

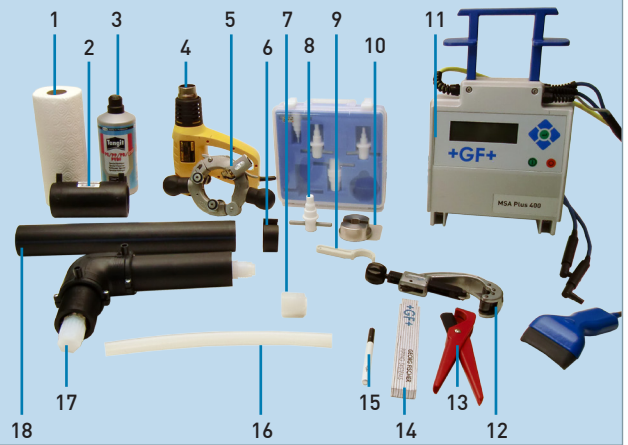
**Instruction manual**

**CONTAIN-IT PLUS  
PFA / PE100**

**PFA  
Flare connection**



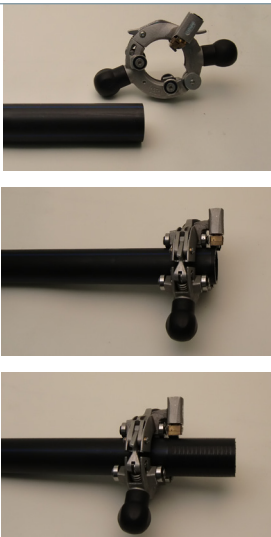
- 1 Cleaning cloth
- 2 Electro fusion coupler
- 3 KS Tangit Cleaner
- 4 Heat gun
- 5 Rotary peeler RS
- 6 Snap ring
- 7 PFA Fitting nut
- 8 Insert pin
- 9 Dedicated nut spanner
- 10 Insert pin jig
- 11 MSA Electrofusion Unit with Traceability (e.g. MAS Plus 400)
- 12 PPC Plastic pipe cutter
- 13 Plastic pipe cutter
- 14 Meter
- 15 Marking Pen
- 16 PFA tubing
- 17 CONTAIN-IT Plus Fitting
- 18 PE 100 Pipe



**1**  
Cut the tubing and the outer pipe on the needed length, in a right angle.



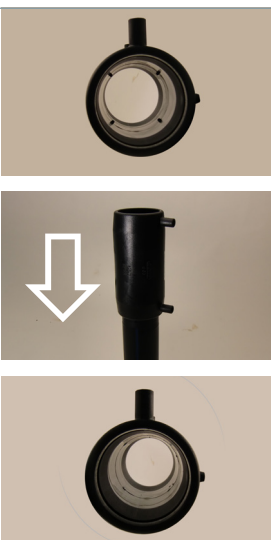
**2**  
Peel the welding zone of the outer pipe (rotary peeler).



**3**  
Clean the welding zone with the Tangit Plastic Cleaner for PE.



**4**  
Remove the bedstops in the electro fusion coupler.



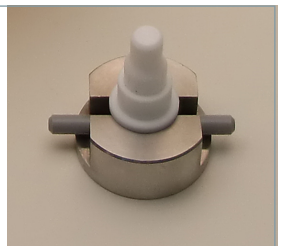
**5**  
Mark the position on the electro fusion coupler, on the fitting and the pipe end.



**6**  
Place the complete electro fusion coupler on the long end of the fitting on the pipe end.



**7**  
Position the insert pin (1/2"»size 13 a. 3/4"» size19) in the insert pin jig.



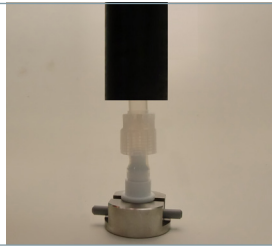
**8**  
Heat up the end of the tubing for 15 to 20 seconds with the heat gun at about 400°C (heated area must be as long as the insert pin base).



