion head into the hole and fitting into the head. Push down gently to keep the iron in contact with the pipe and fitting.

Pro tip:

For branches smaller than 2 in., don't use the fitting to push the iron into the pipe. This overheats the fitting. Instead, push the fusion head into the pipe, then set the fitting on the iron. For larger sizes, you may use the fitting to push the fusion head into the pipe.

Fusion-outlet instructions

Pro tip:

Make sure the fusion head you are using matches the pipe and fitting. In an emergency, it is possible to use a head with the wrong curvature, but you must have the right branch size. Tilting the fusion head slightly from side to side can help ensure contact at all points.

8. Look for a bead to form around the fitting. It does not take much pressure. Too much pressure will cause internal restriction.

9. Ensure the fusion head makes a full impression on the pipe. Check and adjust the head until the ring is complete.

If the fusion head has not made a full impression, do not set the fusion outlet into the hole. It will not form a proper fusion.

10. Set the fitting in the hole and hold in place. Use only enough pressure to maintain contact between the heated surfaces.

11. Level and square the fitting as it cools. Like the socket fittings, you only have a few seconds before the fitting sets. The full cooling time before use is the same as a socket fitting of equal size.

For small holes in the pipe, such as holes from nails or screws, you can use the repair pin shown here. For larger holes, install and cap a fusion outlet fitting or remove the pipe and fuse in a new section. Repair sticks should not be used to fix leaks at a fusion location. A leaking joint must be repaired with a new fitting.

1. Attach the repair head to a fusion iron. Heads are available in 5/16" and 7/16" sizes. Use a size that is larger than the hole.

2. If the hole is too small, carefully drill it out. Use a 1/4" bit for the 5/16" head, and a 3/8" bit for the 7/16" head.

3. Insert the repair head into the pipe, and insert the repair pin into the repair head. Heat for 5 sec.

4. Remove the pin from the iron head and the repair head from the pipe. Insert the pin into the pipe wall. Do not overinsert the pin.

5. Once the pin has set, you may use cutters to remove the rest of the pin. Pressure test the system to ensure a proper repair.

Electrofusion is another technique for fusing a socket onto a pipe. Rather than using contact heat, electrofusion uses electrical resistance heat from a copper coil inside the fitting. The fitting is attached to an electrofusion machine using a pair of leads, and a set voltage is applied to the coil for a set time. The time and voltage can be found on the fitting label.

Electrofusion is particularly useful for situations in which there is not enough space or mobility to perform a traditional socket or butt fusion. However, electrofusion has more steps and is more difficult to inspect visually. Therefore, the choice to use electrofusion over traditional socket fusion depends on the installation's physical restrictions and the installer's preferences. Electrofusions may be integrated with traditional socket fusion and butt fusion if necessary.

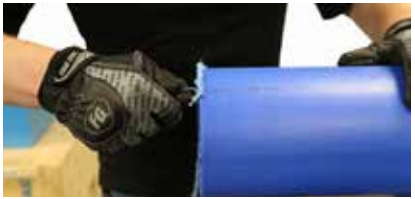
Electrofusion machines are available from approved tool manufacturers.

Caution: Be sure to check the voltage of the machine to ensure that it matches the required voltage of the fitting (40.0 V).

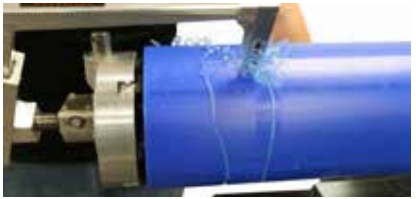
Electrofusion Coupling Dwell Times

Coupling P/N	Dimension (ND - OD)	Heat Time (seconds)	Cooling Time (minutes) Secured Position
1040020984	½" - 20 mm	27 s	10 min
1040020985	¾" - 25 mm	35 s	10 min
1040032986	1" - 32 mm	50 s	10 min
1040040987	1 ¼" - 40 mm	60 s	10 min
1040050988	1 ½" - 50 mm	95 s	10 min
1040063989	2" - 63 mm	105 s	10 min
1040075990	2 ½" - 75 mm	105 s	10 min
1040090991	3" - 90 mm	150 s	15 min
1040110992	3 ½" - 110 mm	200 s	15 min
1040125993	4" - 125 mm	260 s	15 min
1040160994	6" - 160 mm	280 s	15 min
1040200995	8" - 200 mm	470 s	30 min
1040250996	10" - 250 mm	800 s	30 min

Electrofusion instructions



1. Make sure the pipe is cut exactly square to ensure proper contact. Chamfer or ream the pipe to remove any rough edges.



2. Use a peeling tool to remove the outside of the pipe. Peel back at least half the length of the coupling being fused.

Pro tip:

Peeling tools are available from approved manufacturers. Make sure that you use metric or metric-compatible peelers. If the coupling doesn't slide easily onto the pipe, repeat another peel. Multiple passes may be necessary. However, avoid over-peeling the pipe

3. Repeat with the other pipe. If you are using the fitting as a slip coupling, peel one side back the entire length of the coupling.

4. Clean the outside of the pipes with an isopropyl alcohol (91% or higher). Avoid touching those surfaces after cleaning them.

5. Don't open the fitting bag until you are ready to fuse the connection. This helps keep dirt off of the fusion surface.

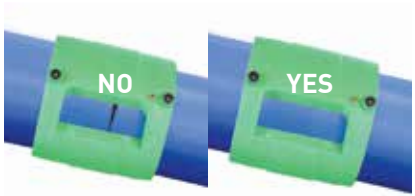
6. Mark the pipe at half the depth of the fitting. The two pipe sections will meet in the middle.

✕ Do not touch the peeled pipe or inside the fitting. Any oils, dirt, dust, or other contaminants may ruin the connection.

7. Insert the pipes into the fitting. The pipes should fit snugly, but without excessive force. You should be able to pull them apart.

Pro tip:

If the fitting cannot be pushed into the coupling without a significant amount of force, make another pass with the peeling tool. Remember to wipe the fusion surface with isopropyl alcohol (91% or higher), as the peeler may be dirty.



✕ Make sure there is no gap in the middle. You won't be able to see the gap, so use your depth marks.

8. Use an alignment tool to ensure both sides of the pipe and fitting are fully supported for the entire fusion process including cool-down.

Electrofusion instructions

(page 3 of 3)

9. Attach the leads to the fitting. Most leads slide in with little resistance, so don't force them. Be careful not to bend them.

10. Scan fitting lable. Rescan if needed. On smaller couplings, the lable can be removed and laid flat for better reading.

11. Verify that the display matches the lable. If the label and the machine don't match, rescan the fitting label or input manually.

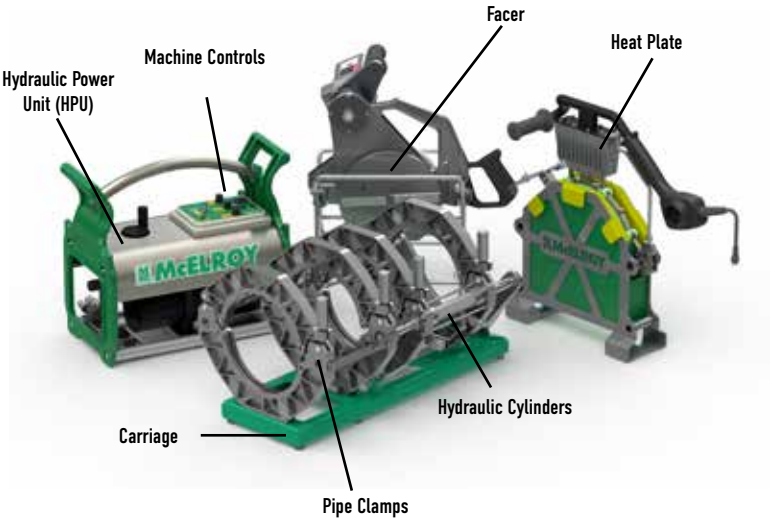
12. Follow the directions on the machine. Verify your prep work and then begin heating upon confirmation.

13. Remove leads when heating is finished. The pipe and fitting will get hotter before cooling down again.

The black indicator on the top of the fitting will drop in after the connection is done heating, as long as the electrical leads are pointing up. You will only be able to verify the fusion during the pressure test. All electrofusion sockets are rated to 300 psi.

Butt fusion is the process of using heat and pressure to join the faces of two pieces of pipe together. This eliminates the need for a socket-type fitting while maintaining the full strength of the connection. As with any fusion, the primary elements are heat and pressure. Therefore, a butt fusion machine is designed to provide both as well as support the pipe and prepare the pipe face for fusion.

Aquatherm supports butt fusion on sizes 6 in. and larger on all SDRs as well as 4 in. on SDR 9, 11, and 17.6. Installers may decide to butt fuse smaller sizes at their own risk.

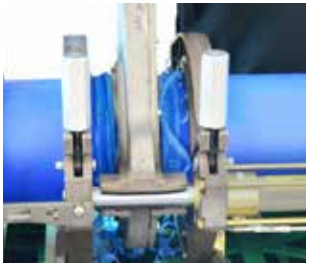


Butt fusion overview

The basic steps to successful butt fusion.

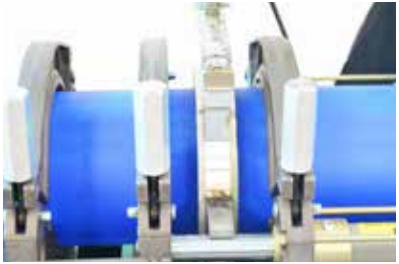
1. Prep → 2. Clean → 3. Clamp/Align → 4. Face



5. Bead-up/Adjustment

6. Heat



7. Fusion/Cool

Butt fusion instructions: 1. Preparation

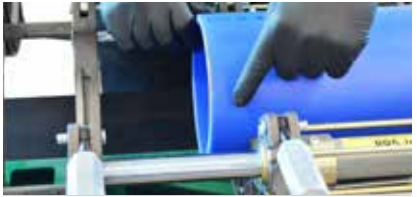
Maintenance should be performed only by trained people, the manufacturer, or authorized dealer. Only refill the hydraulic oil according to the manufacturer's specifications. Make sure that your power supply is fully compatible with the machine you are using.

1.1 Set up and inspect the machine. Follow all of the manufacturer's directions. Perform any maintenance as needed.

1.2 Check and tighten seals as needed. Release any air bubbles by bringing the machine to full pressure and slowly releasing it.

1.3 Inspect and turn on fusion iron. Make sure the iron is clean and set to proper tempuarture. Verify temperature prior to each fusion.

1.4 Set in the correct metric inserts, if needed. The manufacturer will know which clamps and inserts are compatible.



1.5 Cut the pipe at least ½ in. longer than your intended final length (or longer if your cut is not square).

2.1 Prior to fusing, clean the pipe ends to remove any dirt, dust, residue or other contaminants, and then wipe with a clean cloth and isopropyl alcohol (91% or higher).

2.2 Before fusing, clean the facer to remove any contaminants, and then wipe with a clean cloth and isopropyl alcohol (91% or higher).

Pro tip:

Some manufacturers offer different blade materials for extended longevity, and some blades are reversible. Check with your distributor or manufacturer's rep for more information.

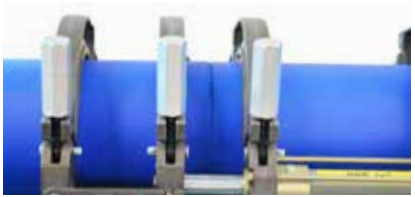
2.3 Prior to fusing, clean the iron to remove any dirt, dust, or other contaminants. Then wipe with a clean cloth and isopropyl alcohol (91% or higher).

Butt fusion instructions: 3. Clamp/Align

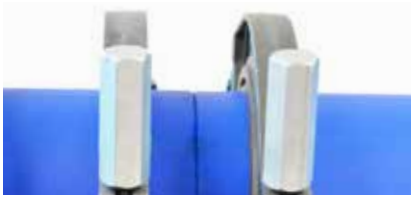
3.1 Set pipe and/or fitting into the clamps. If possible, use at least two clamps for each pipe length. Adjust configuration as needed.

