

OPERATION MANUAL

Aldyl-A Tapping Tee

Refurbish Tool Kit



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GEORG FISCHER PIPING SYSTEMS
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Thank you for selecting Georg Fischer Central Plastics' products. GFCP strives to deliver the best technology and materials combined with rugged, durable construction to provide a productive and reliable connection for your polyethylene system.

To ensure this product lives up to all expectations, it is important to receive proper training from an authorized instructor and to read and comply with this instruction manual.

This manual is intended to provide a general introduction to the tools and steps required for proper use of the product. GFCP assumes no liability in connection with the data contained herein, nor assumes liability for the operation, safety, or use of third party tools and equipment in conjunction with this system. All data is accepted at the user's risk.

GFCP strongly recommends that its products and fittings be installed only by persons that have received training from an authorized instructor, that have a strong working knowledge of polyethylene and heat fusion, and that have demonstrated their understanding of these requirements by making fusion joints that have been qualified by destructive testing. Persons responsible for the joining of polyethylene pipe for regulated gas applications must qualify according to the requirements of Title 49 Code of Federal Regulations, Part 192.285. Other regulations may also apply depending on the application, local codes, and/or jurisdictional oversight of state and local regulating agencies.

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Table of Contents

Safety Notes and Warning Symbols.....4

General Information5

Kit Contents.....6

Replacement Parts.....6




Operating Instructions7





Care and Maintenance10

Safety Notes and Warning Symbols


Safety notes are included in this manual where appropriate, however this manual does not purport to address all of the safety concerns associated with its use. It is the responsibility of the user of this manual to establish appropriate safety and health practices and to determine the applicability of regulatory limitations prior to use.

Symbols are used throughout this manual to indicate the potential for danger, injury, and/or material damage, and to alert the user of important information related to the fusion process. Symbols indicate that particular attention should be given and that an action is necessary.

Symbol	Meaning
	Attention! – Important Information! Possible danger, damage, or risk of injury.
	Best Practice – This symbol is used to indicate an instruction that is considered to be a “best practice”. This practice is highly recommended and potentially vital to success.
	Prohibited! – This symbol is used to indicate a practice, material, tool, or action that is specifically prohibited in conjunction with instructions in this manual.

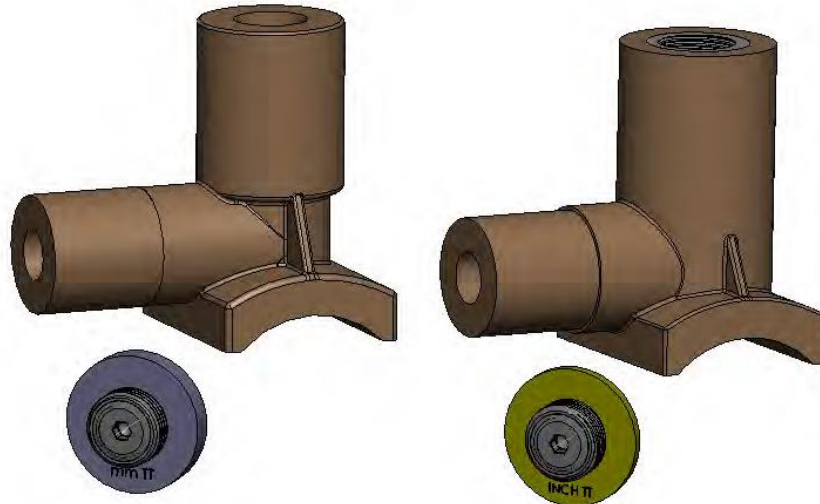
-  Electrofusion fittings and fusion equipment are not to be considered as “explosion proof”.
-  Caution should be exercised when working with generators and other electrical power sources.
-  Tools may have sharp edges. Use with care to avoid injury.
-  Tools should be in good working order and inspected before use for wear and/or damage. Damaged or worn tools should not be used until repaired or replaced.

These instructions pertain solely to the operation of the subject product. These instructions must be followed carefully. Observe all safety precautions prescribed by your company, the pipeline owner, and those prescribed by equipment manufacturers whose equipment may be used in conjunction with the subject product(s).

