

Rovanco® Piping Systems

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INS-RPE

Rhinoflex PEX Electrofusion Installation Instructions

Revised 09/23/22

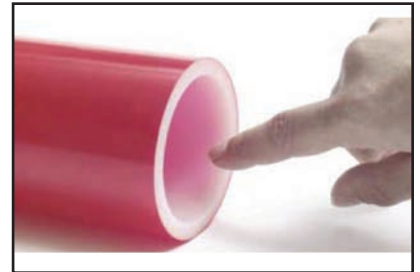


1. Electrofusion Tool and Components for making electrofusion joint.

(not supplied by Rovanco)



2. Trim pipe to desired length. The cut face must be straight with respect to the pipe axis and must be smooth.



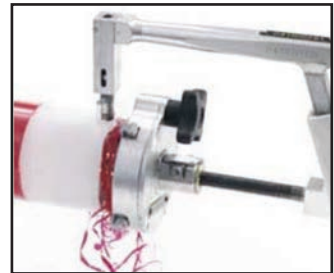
3. Examine the surface of pipe ends and fittings for any damage.



4. Mark scraping area after measuring insert depth of fitting.



5. A rotary scraper must be used to scrape pipe ends. This tool is to be used to take EVOH layer off.



6. Scrape EVOH layer off pipe to virgin PEX.



7. All residual color can be removed with a manual scraper.



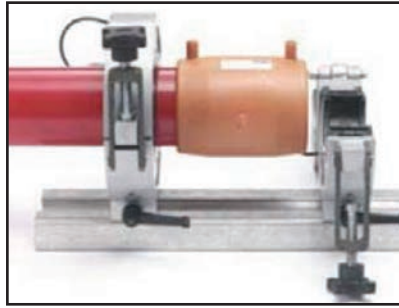
8. The scraping area must be free of dirt and oil. Clean the area with an adequate amount of denatured alcohol and allow the cleaning agent to completely evaporate.



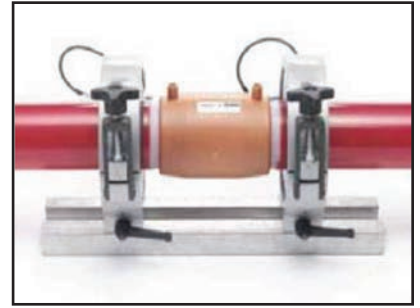
9. Remove PEX fitting and clean interior with denatured alcohol.



10. Push fitting completely onto the first pipe end.



11. Place universal pipe straightening clamps as close as possible to fitting.



12. Prepare second pipe end, then slide it completely into the electrofusion fitting and secure it with pipe clamps.



13. Connect electrofusion welding unit, using the red nipple to the red contact. Welding and cooling parameters are automatically detected. If not then scan bar code. If parameters still do not show then physically type in code.



14. Let machine properly weld and cool.



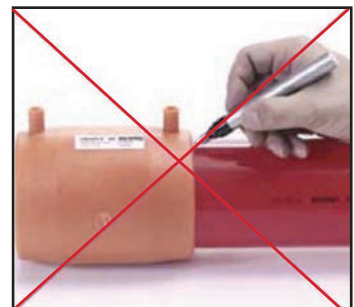
15. After cool down is completed, nipples and universal pipe clamp can be removed.



16. Rhinoflex Pex Electrofusion fitting is now complete.



17. Using a marker pen, note your personal information and date accomplished.



18. Do NOT use Pex electrofusion fitting as a marking aid.



19. Do NOT touch the welding areas. If necessary, re-clean dirty welding areas.



20. Welding area must be dry and dirt free.



21. Do NOT employ used cloth for cleaning. Employ only waterproof, new, non-dyed or fibrous and absorbent cellulose fiber cloth.



22. Do NOT weld pipes which have not been fully inserted.



23. The joint must be flush and no tension must be applied to it. If necessary remove and remount.



24. DO NOT tamp with a hammer. Use only appropriate seating methods.



25. Never weld pipe without pre-installed universal mounting clamps.



26. During welding, the welding units connecting cable must not exert any force on the fitting.