3.2 Leave a lip of 1/2 -1 in. (more if cut is uneven). A thumb's width is normally a good amount. Leave enough room for the facer.

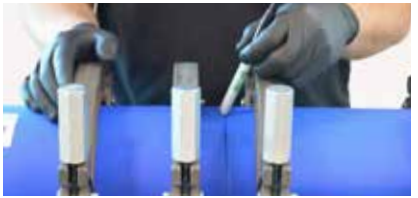
3.3 Reposition clamps to accommodate fittings as needed. Some clamps slide, and others can be removed entirely.



3.4 Tighten clamps and bring the pipe ends together. Make sure all hands are clear of the carriage while it is in motion.



3.5 Align print/paint lines on each pipe as desired (but not necessary) and tighten the clamps.



3.6 Check the pipes' alignment by running your finger or the end of a pen across the gap. If one side is higher than the other, tighten it down.

Butt fusion instructions: 4. Facing

4.1 Open the carriage. Set and lock in the facing tool. Turn on the facer, and let it reach full speed. Never turn on the facer if it is pinched between pipes.

4.2 Close the pipes on facer. Increase pressure until the facer begins shaving off ribbons of polypropylene. Don't use excessive pressure.

4.3 Drive the carriage forward whenever the pressure drops or the facer stops facing. Replace the blades if they are dull.

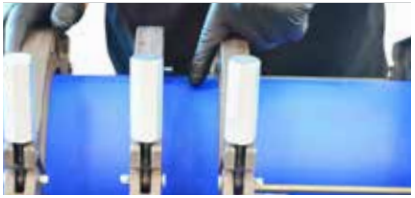
Pro tip:

If one side begins facing before the other, try opening and closing the clamps again to give the facer a "bump." You also can try inserting wood blocks between the clamps and the planing tool to force the facer to shave the opposite side. Facing to a pre-marked point can ensure proper length of the finished connection.

4.4 Proper facing will produce full-width strips on both sides. Now open the carriage to separate the pipes while facer is still moving. Adjust facer if one side is ready before the other.

4.5 Switch off and remove the facer. Don't turn off the facer while the carriage is still closed, as this can leave nicks on the pipe face.

Butt fusion instructions: 5. Adjustment/Beadup



5.1 Close the carriage and check for gaps. Reface or realign as needed. Wipe down the pipe face with 91% isopropyl alcohol.

Pro tip:

Make sure the two pieces being connected are still approximately ¼" longer than your desired final length. You will lose roughly ⅛" off each side of the connection during the adjustment and fusion phases. Measure and track your average loss to increase accuracy.

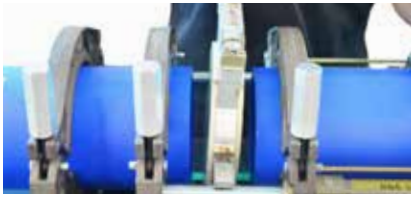
5.2 Set your full fusion pressure level (see below regarding negative drag pressure). Controls vary by manufacturer. Don't change this pressure after setting it.

Drag pressure: Find the drag pressure by increasing the pressure control until the carriage begins to move. Drag pressure varies by machine design and orientation as well as pipe size.

Negative drag pressure: Most fusion orientations are such that when you are determining drag pressure, the controls are in the closed position. In other words, the orientation is where the pipes tend to be forced apart and you have to shift to the closed position and increase pressure until the pipe just begins to close.

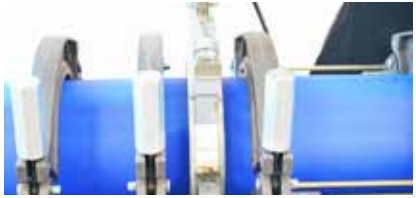
There may be situations where the orientation is such that the pipes tend to be forced together. This requires you to shift the machine to the open position and increase the pressure until the carriage just begins to open. This pressure is called negative drag and you must subtract it from the machine pressure.

Machine pressure: Look up the machine pressure in the tables starting on page 2.48. Machine pressure varies by pipe size and SDR for each type of machine.



5.3 Open the carriage and insert the heating iron. Make sure your heating iron is at 410±18°F (210±10°C).

5.4 Close the pipes onto the heating iron under full pressure to begin formation of the adjustment bead.



5.5 Build your adjustment bead to the specified height. The guide is on page 2.55. Do not let your bead get larger than required.

Full fusion pressure: Add the drag and machine pressures to get full fusion pressure.

Positive drag pressure Full Fusion Pressure = Machine Pressure + Drag Pressure

Negative drag pressure Full Fusion Pressure = Machine Pressure - Drag Pressure

Confirm that your equipment can perform under negative drag conditions. Some equipment may not be able to accommodate negative drag scenarios. Make sure to follow the equipment manufacturers' instructions when dealing with negative drag.

Butt fusion instructions: 6. Heat

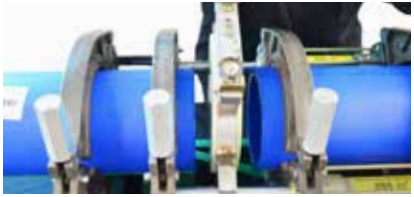
6.1 With the adjustment bead complete, drop the system to drag pressure. If necessary to maintain contact, add up to 10% of machine pressure.

Pro tip:

Butt fusion machines from different manufacturers have different ways of releasing from fusion pressure to drag pressure for the heating phase (or heat soak). Refer to the tool manufacturer's manual for more information.

The heating phase requires as little pressure as possible. Some machines lock in place only requiring the drag pressure. Others require a slight positive pressure to keep them in place, but never more than drag plus 10% machine pressure. Excessive pressure during the heating phase can create a restriction in the pipe.

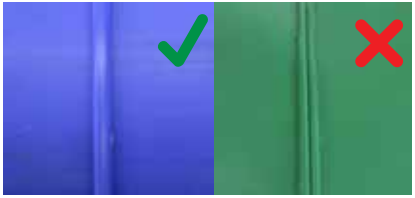
6.2 Use a timer and observe the entire heating time. Too little or too much heating time will create an improper connection.



7.1 Open the carriage and remove the iron. Make sure you have a safe place to set the iron down.

7.2 Bring the pipes together within the transition time. Ensure the machine achieves full fusion pressure within the pressure buildup time.

7.3 Wait for the connection to cool. Do not try to shorten the cooling time by pouring water on the connection.



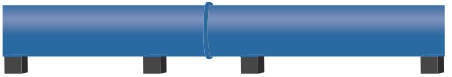
7.4 The final bead should look like one solid piece. A bad fusion joint will have a split bead with two distinct sides.

7.5 Release the pressure, and undo clamps. Don't loosen the clamps until the pressure has been released completely.

7.6 Remove the connection from the machine. Remember to keep the pipe supported if you want to reduce the cooling time.

Reducing cooling times

Butt fusion needs to cool under pressure to ensure proper connections. Cooling times for butt fusion connections can be reduced if the joint is supported properly and not subjected to any loads for the remainder of the cooling time.



Correct

Whether on hangers or blocks, the pipe should be supported on either side of the connection as well as further down the line to prevent deflection.

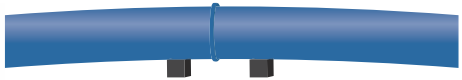
Correct

The pipe also can lay flat on the ground or a similar level surface.

For example, at 70°F the cooling time for 6 in., SDR 11 pipe can be reduced from 14 min. to 9 min. if the joint is not subjected to any stress for the remaining 5 minutes. The following images show proper and improper pipe support.

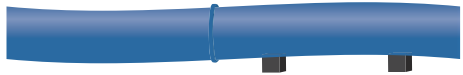
Incorrect

Failure to support the pipe near the connection can result in undue stress on the bottom of the joint.



Incorrect

Failure to support the pipe further away from the center can result in undue stress at the top of the joint.



Incorrect

Failure to support the pipe on both sides of the connection can cause undue stress across the joint.

Fusing different SDRs

To fuse pipes with different SDRs, you will need to make the following modifications:

Use the heat time from the lower SDR (thicker wall) pipe or fitting.

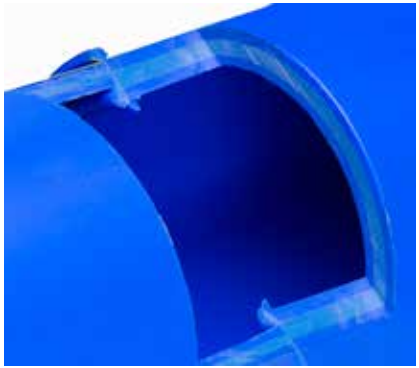
Use the pressure from the higher SDR (thinner wall) pipe or fitting.

Use the average bead height of the two pipes.

The external bead should appear normal. The internal bead will appear lopsided, but this is not an issue.

The system will have the pressure rating of the highest SDR (thinnest wall) material that is fused into the system.

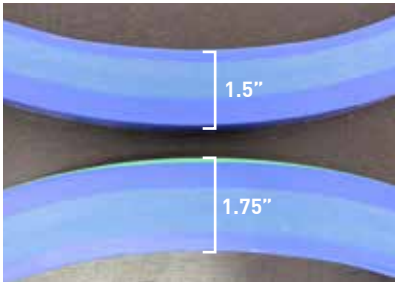
As a general rule, you should avoid butt-fusing different SDRs unless it is absolutely necessary. You should never attempt to butt fuse pipes with different ODs.

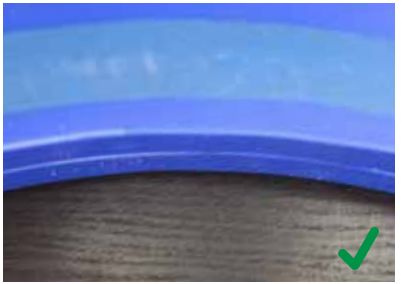


Internal alignment

Because of gravity and the physics of extrusion, larger pipes tend to be slightly thicker on the bottom than they are on the top. However, the top always will be at least as thick as the production SDR, so there is no concern over pressure and temperature ratings.

The difference is not enough to cause problems with flow calculations or require a change in fusion pressures. The only concern is simple aesthetics: the internal bead will be misshapen if a thinner top is fused to a thicker bottom. To avoid the problem, line up the tops and bottoms of the pipe before fusing them. The easiest way to align the pipes is using the printstrip on the side, as the print is always in the same position relative to the top of the pipe. Aligning the printstrip will help eliminate internal misalignment. If aligning the print does not fix the issue, use your best judgment when aligning the pipe. This does not affect the outer wall of the pipe, which always will be consistent.





Butt Fusion Tool Manufacturers and Fusion Parameters

Widos machine pressure

678-766-1250
info@widoswelding.com
www.widoswelding.com

Installers should always use the operator's manual included with the butt fusion machine or the manufacturer's online information to calculate the machine pressure. This table is based on the information available to Aquatherm at the time of this manual's printing and may not be complete, accurate, or current. If there is a discrepancy between this table and any information provided by the tool manufacturer, the tool manufacturer's information shall be considered correct.