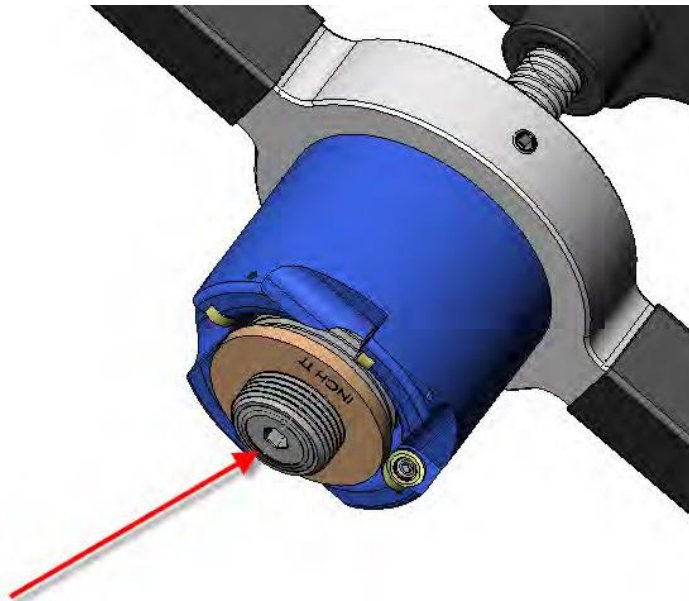
-  Failure to observe these procedures may cause personal injury and/or property damage. Each Operator must be properly trained in the use of this product or equipment prior to conducting and performing the following steps in a live natural gas application.

General Information

Preparing your tool for use.



There are two different styles of the Aldyl-A Tapping Tees. The metric style has a smaller chimney and an undercut above the base. The second is the older inch-style fitting. Each fitting requires a different threaded adapter which is identifiable by the color. The thicker silver washer designates the mm-style fitting. The adapters are removed with a 3/16" Allen Wrench as shown in the picture below. You must identify which style of fitting you will be repairing and install the correct adapter accordingly.



Kit Contents

Item Description
Refurbish Tool Kit

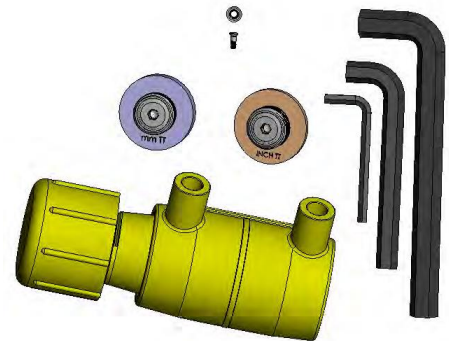
Item#
360001735



Replacement Parts

Item Description
Refurbish Tool Scraper
Repair Kit (fittings only)
Vise Grip Clamp
Cutting Insert Kit
Inch Adapter with Washer
Metric Adapter with Washer

Item#
360004698
360004429
360005941
360065356
360010471
360010472



Operating Instructions

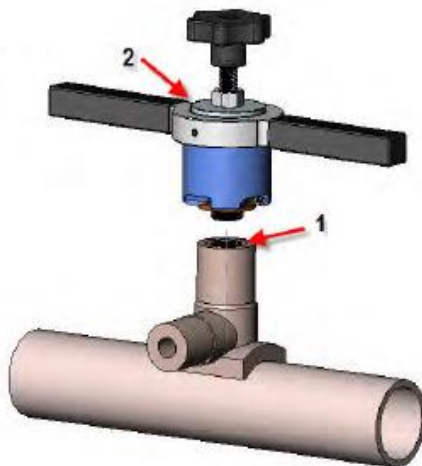
Preparing the fitting.

Clean the fusion area of the fitting chimney with a lint-free cloth and isopropyl alcohol to remove any contaminants that may be spread during the scraping operation.

