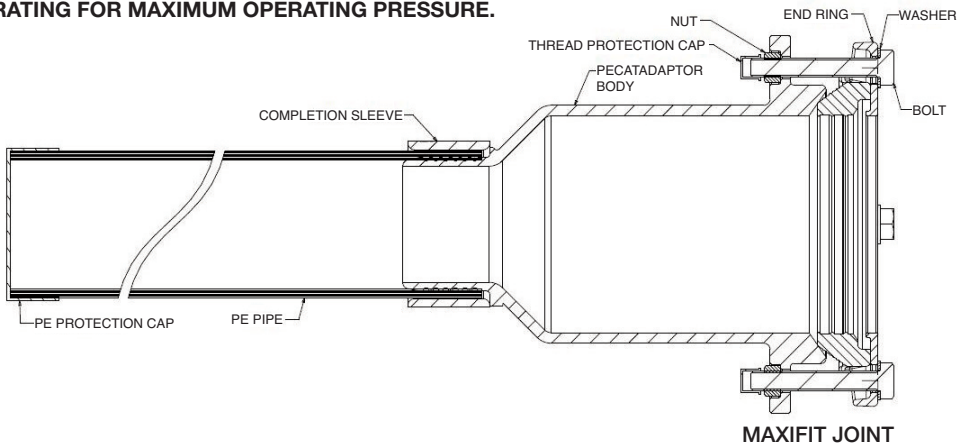


PECATADAPTOR INSTALLATION INSTRUCTIONS

IMPORTANT: THE MAXIFIT JOINT DOES NOT PREVENT PIPE PULL OUT. ADEQUATE EXTERNAL RESTRAINT TO PIPE WORK IS ESSENTIAL. REFER TO PE PIPE SDR RATING FOR MAXIMUM OPERATING PRESSURE.



Preparation of MAXIFIT pipe end

1. Examine the ferrous pipe end and ensure it is round, smooth, free from dents and score marks and within the outside diameter range of the fitting. Weld beads must be ground flush, maintaining correct surface profile. Ensure that the pipe end is free of scale, rust or any loose debris or other surface defects that may affect the joint performance.
2. Place Pecatadaptor body fully over the pipe end and adjust the setting gap as shown in the table.
3. Tighten bolts diametrically opposite giving the nuts one or two turns at a time to draw up the end ring evenly. The bolts must be thoroughly tightened to the Torque figure stated, working around the end ring as many times as necessary. On completion, the radial gap between the pipe and body should be even all the way round. Rubber may be seen to extrude into the gap.

Preparation of polyethylene pipe end

Preparation of the polyethylene pipe (PE), prior to fusion welding, should be in accordance with the recommendations of the polyethylene pipe, fittings, fusion equipment manufacturers and the gas industry standards.

Setting Gap Table

Typical Pipe Diameter Range	Setting Gap (mm)
Size less than DN150	20
Size DN150 to DN300	25

Torque valves for M12 bolts 55-65Nm (40-50) lbf.ft.

PRESSURE TESTING: PRESSURE TEST IN ACCORDANCE WITH INDUSTRY STANDARDS USING APPROPRIATE RESTRAINTS TO PREVENT PIPE PULL OUT.



To visit our Video Library go to:
www.youtube.com/user/CraneBSU



46-48 WILBURY WAY, HITCHIN,
HERTFORDSHIRE, SG4 0UD

TELEPHONE: +44 (0)1462 443225
TELEPHONE: +44 (0)1462 443226
FAX: +44 (0)1462 443311
EMAIL: sales@wask-uk.com

www.wask-uk.com



FM311 ISO 9001



Visit www.flowoffluids.com to book your copy of the New Technical Paper 410.

- Designed & manufactured under quality management systems in accordance with BS EN ISO 9001:2008

Every effort has been made to ensure that the information contained in this publication is accurate at the time of publishing. Crane Ltd assumes no responsibility or liability for typographical errors or omissions or for any misinterpretation of the information within the publication & reserves the right to change without notice.

W_PECAT_0116
IOM_JR0026_v3