Dimension ND (OD mm)	SDR	Maxiplast	W4400	W4600	W4900	W4911 & 4955	W5100 & 5500	W6100
		lb	Machine pressure, bar					
4" (125 x 7.1)	17.6	58	11	6	5	5	-	-
4" (125 x 11.4)	11	89	17	8	7	7	-	-
4" (125 x 14.0)	9	108	20	10	9	9	-	-
6" (160 x 9.1)	17.6	94	18	9	8	8	-	-
6" (160 x 14.6)	11	145	27	13	12	12	-	-
6" (160 x 17.9)	9	176	32	16	14	14	-	-
6" (160 x 21.9)	7.4	207	39	19	17	17	-	-
8" (200 x 11.4)	17.6	-	-	13	12	12	5	-
8" (200 x 18.2)	11	-	-	20	18	18	8	-
8" (200 x 22.4)	9	-	-	25	22	22	9	-
8" (200 x 27.4)	7.4	-	-	29	26	26	11	-
10" (250 x 14.2)	17.6	-	-	21	18	18	8	-
10" (250 x 22.7)	11	-	-	32	28	28	12	-
10" (250 x 27.9)	9	-	-	38	33	33	14	-
10" (250 x 34.2)	7.4	-	-	45	40	40	17	-
12" (315 x 17.9)	17.6	-	-	-	29	29	12	10
12" (315 x 28.6)	11	-	-	-	44	44	19	15
12" (315 x 35.2)	9	-	-	-	53	53	22	18

Widos machine pressure

Dimension ND (OD mm)	SDR	W4911 & 4955	W5100 & 5500	W6100
		Machine pressure, bar		
14" (355 x 20.1)	17.6	36	15	13
14" (355 x 32.2)	11	56	24	19
14" (355 x 39.7)	9	67	28	23
16" (400 x 22.7)	17.6	-	20	16
16" (400 x 36.3)	11	-	30	24
18" (450 x 25.5)	17.6	-	25	20
18" (450 x 40.9)	11	-	38	31
20" (500 x 28.4)	17.6	-	30	25
24" (630 x 35.7)	17.6	-	-	39

Full fusion pressure = machine pressure + drag pressure

Refer to tool manufacturer's manual for mitered fitting machine pressures.

McElroy machine pressure

McELROY
918-836-8611
fusion@mcelroy.com
www.mcelroy.com

Installers should always use the operator's manual included with the butt fusion machine or the manufacturer's online information to calculate the machine pressure. This table is based on the information available to Aquatherm at the time of this manual's printing and may not be complete, accurate, or current. If there is a discrepancy between this table and any information provided by the tool manufacturer, the tool manufacturer's information shall be considered correct.

Dimension ND (OD mm)	SDR	Rolling, TracStar® 250	Acrobat™ 160	Acrobat 250	Acrobat 315	Polygon™	Rolling, TracStar® 412 & 618	MegaMc® 824, TracStar® 630
		Machine pressure, pounds per square inch (psi)						
4" (125 x 7.1)	17.6	36	66	66	-	59	19	-
4" (125 x 11.4)	11	55	101	101	-	91	29	-
4" (125 x 14.0)	9	66	121	121	-	109	35	-
6" (160 x 9.1)	17.6	58	108	108	-	97	31	-
6" (160 x 14.6)	11	90	166	166	-	149	48	-
6" (160 x 17.9)	9	108	198	198	-	179	57	-
6" (160 x 21.9)	7.4	127	235	235	-	211	67	-
8" (200 x 11.4)	17.6	91	-	168	103	-	48	16
8" (200 x 18.2)	11	141	-	259	159	-	74	25
8" (200 x 22.4)	9	168	-	310	190	-	89	30
8" (200 x 27.4)	7.4	199	-	367	225	-	105	35
10" (250 x 14.2)	17.6	142	-	263	161	-	75	25
10" (250 x 22.7)	11	220	-	405	248	-	116	39
10" (250 x 27.9)	9	263	-	484	296	-	139	46
10" (250 x 34.2)	7.4	311	-	573	351	-	164	55
12" (315 x 17.9)	17.6	-	-	-	255	-	120	40
12" (315 x 28.6)	11	-	-	-	394	-	184	61
12" (315 x 35.2)	9	-	-	-	471	-	220	73

McElroy machine pressure

Dimension ND (OD mm)	SDR	Rolling, TracStar® 412LF & 618LF	MegaMc® 824LF, TracStar® 630LF	Acrobat™ with QuikFit™ Carriage
		Machine pressure, psi		
14" (355 x 20.1)	17.6	152	50	255
14" (355 x 32.2)	11	234	78	393
14" (355 x 39.7)	9	280	93	470
16" (400 x 22.7)	17.6	193	64	324
16" (400 x 36.3)	11	297	99	499
18" (450 x 25.5)	17.6	244	81	410
18" (450 x 40.9)	11	376	125	632
20" (500 x 28.4)	17.6	-	100	506
24" (630 x 35.7)	17.6	-	159	803

Full fusion pressure = machine pressure + drag pressure
Refer to tool manufacturer's manual for mitered fitting machine pressures.

Ritmo machine pressure

863-679-8655
info@ritmoamerica.com
www.ritmoamerica.com

Installers should always use the operator's manual included with the butt fusion machine or the manufacturer's online information to calculate the machine pressure. This table is based on the information available to Aquatherm at the time of this manual's printing and may not be complete, accurate, or current. If there is a discrepancy between this table and any information provided by the tool manufacturer, the tool manufacturer's information shall be considered correct.

Dimension ND (OD mm)	SDR	Gamma 160	Basic/Delta Dragon 160	Basic/Delta Dragon 200	Basic/Delta Dragon 250B	Basic/Delta Dragon 315B	Basic/Delta Dragon 355B
		[N]	Machine pressure, psi				
4" (125 x 7.1)	17.6	263	196	121	65	-	-
4" (125 x 11.4)	11	406	303	187	100	-	-
4" (125 x 14.0)	9	485	361	223	119	-	50
6" (160 x 9.1)	17.6	431	327	198	106	94	44
6" (160 x 14.6)	11	665	497	306	164	145	68
6" (160 x 17.9)	9	794	591	365	195	172	81
6" (160 x 21.9)	7.4	951	707	436	234	206	97
8" (200 x 11.4)	17.6	-	-	310	166	147	69
8" (200 x 18.2)	11	-	-	477	256	226	107
8" (200 x 22.4)	9			570	305	269	127
8" (200 x 27.4)	7.4	-	-	682	366	322	152
10" (250 x 14.2)	17.6	-	-	-	366	228	108
10" (250 x 22.7)	11	-	-	-	399	352	166
10" (250 x 27.9)	9			-	477	421	199
10" (250 x 34.2)	7.4	-	-	-	571	503	238
12" (315 x 17.9)	17.6	-	-	-	-	363	171
12" (315 x 28.6)	11	-	-	-	-	558	264
12" (315 x 35.2)	9			-		668	316

Ritmo machine pressure

Dimension ND (OD mm)	SDR	Basic/Delta Dragon 355B	Basic/Delta Dragon 500	Basic/Delta Dragon 630
		Machine pressure, psi		
14" (355 x 20.1)	17.6	217	-	150
14" (355 x 32.2)	11	335	-	232
14" (355 x 39.7)	9	401	253	278
16" (400 x 22.7)	17.6	-	174	191
16" (400 x 36.3)	11	-	269	294
18" (450 x 25.5)	17.6	-	220	241
18" (450 x 40.9)	11	-	340	373
20" (500 x 28.4)	17.6	-	272	298
24" (630 x 35.7)	17.6	-	-	473

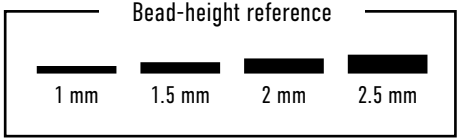
Full fusion pressure = machine pressure + drag pressure

Refer to tool manufacturer's manual for mitered fitting machine pressures.

Adjustment bead height

(4"- 24")

Size	SDR 7.4	SDR 9	SDR 11	SDR 17.6
4" (125 mm)	-	0.04" (1.0 mm)	0.04" (1.0 mm)	0.04" (1.0 mm)
6" (160 mm)	0.06" (1.5 mm)	0.04" (1.0 mm)	0.04" (1.0 mm)	0.04" (1.0 mm)
8" (200 mm)	0.08" (2.0 mm)	0.06" (1.5 mm)	0.04" (1.0 mm)	0.04" (1.0 mm)
10" (250 mm)	0.08" (2.0 mm)	0.08" (2.0 mm)	0.06" (1.5 mm)	0.04" (1.0 mm)
12" (315 mm)	-	0.08" (2.0 mm)	0.08" (2.0 mm)	0.04" (1.0 mm)
14" (355 mm)	-	0.10" (2.5 mm)	0.08" (2.0 mm)	0.06" (1.5 mm)
16" (400 mm)	-		0.08" (2.0 mm)	0.06" (1.5 mm)
18" (450 mm)	-		0.1" (2.5 mm)	0.06" (1.5 mm)
20" (500 mm)	-		-	0.06" (1.5 mm)
24" (630 mm)	-		-	0.08" (2.0 mm)



The height of the bead is important during the fusion, as too small of a bead may lead to an improper connection, whereas too large of a bead can create a flow restriction and also may indicate a problem with fusion pressure. You will need to carefully watch the bead during the adjustment phase and reduce the pressure once the bead reaches its required height.

Remember that 1 mm is only 1/25th of an inch and is difficult to measure. Generally, a bead is at its 1 mm height when you first see it. If your final bead (when the connection is all finished) looks too large, try reducing the size of your adjustment bead slightly.

Butt fusion heating and cooling times (4"- 10")

Dimension		Heating	Fusion		Fuse/inspect/cool			
ND (OD x Wall thickness in mm)	SDR	Heating time	Maximum transition time	Time of pressure buildup	Ambient ⩽ 60°F (15°C)	Ambient 60-80°F (15-25°C)	Ambient 80-105°F (25-40°C)	Reduced Cooling, no load*
4" (125 x 7.1)	17.6	1 min., 22 sec.	6 sec.	7 sec.	6 min.	8 min.	10 min.	5 min.
4" (125 x 11.4)	11	2 min., 8 sec.	7 sec.	10 sec.	9 min.	11 min.	15 min.	8 min.
4" (125 x 14.0)	9	2 min., 34 sec.	8 sec.	13 sec.	11 min.	14 min.	18 min.	9 min.
6" (160 x 9.1)	17.6	1 min., 44 sec.	6 sec.	9 sec.	7 min.	9 min.	12 min.	6 min.
6" (160 x 14.5)	11	2 min., 41 sec.	8 sec.	13 sec.	11 min.	14 min.	19 min.	9 min.
6" (160 x 17.9)	9	3 min., 14 sec.	9 sec.	16 sec.	13 min.	17 min.	23 min.	11 min.
6" (160 x 21.9)	7.4	3 min., 53 sec.	10 sec.	19 sec.	16 min.	21 min.	27 min.	14 min.
8" (200 x 11.4)	17.6	2 min., 8 sec.	7 sec.	10 sec.	9 min.	11 min.	15 min.	8 min.
8" (200 x 18.2)	11	3 min., 18 sec.	9 sec.	16 sec.	13 min.	17 min.	23 min.	12 min.
8" (200 x 22.4)	9	3 min., 56 sec.	10 sec.	19 sec.	16 min.	21 min.	28 min.	14 min.
8" (200 x 27.4)	7.4	4 min., 43 sec.	11 sec.	23 sec.	20 min.	25 min.	34 min.	17 min.
10" (250 x 14.2)	17.6	2 min., 37 sec.	8 sec.	13 sec.	11 min.	14 min.	18 min.	9 min.
10" (250 x 22.7)	11	4 min., 1 sec.	10 sec.	20 sec.	17 min.	21 min.	28 min.	14 min.
10" (250 x 27.9)	9	4 min., 46 sec.	11 sec.	24 sec.	20 min.	26 min.	34 min.	17 min.
10" (250 x 34.2)	7.4	5 min., 35 sec.	13 sec.	29 sec.	25 min.	31 min.	41 min.	21 min.