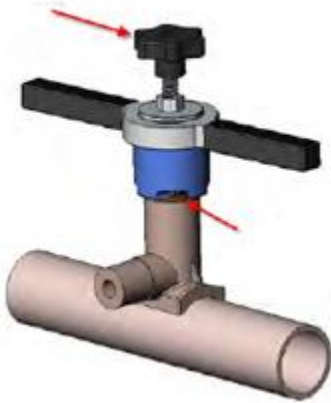


Next, remove the cap from the Tapping Tee and identify if the top of the punch is approximately $\frac{3}{8}$ below the surface. This area is needed so the threaded adapter has enough thread engagement to properly seat against the top of the tapping tee. If it is not, use the supplied Allen wrench and lower the punch. This will also guarantee a square and consistent scrape. Start by making sure the scraping tool is bottomed out against the top washer.

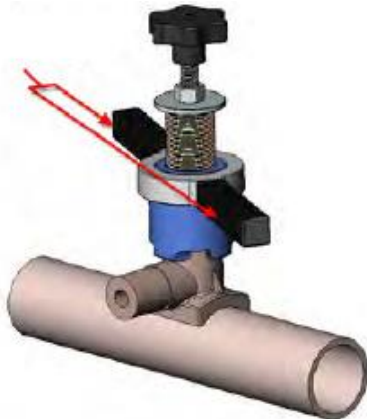
1. Remove cap from the tee
2. Position cutter against the top stop.



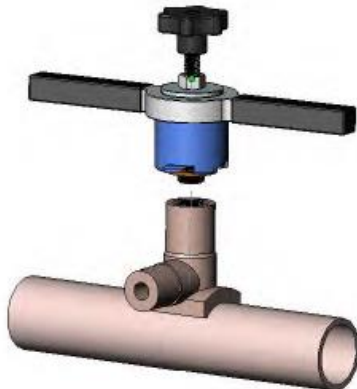
3. Once you have done this, the scraper should be screwed into the top of the tapping tee using the top plastic star knob. Tighten until the base washer is against the chimney of the tapping tee.



4. Once the tool is tight against the top of the Tapping Tee, begin scraping the fitting. This is done by turning the handles in a clockwise direction. Be sure to apply even pressure to both handles. No downward pressure is needed because the scraper has a self-feeding lead screw. Continue to rotate until you reach the bottom stop.




5. Once you have reached the bottom stop, begin to rotate the scraper counterclockwise for removal. Continue rotating until the scraper completely disengages from the tapping tee.



Installing the repair fitting.

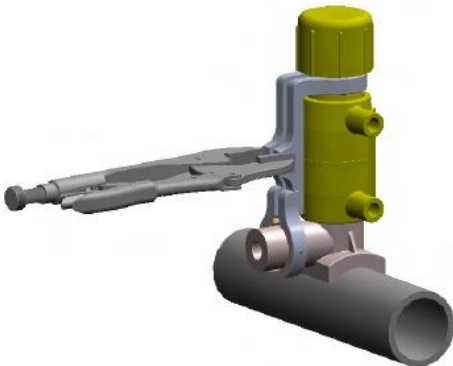
Ensure there is no gas pressure build-up in the fusion zone of the fitting during the fusion or cooling process. Methods for accomplishing this include threading the punch down into the tap hole, using squeeze off tools, or venting.

 **Warning!** This procedure does not address safety considerations. Follow your company's safety policies regarding working in a potentially combustible environment.

1. Remove the electrofusion fitting from the bag and install the EF Fitting as shown below. Push the 40 mm end of the coupling down over the fitting chimney until the end of the coupling is in contact with the fitting outlet.



2. Once the components are assembled and placed on the scrapped tee, they will need to be secured with the supplied vise grip clamp as shown below.



3. Once this is done and the part is secure, attach the processor leads to the EF Coupling and fuse with normal procedures. Allow the fusion to cool completely before exposing to back-gill or pressure testing. If service is to be restored, return the tee punch to the original position. Replace plug snugly with Allen wrench and tighten the purge point cap by hand until it bottoms out.

Care and Maintenance

Care should be taken to guarantee the performance of the scraping tool. The cutting inserts in the tool are made of carbide which is a very hard material and will provide an excellent service life. Care must be taken to protect them from impacts that will fracture the cutting edge. The supplied cap must be used when tool is not in service. If the carbide inserts are damaged, they will not cut as designed. If they are chipped, it is possible to rotate them by loosening the screw. If broken, replacement inserts are available.