**NOTICE**  
Be careful not burn yourself » do not touch the heated area on tubing and heat gun!

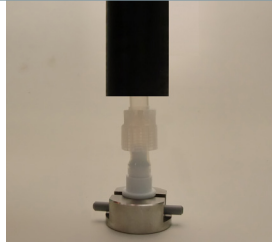
9

After heating up the end of the tubing, immediately slide it over the insert pin up to the base of the insert, thereby expanding the tubing into a flare shape.



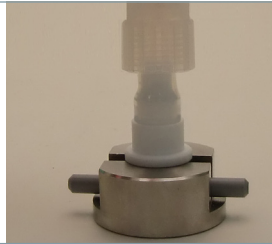
10

The tubing must be held for about one minute while it sets in a flared shape (cooling time can be reduced by blowing cooling air on the tube). After cooling for the required time, remove the tubing from the insert pin (cooling time can also be reduced immersing tubing and insert pin in deionized water or similar!).



11

Do visual check that the tubing has been expanded into a flared shape.



12

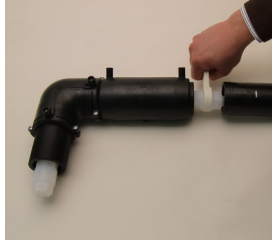
After flaring is complete, promptly attach the CONTAIN-IT Plus fitting to the expanded tubing.



13

Fasten the fitting nut to body and tighten to the end surface, using the dedicated nut spanner.

As a guide, tighten the nut by a further 1/8 turn in order, to make sure the nut is screwed far enough to make contact with the body end surface; further we refer to the follow tightening torques:



Body size	CONTAIN-IT Plus dim.	Torque (N x m)
4	1/2" / 50mm	5.0 to 5.3
5	3/4" / 63mm	10.0 to 10.5

14

Pressure test of the tubing line.



15

Place the snap ring in the gap between CONTAIN-IT Plus fitting and outer pipe.



16

Place the electro fusion coupler at the right position (marked in step 5).



17

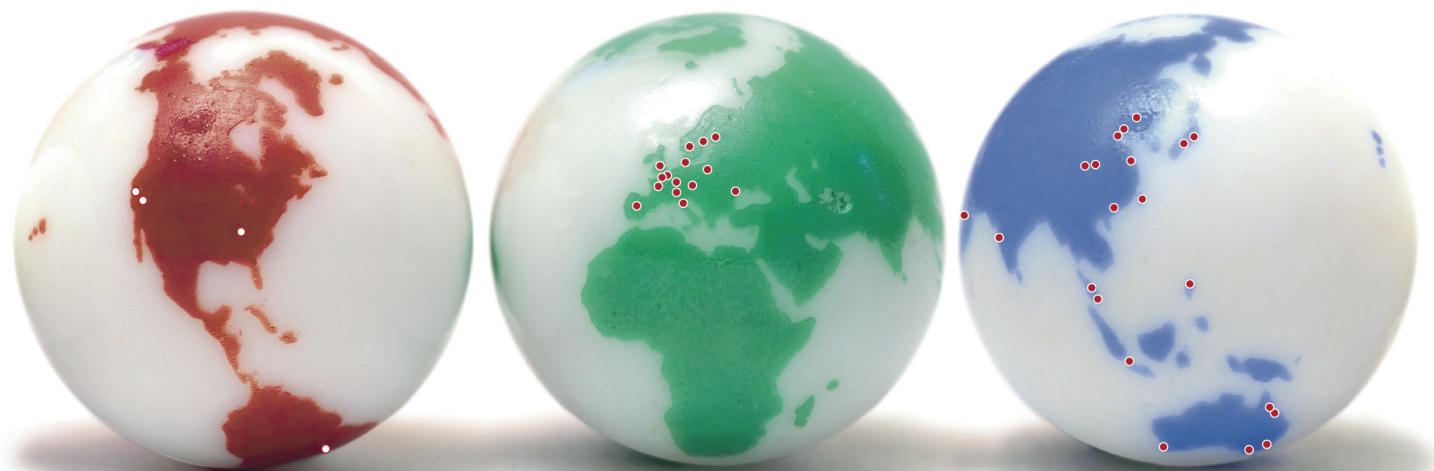
Do the electro fusion welding (MSA).



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