*No load on joint, properly supported for the full duration of the standard cooling time

Butt fusion heating and cooling times (12”- 24”)

Dimension		Heating	Fusion		Fuse/inspect/cool			
ND (OD x Wall thickness in mm)	SDR	Heating time	Maximum transition time	Time of pressure buildup	Ambient ⩽ 60°F (15°C)	Ambient 60-80°F (15-25°C)	Ambient 80-105°F (25-40°C)	Reduced Cooling, no load*
12” (315 x 17.9)	17.6	3 min., 15 sec.	9 sec.	16 sec.	13 min.	17 min.	23 min.	11 min.
12” (315 x 28.6)	11	4 min., 53 sec.	12 sec.	24 sec.	21 min.	26 min.	35 min.	18 min.
12" (315 x 35.0)	9	5 min., 45 sec.	13 sec.	30 sec.	26 min.	32 min.	43 min.	22 min.
14” (355 x 20.2)	17.6	3 min., 37 sec.	9 sec.	18 sec.	15 min.	19 min.	25 min.	13 min.
14” (355 x 32.3)	11	5 min., 23 sec.	13 sec.	28 sec.	24 min.	30 min.	39 min.	20 min.
14” (355 x 39.7)	9	6 min., 19 sec.	16 sec.	34 sec.	29 min.	36 min.	48 min.	25 min.
16” (400 x 22.8)	17.6	4 min., 1 sec.	10 sec.	20 sec.	17 min.	21 min.	28 min.	14 min.
16” (400 x 36.3)	11	5 min., 57 sec.	14 sec.	31 sec.	27 min.	33 min.	44 min.	23 min.
18” (450 x 25.6)	17.6	4 min., 27 sec.	11 sec.	22 sec.	19 min.	24 min.	32 min.	16 min.
18” (450 x 40.9)	11	6 min., 28 sec.	15 sec.	35 sec.	30 min.	38 min.	50 min.	25 min.
20” (500 x 28.4)	17.6	4 min., 51 sec.	12 sec.	24 sec.	21 min.	26 min.	35 min.	18 min.
24” (630 x 35.8)	17.6	5 min., 52 sec.	14 sec.	31 sec.	26 min.	33 min.	44 min.	22 min.

*No load on joint, properly supported for the full duration of the standard cooling time

Chapter 3: Planning

Beyond heat fusion, there are a number of differences between installing Aquatherm pipe and installing other systems. This chapter will discuss important installation details, such as pipe sizing, hanger spacing, expansion controls, insulation, and pressure testing.

Aquatherm offers extensive fabrication services to provide potential labor and material savings. For more information, please visit at: *aquatherm.com/fabrication-services.*

Technical Bulletins

Aquatherm works hard to deliver the best training and most accurate product information available to you, the installer.

However, because of the wide variety of applications in which Aquatherm PP-R and PP-RCT pipe are used, as well as the ongoing development of third-party tools, clamps, insulations, and other solutions, staying up on the best practices requires a bit of effort.

To keep you informed of new techniques and requirements, Aquatherm frequently releases Technical Bulletins to fill in the gaps between editions of the Installer Manual. Technical Bulletins also give more detailed explanations of some additional installation techniques and safety precautions.

As a result, in the event of a discrepancy between this Installer Manual and the current Technical Bulletins on the Aquatherm website, the bulletins should be considered correct.

Aquatherm recommends reading the Technical Bulletins in addition to this manual.

These Technical Bulletins can be found at:
aquatherm.com/technical-bulletins

Clamps and hangers

If you are installing metal clamps, use only rubber-lined or insulated clamps, as shown here. Metal clamps should never be directly tightened down on hot water piping. The pipe must be able to expand outward slightly when heated to avoid excessive localized stresses. The rubber/elastomeric lining material must be at least 0.125 in. (3mm) thick) Plastic clamps sized for use with metric-OD pipe are generally acceptable without additional lining material.

Metal clamps–even plastic-safe clamps–can damage hot-water pipes and can condense when used on cold-water pipe. When installing chilled water lines in high-humidity areas, use a non-crushable pipe shield. Metal that is in direct contact with Aquatherm PP-R and PP-RCT pipe may sweat in certain chilled applications, even if the pipe itself shows no signs of condensation. Do not tighten metal clamps directly onto pipe at locations where the support is being used as a fixed-point/anchor. Rubber-lined clamps will provide sufficient friction to prevent pipe movement. Clamps must be installed in accordance with the clamp manufacturer's instructions including proper bolt torque and use of spacers or other means to avoid over-tightening the clamp and creating excessive localized stress in the pipe wall.

See also Technical Bulletin 201207E-AQTTB.

Also, refer to the Aquatherm TechTV video: aquatherm.com/videos/support-considerations

Anchors and guides

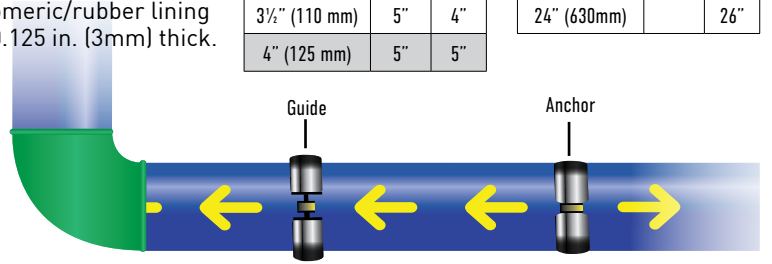
For the purposes of supporting the pipe and addressing linear expansion, there are two types of supports: anchors and guides. Anchors are tight against the pipe and prevent movement through that point. Guides support the pipe, but are loose and allow movement through the joint.

There are many available options for metric-size supports. Aquatherm Technical Bulletin 201207E provides additional guidance in selecting proper pipe clamps for the Aquatherm pipe. Properly sized metric clamps/supports should be used whenever possible. However, IPS or CTS size supports may be used when sized correctly. The table to the right provides the proper sizing when using IPS or CTS clamps and hangers on bare pipe. Larger clamps/hangers will be needed to fit over insulation and/or pipe shields.

Hangers or clamps used as guides must allow free movement of the pipe in the axial direction and allow for circumferential expansion of the pipe. Hangers or clamps used as anchors or fixed points on hot water pipe must include an elastomeric/rubber lining at least 0.125 in. (3mm) thick.

	Hanger Size	
Pipe Size	CTS	IPS
½" (20 mm)	¾"	½"
¾" (25 mm)	1"	¾"
1" (32 mm)	1¼"	1"
1¼" (40 mm)	1½"	1¼"
1½" (50 mm)	2"	2"
2" (63 mm)	2 ½"	2½"
2½" (75 mm)	3"	3"
3" (90 mm)	3½"	3½"
3½" (110 mm)	5"	4"
4" (125 mm)	5"	5"

	Hanger Size	
Pipe Size	CTS	IPS
6" (160 mm)	8"	6"
8" (200 mm)	8"	8"
10" (250 mm)	10"	10"
12" (315 mm)		12"
14" (355 mm)		14"
16" (400mm)		16"
18" (450mm)		18"
20" (500mm)		20"
24" (630mm)		26"



Joining spools: Socket and butt fusion




When pre-fabricating spool pieces, you will need to have a plan for installing spools once they are built. Time saved utilizing pre-fabrication can be lost trying to rework sections that aren't easy to join together.

Traditional fusion methods (socket and butt fusion) require space for a few inches of axial movement. If that space for lateral movement is available, then socket and butt fusion will be the most cost-effective and secure means of joining the spools. For straight lengths do not move unclamped spools until the fusion time is completed.

Places where the pipe changes direction, such as at elbows, allow an installer to take advantage of the pipe's flexibility.

(See page 3.33 as well as the Aquatherm North America Design & Planning Guide for safe bending lengths.) Using a fusion machine, the installer can force the pipe to bend, perform the fusion, and bring the pipe and fitting together for a square connection (see photo series above).

Joining spools: Flanges

Flange adaptors can join the pipe to itself or another material. Aquatherm flange connections consist of two parts: an adaptor and a ring (see the Aquatherm North America Design & Planning Guide). Flange adaptors are commonly used to connect to equipment or metal piping. Flange transitions are available up to 24 in.

Planning for flanged spools will include considerations for the thickness of a gasket and any equipment being installed between the spools, such as valves. This affects both the spools' build lengths as well as the bolts' length.

See Technical Bulletin 201405B-AQTTB - Flanges and Butterfly Valve Installation Guidelines.

Also refer to Aquatherm TechTV Flanges: aquatherm.com/videos/flanges.

In areas where axial movement is not possible, electrofusion couplings can join pipe sizes up to 10 in. without axial movement.

One side of the pipe is peeled back far enough for the electrofusion socket to be used as a slip coupling (right). Once the spool is in place, the coupling is slid back to center (below).

Refer to Technical Bulletin 201603A - AQTTB - Electrofusion Couplings.

Support intervals

With PP-R and PP-RCT, the hanger spacing varies with the maximum temperature of the pipe.

The maximum temperature is the highest temperature the pipe will be subjected to, either from the internal fluid or the ambient conditions. Note that a pipe with no flow will eventually reach the same temperature as the ambient conditions, which can be much warmer or colder than the pipe is during normal operation.

Warning – Aquatherm piping should NOT be used to support equipment such as pumps, strainers, backflow preventers and any other system component, device or mounted equipment not provided by Aquatherm. Equipment and components must have their own support separate from the Aquatherm piping and associated supports used for the Aquatherm piping. Valves 6-in. and larger may also require additional support or shorter support spacing on either side of the valve.

Note: These support intervals are based on the pipes carrying water. If the pipes are carrying a fluid that is denser than water, additional support may be required. Alternative spacing should be confirmed in the chemical compatibility report.

Support intervals (SDR 17.6 MF)

Maximum temperature	Pipe diameter									
	4" 125 mm	6" 160 mm	8" 200 mm	10" 250 mm	12" 315 mm	14" 355 mm	16" 400 mm	18" 450 mm	20" 500 mm	24" 630 mm
	Support intervals									
86°F (30°C)	8.4'	8.5'	8.7'	9.0'	9.2'	9.4'	9.7'	10.0'	10.3'	10.8'
104°F (40°C)	6.1'	6.2'	6.6'	6.7'	6.9'	7.1'	7.5'	7.9'	8.4'	9.2'
122°F (50°C)	5.7'	5.9'	6.2'	6.4'	6.6'	6.7'	7.2'	7.5'	8.0'	9.0'
140°F (60°C)	5.6'	5.7'	5.9'	6.2'	6.2'	6.4'	6.9'	7.4'	7.7'	8.7'

Support intervals (SDR 11 MF)

Maximum temperature	Pipe diameter																
	½" 20 mm	¾" 25 mm	1" 32 mm	1¼" 40 mm	1½" 50 mm	2" 63 mm	2½" 75 mm	3" 90 mm	3 ½" 110 mm	4" 125 mm	6" 160 mm	8" 200 mm	10" 250 mm	12" 315 mm	14" 355 mm	16" 400 mm	18" 450 mm
	Support intervals																
86°F (30°C)	4.0'	4.6'	5.2'	5.9'	6.7'	7.5'	8'	8.5'	9.5'	10.5'	11.2'	11.3'	11.5'	12.5'	13.5'	15'	16'
104°F (40°C)	4.0'	4.0'	4.0'	4.4'	5.1'	5.7'	6.1'	6.4'	7.1'	7.9'	8.9'	9.0'	9.2'	10.1'	11'	14'	15'
122°F (50°C)	4.0'	4.0'	4.0'	4.4'	5.1'	5.7'	6.1'	6.4'	6.9'	7.4'	8.0'	8.2'	8.4'	9.2'	10'	12'	13'
140°F (60°C)	4.0'	4.0'	4.0'	4.1'	4.8'	5.4'	5.7'	6.1'	6.6'	7.1'	7.7'	7.9'	8'	8.7'	9.5'	11'	12'
158°F (70°C)	4.0'	4.0'	4.0'	4.1'	4.8'	5.4'	5.7'	6.1'	6.2'	6.4'	6.7'	6.9'	7.1'	7.8'	8.5'	10'	11'
176°F (80°C)	4.0'	4.0'	4.0'	4.0'	4.4'	5.1'	5.4'	5.7'	5.9'	6.1'	6.4'	6.6'	6.7'	7.1'	7.5'	9.0'	10'
200°F (93°C)	4.0'	4.0'	4.0'	4.0'	4.0'	5.0'	5.2'	5.3'	5.4'	5.5'	5.6'	5.7'	5.8'	6.1'	6.5'	7.2'	8.2'

Support intervals (SDR 9 MF)

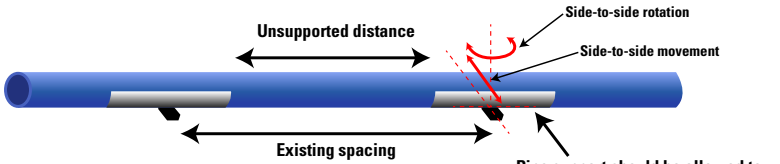
Maximum temperature	Pipe diameter												
	1" 32 mm	1¼" 40 mm	1½" 50 mm	2" 63 mm	2 ½" 75 mm	3" 90 mm	3½" 110 mm	4" 125 mm	6" 160 mm	8" 200 mm	10" 250 mm	12" 315 mm	14" 355 mm
	Support intervals												
86°F (30°C)	5.2'	5.9'	6.7'	7.5'	8.0'	8.5'	9.5'	9.9'	10.2'	10.3'	10.7'	11.0'	11.2'
104°F (40°C)	4.0'	4.4'	5.1'	5.7'	6.1'	6.4'	7.1'	7.4'	7.4'	7.9'	8.0'	8.2'	8.4'
122°F (50°C)	4.0'	4.4'	5.1'	5.7'	6.1'	6.4'	6.9'	6.9'	7.1'	7.4'	7.6'	7.9'	8.0'
140°F (60°C)	4.0'	4.1'	4.8'	5.4'	5.7'	6.1'	6.6'	6.6'	6.7'	7.1'	7.4'	7.4'	7.6'
158°F (70°C)	4.0'	4.1'	4.8'	5.4'	5.7'	6.1'	6.2'	6.1'	6.4'	6.7'	7.1'	7.2'	7.2'
176°F (80°C)	4.0'	4.0'	4.4'	5.1'	5.4'	5.7'	5.9'	5.7'	6.1'	6.4'	6.6'	6.7'	6.9'
200°F (93°C)	4.0'	4.0'	4.0'	4.7'	5.1'	5.3'	5.5'	5.3'	5.6'	6.0'	6.2'	6.5'	6.6'

Increased hanger spacing

In some applications, the positioning of hangers is determined by outside factors, such as a retrofit with hangers from previous metal pipes. In order to accommodate for these variations, installers may use an in-line support, like the one shown here.

The supported distance can be added to the hanger spacing. For example, a pipe with a 6-ft spacing requirement can be hung on 8-ft spacers if 2 ft of the pipe is supported in-line.

The supports must be rigid enough to support the filled pipe, and have a smooth surface to avoid damage to the pipe. Metal supports should not apply any compressive stress (pressure) on the outside of the pipe. The supports must be allowed to move in the pipe direction if in a guide, but should not be allowed to rotate/pivot at the guide. If used at an anchor point, the in-line support must be anchored against axial movement as well as rotation and side-to-side movement.



Note: Unsupported distance not to exceed Aquatherm support spacing (3.9-3.11)

Linear expansion

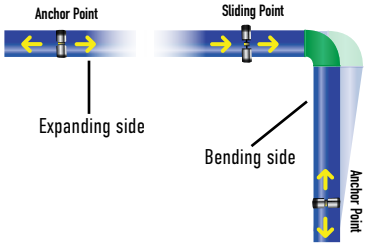
Linear expansion occurs when pipe is heated. The amount of expansion is determined by the change in temperature. It is important to know how much expansion will occur during system operation and plan for it. Aquatherm's MF pipes use a combination of glass fibers and PP-R or PP-RCT to reduce linear expansion and contraction by 75%.

To determine the sizes for various types of expansion controls, consult the Aquatherm North America Design & Planning Guide.

The MF extrusion process produces a middle layer with expansion-inhibiting properties. The percentage of PP-RCT is high enough to ensure proper fusion between layers during the extrusion process, so the middle layer cannot be separated from the inner and outer layers.

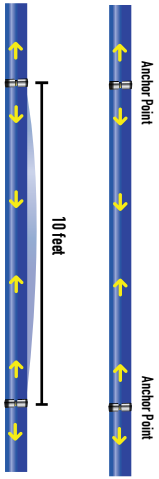
To control linear expansion, you will need to isolate and direct the expansion in a safe way. Expansion will move away from anchors and through guides until it reaches your expansion control or another anchor. On long runs, you should use an expansion control every 120 ft. Remember that branches and other fittings cannot expand through an anchor or guide. Common expansion controls include:

Bending leg: Expansion is directed to where the pipe changes direction. The force of the expansion is absorbed by the flexibility of the bending side.



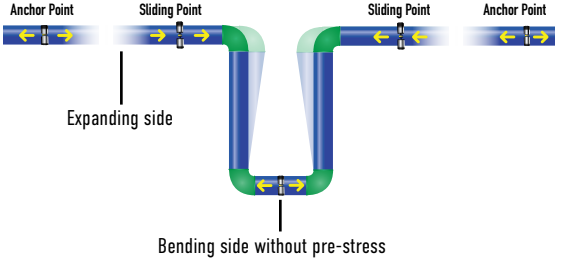
Linear isolation: For vertical installations, expansion can be contained to each floor, leaving each 10-ft space with a fraction of an inch of expansion. This will cause a slight bowing of the pipe, which can be minimized using a midfloor guide.

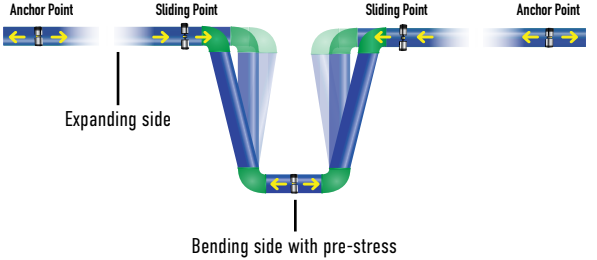
Note: Non-MF pipes in heated applications must have other expansion controls installed every 30 ft. Expansion should be handled by the engineer in the design documents, and those documents must be followed. The information here is for reference and verification only.



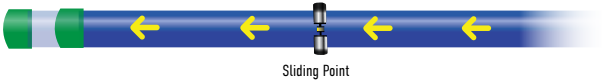
Expansion controls

Expansion loop: Used on long, straight runs. Two distant anchors direct expansion to a central loop. An expansion loop can be used on long straight runs. The loop can even be pre-stressed to accommodate additional expansion or to give a square appearance during operation.

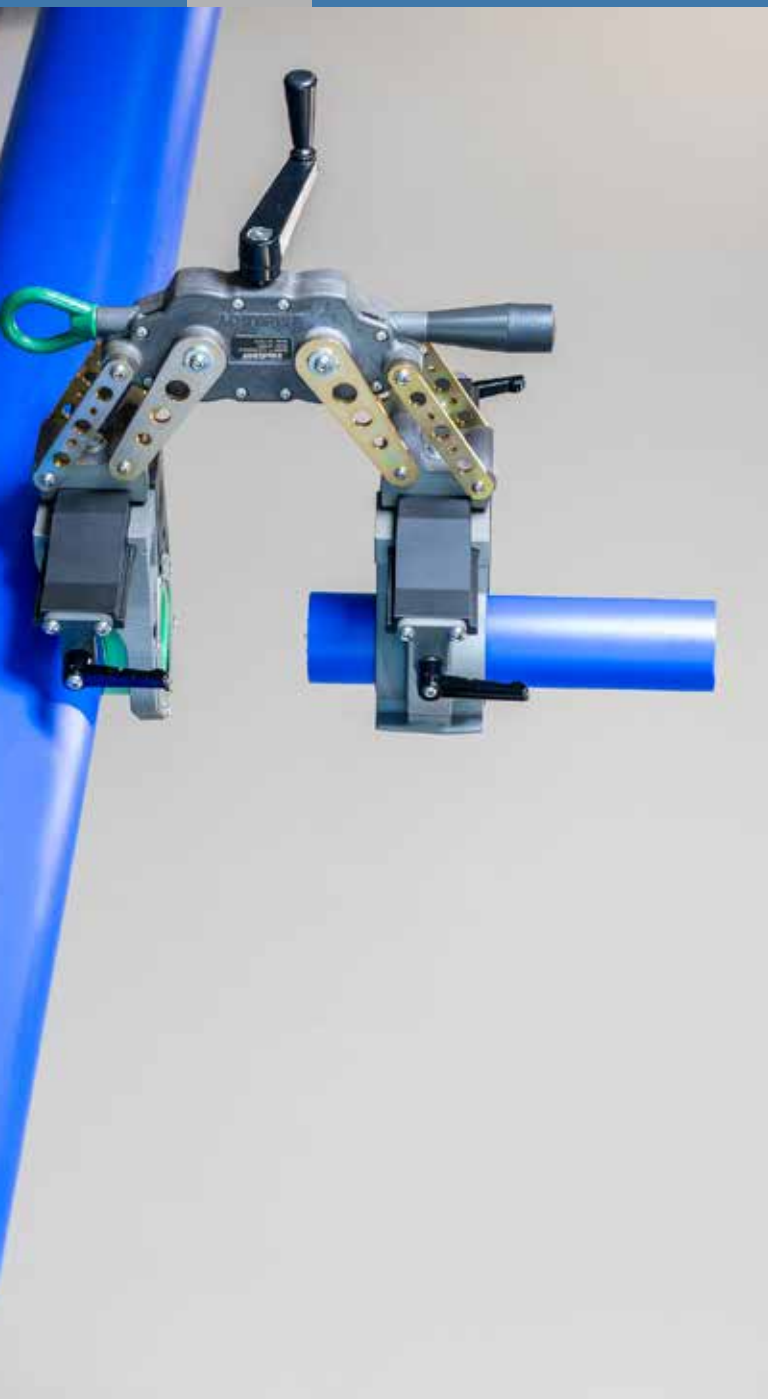




Sliding end: Used for short distances where the pipe ends with a cap. The distance between the end of the pipe and the wall (or other obstruction) must be less than the expansion. The pipe should be supported as close to the end as possible.




aquatherm



Aquatherm pipe is required to pass a system malfunction test of 8,760 hours (~1 year) at 230°F. This does not mean the pipe is intended to be operated at this condition, but rather that it can withstand temperatures above 200°F for a limited time. Therefore, Aquatherm pipe can be connected directly to a boiler in many cases.

Some codes may require a minimum of 18 in. of metal pipe from the boiler to the Aquatherm PP-R.

It is safest to complete all heat-producing connections, such as soldering, brazing, or welding, before making the Aquatherm piping connections to the metal pipe. When this is impossible, you can install a union that can be uncoupled until the metal piping installation is complete.

Never expose any PP-R or PP-RCT piping and transition fittings to temperatures in excess of 170°F during the metal piping installation process. This can distort and deform any O-ring seals and fitting connections, resulting in a leak.

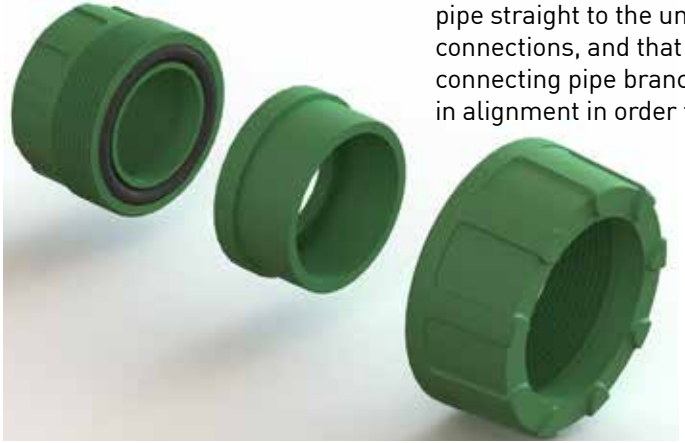
Where copper is used in a mechanical system, perform all solder joints on copper pipe at the following minimum distances from the PP-R pipe along the copper tube:

10" from a ½" or ¾" PP-R fitting or pipe;
18" from a 1" or 1¼" PP-R fitting or pipe;
20" from a 1½" PP-R fitting or pipe;
22" from a 2" (or larger) PP-R fitting or pipe.

For additional safety, use a commercial heat-blocking agent or heat shield between the solder joint and the PP-R or PP-RCT pipe; immediately cool the copper tube and the transition fitting after the soldering is completed.

Unions

Unions are designed to connect/reconnect two pieces of PP-R and PP-RCT pipe without the requirements of a more permanent connection, such as fusion. Unions contain an O-ring or gasket seal with a flat mating surface as shown in the figure below.



It is important to fuse the pipe straight to the union's connections, and that the connecting pipe branches be in alignment in order for the O-ring or gasket to make a flush connection with the union's flat mating surface. There should be no excessive gaps present between the union's O-ring or gasket and flat mating surface prior to threading the connection in order for the union to seal properly. Always support piping at the union, as excessive bending stress on the union may cause the union to leak over time.

Avoid cross threading the union nuts when assembling the union. PP-R unions only require a hand tight connection to seal. Do not over tighten. Excessive torque

Brass Union

PP-R Union

might result in leakage due to over compression of the seal and may permanently damage the body of the union. Strap wrenches may be used to tighten the PP-R union no more than 1/8 turn beyond hand-tight, and only if needed if leaks occur after the unions have been hand-tightened and proper alignment has been ensured. Replacement O-rings are available from Aquatherm. Brass unions will require wrenches to tighten the union connection.

Unions nuts may require further re-tightening following a startup where temperature changes have occurred within the system, such as in a heating or dual-temp system. Unions should be periodically checked and re-tightened if needed when operational changes have occurred in the system.

Bushings, reducers, and reducing couplings

To help limit the number of reducing fittings that a wholesaler must stock, Aquatherm uses bushings which are designed to be inserted into another fitting, such as a coupling, tee, or elbow. The larger spigot side acts like a piece of pipe and is the side from where the pipe is reduced. The smaller socket side is fused to the smaller diameter pipe.

The spigot side has a bevel on its face and a thicker wall than a normal socket connection. The socket side is labeled with the fitting dimension and has a stop on the inside, just like a regular socket fitting. Bushings are available in sizes from ½ in. to 4 in.

Reducers are used with larger pipes and are butt-fused on both sides. They may go directly onto a pipe or fitting.

Aquatherm also provides reducing couplings to reduce pipe during a straight run. Sizes smaller than 4 in. are socket fused on both ends. Sizes that reduce from larger than 4 in. to 4 in. or smaller will butt fuse on the larger size and socket fuse on the smaller size.

Bushing

The benefits of an all-polypropylene system can be realized up to 6 in. Aquatherm has available large-diameter PP-R ball valves.

True union ball valves, ½-2½ in.

The true union ball valves are designed to allow removal of internal components. The components are held in place by a seat retainer that can be tightened using a spanner wrench. When the valve is in the open position, the handle is directed away from the end with the retainer. The valve should be installed with the handle pointing downstream when the valve is open. This ensures the retainer is upstream and cannot be inadvertently removed while the system is pressurized.

See Technical Bulletin 201609A-AQTTB for further information.

ISO flange ball valve, 3-6 in.

The valves flange in-line and can be installed quickly and easily as long as the following items are addressed:

- The bolt-hole pattern is built to the ISO/ European standard. Therefore, flange rings and full face gaskets will need to match the pattern.
- The nuts inset in the valve are a coarse metric thread, and require metric bolting.
- Valves are provided with gasket and bolt kits, or these can be ordered separately as needed.

Threaded connections

Aquatherm offers a wide range of threaded transitions to connect with non-fusible system components. These transitions have a machined brass or stainless-steel thread mold-inserted into a PP-R base for maximum strength.

The brass transition components are zero-lead (<0.25% Pb) in accordance with the Safe Drinking Water Act (SDWA).

When installing these threaded connections, there are a few important things to remember:

- Only continue one or two turns past hand-tight, and do not bottom out. Use tape or a thread sealant intended for use with plastic fittings. **Do NOT bottom out in the threaded fitting**.
- Your sealant needs to be compatible with brass or stainless steel as you are not threading to PP-R.
- Always apply counter pressure on the fitting when tightening the connection. If the fitting has a hex head, place your wrench on it; a crescent wrench may give you a more secure fit. For fittings without a hex head, use a strap or pipe wrench on the PP-R body of the fitting.

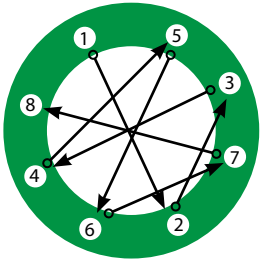
Excessive torque on the brass may cause the brass to turn in the PP-R body, which will result in a leaking fitting. Never tighten the mating components to the point where the brass insert moves. Over-tightening to the point where the brass insert moves will require the fitting to be removed and replaced.

FPT Hex Brass

MPT Round SS

MPT Hex Brass

To transition to other piping systems and mechanical equipment, Aquatherm provides a full range of flange adapters. Aquatherm's flange rings are uniquely designed to have a metric center and an ANSI bolt pattern. For a flange transition, you will need both the adapter (fusible fitting) and the ring.



Aquatherm recommends using a full-face rubber gasket (black EPDM or red SBR) with a minimum 1/8 in. thickness with its flanges. Viton® gaskets may also be used if needed for chemical resistance. The gasket should have an inside diameter consistent with the ID of the flange adapter.

Bolt tightening should follow the "star" pattern regardless of flange size and number of bolts (see example at left). Tighten all bolts to a third of the torque rating and repeat until fully tightened. Bolt length will depend on the thickness of gasket and flange ring being used. Bolts should

always be re-torqued within 24-48 hours of initial torque, and after a seasonal or operational change such as cooling to heating.

Refer to Technical Bulletin 201405B-AQTTB for detailed flange connection instructions, and also see the Aquatherm TechTV video: aquatherm.com/videos/flanges.

Bolt length table

Aquatherm Flange Adapter		Bolt Diameter	AQT Flange-to-Flange	AQT Flange-to-Steel	AQT Flange to BFV
Part no.	Description	in.	in.	in.	in.
0115512	1" (32 mm) – SDR 7.4	0.50	3.00	2.50	-
0115514	1 ¼" (40 mm) – SDR 7.4	0.50	3.25	2.75	-
0115516	1 ½" (50 mm) – SDR 7.4	0.50	3.50	2.75	-
0115518	2" (63 mm) – SDR 7.4	0.63	3.75	3.00	2.25
0115520	2 ½" (75 mm) – SDR 7.4	0.63	3.75	3.25	2.25
0115522	3" (90 mm) – SDR 7.4	0.63	4.00	3.50	2.25
0115524	3 ½" (110 mm) – SDR 7.4	0.63	4.25	3.75	-
0115526	4" (125 mm) – SDR 7.4	0.63	4.50	4.00	2.75
0115530BV	6" (160 mm) – SDR 7.4	0.75	5.50	4.50	3.25
0115534BV	8" (200 mm) – SDR 7.4	0.75	6.00	5.00	3.50
0115538BV	10" (250 mm) – SDR 7.4	0.88	7.00	5.50	4.00
0315530BV	6" (160 mm) – SDR 9	0.75	5.50	4.50	3.25
0315534BV	8" (200 mm) – SDR 9	0.75	6.00	5.00	3.50
0315538BV	10" (250 mm) – SDR 9	0.88	7.00	5.50	4.00
0315542BV	12" (315 mm) – SDR 9	0.88	8.00	6.00	4.75
0315544BV	14" (355 mm) – SDR 9	1.00	10.00	7.50	5.75

Bolt length table

Aquatherm Flange Adapter		Bolt Diameter	AQT Flange-to-Flange	AQT Flange-to-Steel	AQT Flange to BFV
Part no.	Description	in.	in.	in.	in.
0115531BV	6" (160 mm) – SDR 11	0.75	5.50	4.50	3.25
0115535BV	8" (200 mm) – SDR 11	0.75	6.00	5.00	3.50
0115539BV	10" (250 mm) – SDR 11	0.88	7.00	5.50	4.00
0115543BV	12" (315 mm) – SDR 11	0.88	7.00	5.50	4.25
0115545BV	14" (355 mm) – SDR 11	1.00	7.50	6.00	4.25
0115547BV	16" (400 mm) – SDR 11	1.00	8.00	6.50	4.75
0115549BV	18" (450 mm) – SDR 11	1.13	9.00	7.00	5.75
2915530BV	6" (160 mm) – SDR 17.6	0.75	5.50	4.50	3.25
2915534BV	8" (200 mm) – SDR 17.6	0.75	6.00	5.00	3.50
2915538BV	10" (250 mm) – SDR 17.6	0.88	7.00	5.50	4.00
2915542BV	12" (315 mm) – SDR 17.6	0.88	6.00	5.00	3.75
2915544BV	14" (355 mm) – SDR 17.6	1.00	6.50	5.50	4.00
2915546BV	16" (400 mm) – SDR 17.6	1.00	7.00	6.00	4.25
2915548BV	18" (450 mm) – SDR 17.6	1.13	8.00	6.50	5.25
2915550BV	20" (500 mm) – SDR 17.6	1.13	8.00	6.50	5.50
2915554BV	24" (630 mm) – SDR 17.6	1.25	8.50	7.00	6.25

Aquatherm flange bolt torque and size

Nominal pipe size	Torque		Bolts		
	N-m	ft-lb	Number	Diameter	Washers
½"	9	7	4	½	Yes
¾"	14	10	4	½	Yes
1" (32 mm)	15	11	4	½	Yes
1¼" (40 mm)	20	15	4	½	Yes
1½" (50 mm)	30	22	4	½	Yes
2" (63 mm)	35	26	4	⅝	Yes
2½" (75 mm)	40	30	4	⅝	Yes
3" (90 mm)	40	30	4	⅝	Yes
3½" (110 mm)	50	37	8	⅝	Yes
4" (125 mm)	50	37	8	⅝	Yes
6" (160 mm)	60	44	8	¾	Yes

Nominal pipe size	Torque		Bolts		
	N-m	ft-lb	Number	Diameter	Washers
8" (200 mm)	75	55	8	¾	Yes
10" (250 mm)	95	70	12	⅞	Yes
12" (315 mm)	142	105	12	⅞	Yes
14" (355 mm)	203	150	12	1	Yes
16" (400 mm)	244-366	180-270	16	1	Yes
18" (450 mm)	271-407	200-300	16	1⅛	Yes
20" (500 mm)	271-407	200-300	20	1⅛	Yes
24" (630 mm)	393-590	290-435	20	1 ¼	Yes

Note: These are typical values for rubber gaskets with lubricated or plated bolts. Values may be increased for harder gaskets or plain/un-plated bolts. Bolted connections must include washers on the nuts side as well as the bolt head side of the connection.

Aquatherm flange adapters can be used directly with ANSI butterfly valves. A spacer is not required to allow the butterfly valve to operate properly.

Tolerances with some butterfly valves may be very tight. Opening the valve before bolting it in place can help center the valve and ensure proper actuation.

Refer to Technical Bulletin 201405B-AQTTB for detailed butterfly valve connection instructions.

Branch lines

Pipe size	Thread size		
	½"	¾"	1"
1¼"	M/F	M/F	
1½"	M/F	M/F	
2"	M/F	M/F	
2½"	M/F	M/F	F
3"	M/F	M/F	F
3½"	M/F	M/F	F
4"	M/F	M/F	F
6"	M/F	M/F	F
8"	F	F	F
10"	F	F	F

M = MPT thread available
F = FPT thread available

Pipe size	Outlets available
1¼"	½" - ¾"
1½"	½" - ¾"
2"	½" - 1"
2½"	½" - 1 ¼"
3"	½" - 1 ¼"
3½"	½" - 1 ½"
4"	½" - 2"
6"	½" - 3"
8"	½" - 4"
10"	½" - 4"
12"	2" - 6"
14"	2" - 8"
16"	2" - 10"
18" - 24"	2" - 12"

There are two ways to install branch lines on Aquatherm pipe: tees and outlets. Tees are full-sized fittings that either socket fuse or butt fuse in-line. They usually are used for branches that are within two sizes of the main line.

Outlets are smaller fittings that use outlet fusion to attach to the side of the pipe, see outlet fusion installation in Chapter 2. The table immediately to the left gives the available branches for each pipe size.

The table on the far left shows the available outlets with metal threads.

Unlike many other piping materials, PP-R and PP-RCT are able to absorb the stress caused by expansion within certain limits. The MF construction helps keep the pipe within these limits for most applications.

In cases where the pipe needs to be buried in soil, sand, or concrete, PP-R and PP-RCT are safe, non-leaching, and resistant to crushing or damage. Aquatherm pipe also is suitable for directional boring, if a properly sized pulling head is used.

Buried installations generally do not require additional consideration for the expansion of MF pipes. Resistance to movement from the concrete or backfill will restrict the natural expansion or contraction of the pipe. The expansive force of PP-R and PP-RCT are much lower than metal pipes.

Aquatherm pipe is safe to use with insulating backfills. When penetrating through concrete on an application where the pipe may expand or contract, or otherwise be subjected to movement or lateral forces, a shield or protective layer must be used and should be installed per local codes. It is best to anchor the pipe at that location.

Thrust blocking: Because of the inherent strength and integrity of fused connections, thrust blocking is not required in buried applications.

Maximum pull force

The following table gives the maximum pull force for directional boring or similar applications. Make sure that the pull heads you are using are compatible with metric polypropylene pipe. Pull forces include a 2.5 safety factor.

Pipe diameter	SDR 9	SDR 11	SDR 17.6
6" - 160 mm	13,570	11,350	7,360
8" - 200 mm	21,200	17,740	11,500
10" - 250 mm	33,120	27,720	17,970
12" - 315 mm	52,590	44,010	28,530
14" - 355 mm	66,790	55,890	36,240
16" - 400 mm	-	70,960	46,010
18" - 450 mm	-	89,810	58,230
20" - 500 mm	-	-	71,890
24" - 630 mm	-	-	114,140

Note: For smaller pipe sizes see the Aquatherm Design & Planning Guide chapter 3.

In general, Aquatherm does not recommend bending Aquatherm pipe as a means of making a change in direction or going around obstacles. However, there are instances when the pipe is required to bend, such as buried and trenchless applications.

The pipe may be bent or bowed a maximum of 5° off straight in a 20-ft section or to a bending radius of 100 x the pipe OD. For an 8-in SDR 11 pipe with an OD of 200 mm (or 7.87 in.), the bending radius is 787 in. or 66 ft.

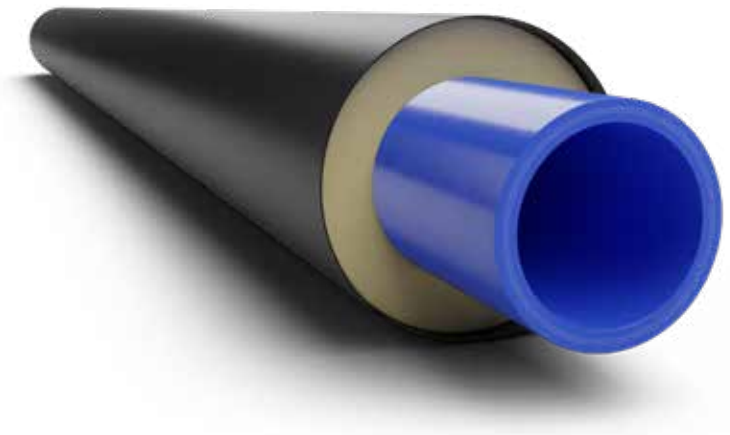
This applies for all SDRs and pipe diameters for **aquatherm blue**, with and without multi-layer, faser-composite. The only exceptions to this are Aquatherm's coiled tubing products.

When using coiled Aquatherm products for radiant floor, snow melt, field/turf warming, or similar applications, the bending radius should be no less than 8 x OD of the tubing being used. For example, ½-in. tubing with an OD of 20 mm, 8 x 20 = 160 mm bending radius; 160 mm = 6.3 in. bending radius or 12 in. on center. Always bend the tubing in the coil direction and use a bending guide to prevent the tube from kinking.

Please note that considerable force may be required to field bend the pipe, and the pipe may spring back forcibly if the restraints slip or are released inadvertently while bending or after installation. Observe appropriate safety precautions during field bending.

Insulation sizing

Insulation sizing: Aquatherm pipe is made using a metric OD, so standard insulations do not always fit over the pipe. The table on the right gives the closest fit between IPS and CTS pipe sizes and the best fit using only the more common IPS size.



Pre-formed insulation		
Aquatherm ND	Best fit	Best IPS fit
½"	½" IPS	½"
¾"	¾" IPS	¾"
1"	1" IPS	1"
1¼"	1½" CTS	1¼"
1½"	2" CTS	2"
2"	2 ½" CTS	2 ½"
2 ½"	3" CTS	3"
3"	3 ½" CTS	3 ½"
3½"	4" IPS	4"
4"	5" CTS	5"
6"	6" IPS	6"
8"	8" CTS	8"
10"	10" CTS	10"
12"	12" IPS	12"

UV radiation can damage and weaken PP-R and PP-RCT over time. Avoid exposing Aquatherm pipe and fittings to UV radiation.

Transport and storage: Aquatherm pipes come in UV-resistant bags or wrap for storage and transport. Leave the pipes in these bags or wrap until you are ready for installation.

Installation: Aquatherm offers its pipes with a UV protective layer. This upgrade is ideal for UV protection because it does not require maintenance. However, extra preparation is needed for installation (see 3.36). Another option is to paint the pipe. Painted pipe may need to be recoated or maintained. Aquatherm recommends using an elastomeric paint, which will expand and contract with the pipes. Visit: *aquatherm.com/ancillary-products* for paint options.

You also may paint the pipe for non-UV reasons. Standard acrylic, enamel, epoxy, and latex paints do not harm the pipe. Painting the pipe is considered an aftermarket modification and Aquatherm does not assume any responsibility for the performance of the paint.

Refer to Aquatherm Technical Bulletin 201311A-AQTTB -UV Protection.

Fusing UV pipe

To fuse the Aquatherm UV-protected pipe, you will need to remove the outer layer[1]. The outer layer is a black polyethylene, and it is factory extruded over the top of normal **aquatherm blue®**. You may still need to protect or paint the fittings depending on amount of UV exposure expected.

Mark the pipe one size up from its actual size. This protects the black layer from the heat-fusion process.

Cut around the outside of the pipe, just through the black layer. A rolling cutter works well. Do not cut into the pipe wall.

Cut from the mark to the edge of the pipe. Wear protective gloves, and mind your fingers.

Use a knife to pry up the edge of the black layer. Re-score the cuts if they are not deep enough.

Peel back and remove the black layer. Fuse the pipe following normal guidelines.

1 – Note on UV outlets

When installing fusion outlets on UV pipe, the UV layer must be removed at the fitting location for proper fusion to occur. Measure the diameter of the fusion heads and remove an additional 1/8" of UV layer beyond the intended fusion area. A utility knife can be used to cut the UV layer. Be careful to only cut the UV layer and not the pipe underneath. At the start of the heating process, check to ensure that the heater is not in contact with the UV layer.

Flushing: Before beginning operation, flush the system to remove dust, pipe shavings, and other particles that may have fallen into the pipe. Make sure the system is flushed in a safe manner that doesn't damage or clog any components. Unless otherwise required, water is sufficient for flushing the system.

The following concerns should be addressed before the installed piping is put into service:

1. Protection of the water quality
2. Avoidance of corrosion damage to metallic components in the system
3. Avoidance of malfunctions of pumps and equipment such as strainers and valves
4. Cleanliness of the inner surface of the pipe for optimal flow

These requirements can be met by:

1. Flushing the system with clean, clear water
2. Flushing the system with a mixture of air and water
3. Flushing the system with a medium as may be determined by local codes, engineering specifications, or the needs of the mechanical equipment used

Where no requirements are established, potable water is sufficient for flushing Aquatherm piping systems.

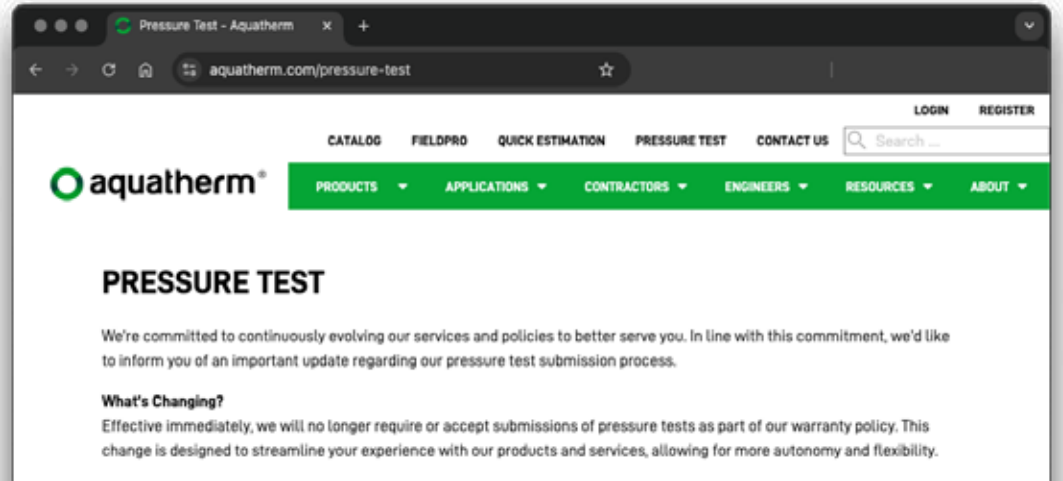
Flushing of the entire system should be continued until the water coming out of the piping system runs clear of any debris, particulates, oils, or other contaminants. If flushing with chemicals other than those already noted, please contact the Aquatherm Engineering Department to verify compatibility.

If disinfection is required, please refer to the Technical Bulletin 201301A – AQTTB – Disinfecting Aquatherm Piping Systems.

Pressure testing (page 1 of 16)

The following test procedure is intended to help ensure a leak-free system upon completion of product installation by properly trained installers

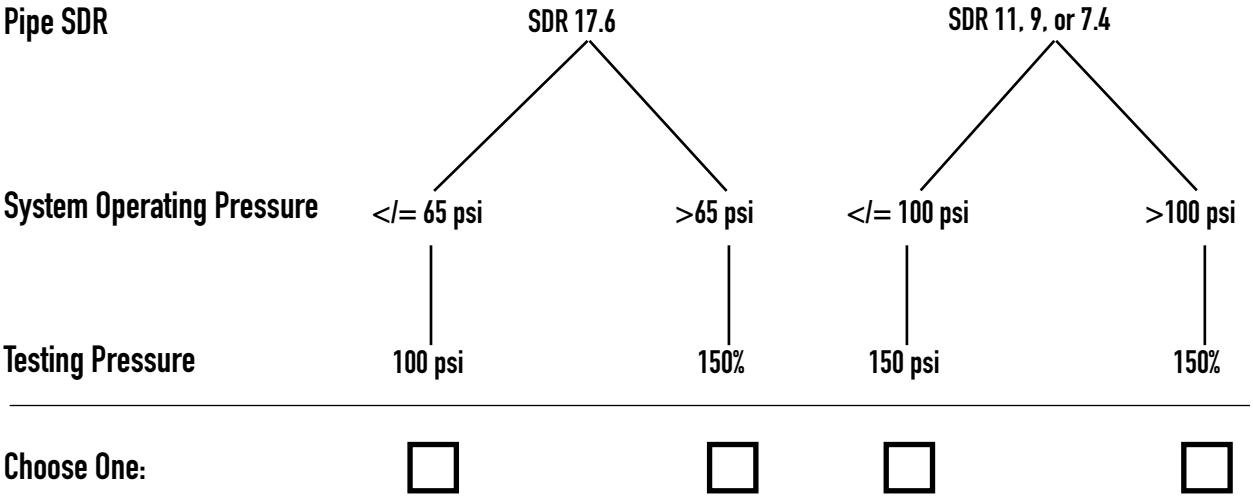
While every effort is made to ensure the procedure given here is up to date, the most current method should be used, and can be found at https://aquatherm.com/pressure-test by clicking on "View Pressure Test".



Step 1: Determine your testing pressure. To help ensure the integrity of the heat fusion connections, a pressure test must be performed on the completed system. The amount of pressure used depends on the type of pipe and intended pressure of the application.

- If the piping system has a mixture of SDR pipe, you should test to the higher SDR's (thinner walled pipe's) testing requirements. For example, if the piping system contains SDR 17.6 pipe and SDR 11 piping, you should test to the requirements of the SDR 17.6 piping.
- If the piping system contains SDR 17.6 pipe and has an intended operating pressure of 65 psi or lower, the system must be tested at 100 psi.
- If the piping system contains SDR 17.6 pipe and has an intended operating pressure higher than 65 psi, the system must be tested at 150% of the intended operating pressure or a maximum of 200 psi[7].
- If the system contains only SDR 11 or heavier-walled pipe (lower SDR) and has an intended operating pressure of 100 psi or less, the system must be tested at 150 psi.
- If the system contains only SDR 11 or heavier-walled pipe (lower SDR) and has an intended operating pressure higher than 100 psi, the system must be tested at 150% of the intended operating pressure.
- If you have concerns regarding your testing pressure, please contact Aquatherm.

Pressure testing



Step 1: Determine your testing pressure (cont.).

The following are maximum testing pressures for high-rise buildings or high-pressure systems. The maximum testing pressures should not exceed the following:

Pipe	Maximum Test Pressure Allowed
PP-RP (RCT) SDR 9	400 psi
PP-RP (RCT) SDR 11	320 psi
PP-RP (RCT) SDR 17.6	200 psi

Pressure testing (page 5 of 17)

Step 2: Low Pressure (<15 psi) **Leak Check**
Prior to conducting the Aquatherm Pressure Test (cyclic, 30-min hydrostatic, and 2-hr hydrostatic tests), it is recommended to perform a low-pressure preliminary test to check for leaks or open-end pipes. Air may be used for this test; however, the pressure must not exceed 15-psi.

WARNING: Temperature changes can significantly affect the pressure of compressed air. Exceeding 15 psi can result in a hazardous condition with risk of injury or death.

While this preliminary low-pressure leak check may be performed with air, the Aquatherm Pressure Test must be performed with water only, due to its incompressibility.

Step 3: Observe safety protocols. It is important for the tester and all others at the project site to observe all safety recommendations from Aquatherm until the testing is complete.

For all systems:

- Visually inspect the connections for signs of proper fusion, following the guidelines provided during training and given in the Aquatherm Installer Manual. Socket connections should have two even rings of melted plastic ("beads"), and a visible depth mark. Butt fused connections should have a single bead with a rounded top. This inspection is most easily done during the fusion process. The absence of these signs may be indicative of an improper fusion.
- Ensure all air has been completely purged from the system prior to pressure testing. Entrapped air can result in significant pressure surges and violent, dangerous and catastrophic rupture.
- Remove all fusion equipment from the system before starting the pressure test.
- Set your pressure gauge near the lowest point[3] of the system, where the pressure will be highest. This reduces the risk of over-pressurizing the system.
- Observe the system during the test for any indications of leaks. If a leak is found, relieve all test pressure and repair the leak before continuing.

(continued on next page)

Step 4: Perform the test.[2] Follow the steps in the order indicated below. Use a pressure test gauge that is accurate to within 0.5 psi. The cyclic, 30-min hydrostatic, and 2-hr hydrostatic tests must be performed with water only.

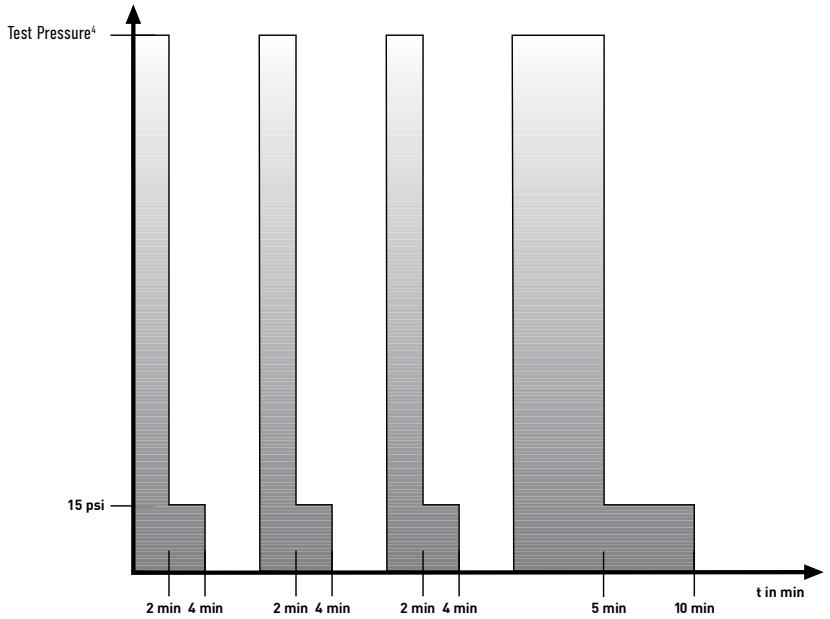
Cyclic Pressure test:

- Release any existing pressure from the system.
- Bring the system up to test pressure for two minutes.
- Reduce the system pressure to 15 psi for two minutes.
- Release the pressure from the system.
- Bring the system up to test pressure for two minutes.
- Reduce the system pressure to 15 psi for two minutes.
- Release the pressure from the system.
- Bring the system up to test pressure for two minutes.
- Reduce the system pressure to 15 psi for two minutes.
- Release the pressure from the system.
- Bring the system up to test pressure for five minutes.

(continued on next page)

Cyclic Pressure test (continued from previous page):

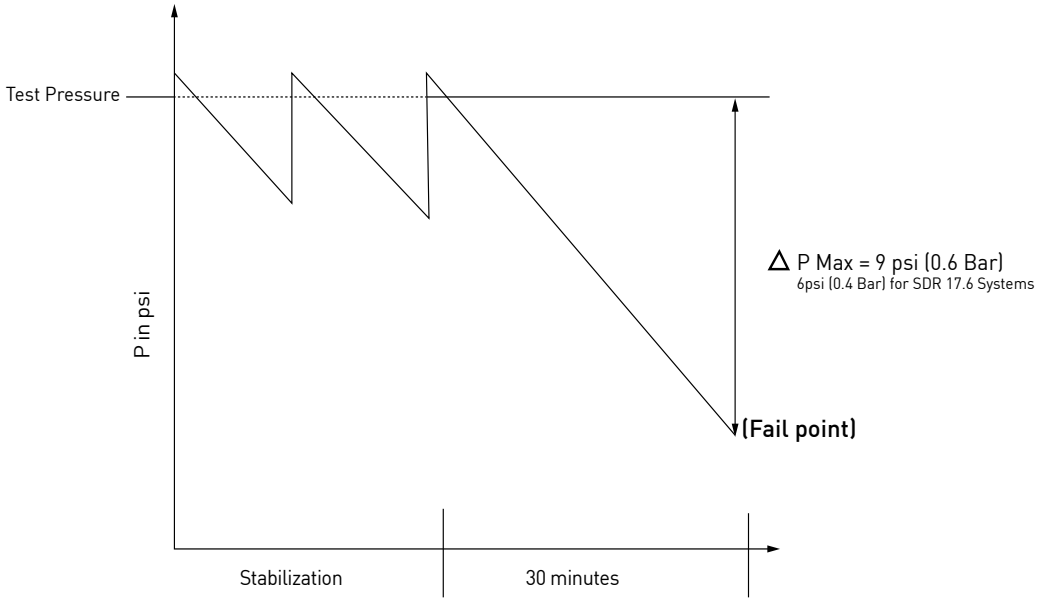
- Reduce the system pressure to 15 psi for five minutes.
- Release the pressure from the system.
- This test is intended to expand and stress the system and joints, so additional pump pressure may be necessary to maintain the test pressure initially. Any significant loss of pressure or inability to maintain the test pressure should be investigated for leaks, damage, entrapped air or equipment malfunction.


Test Pressure[4]
15 psi
2 min
4 min
2 min
4 min
2 min
4 min
5 min
10 min
t in min

30-Minute test:

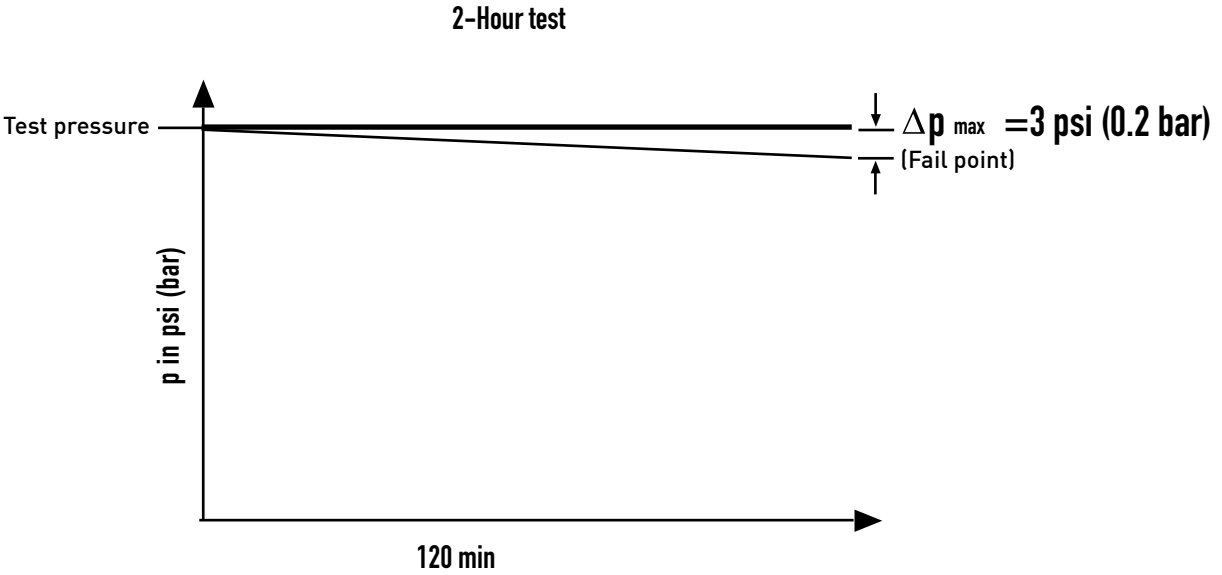
- Bring the system up to the test pressure. The system will expand slightly once it is up to pressure, so additional pressure may be required to help it stabilize.
- Once the system stabilizes, observe it for 30 minutes. The system should be able to hold the pressure during that time.
- The loss of more than 9 psi (6 psi for SDR 17.6 systems) or steadily decreasing pressure during this test is indicative of a leak. If a leak occurs, identify the leak and repair the system then repeat this test.
- If the system does not stabilize properly, but no leak is found, then there is likely entrapped air in the piping. Inspect the system for high points or other locations where filling may have entrapped air and ensure all air is removed from the piping system.[3]
- A successful version of this test must be completed before proceeding.

Pressure testing



2-Hour test:

- If the system has lost any pressure during the 30-Minute test, bring the system back up to the test pressure.
- Observe the system for 120 minutes. The system should be able to hold the full test pressure during that time.
- The loss of more than 3 psi or steadily decreasing pressure during this test is indicative of a leak. Identify the leak and repair the system before repeating this test. The test pressure must have less than 3 psi loss and have stabilized at a value of less than 3 psi loss during the test.


2-Hour test
Test pressure
Δp max =3 psi (0.2 bar)
(Fail point)
p in psi (bar)
120 min

Step 5: Complete the pressure test record and give to building owner

- Submit the forms to the building owner promptly after completing the pressure test.
- If you are testing a system in sections, save all the pressure test records and submit them together.
- Include the installer numbers of all the installers who fused connections on the system.

1. Revised 13 March 2018
2. Revised 14 Nov. 2018
3. Revised 20 May 2019
4. Revised 25 July 2019
5. Revised 19 August 2019
6. Revised 24 March 2022
7. Revised 1 September 2024 - compressed air revisions

Notes

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This manual is designed to accompany Aquatherm training and should be used in conjunction with the Aquatherm North America Design & Planning and Parts Guides. This document is not a substitute for taking an Aquatherm Training course.

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