

## PE T-Casing joint

### Application:

PE T-Casing joint is used for branching on FlexPipes.

### Usage for:

main pipe dimensions Ø 90-180 mm

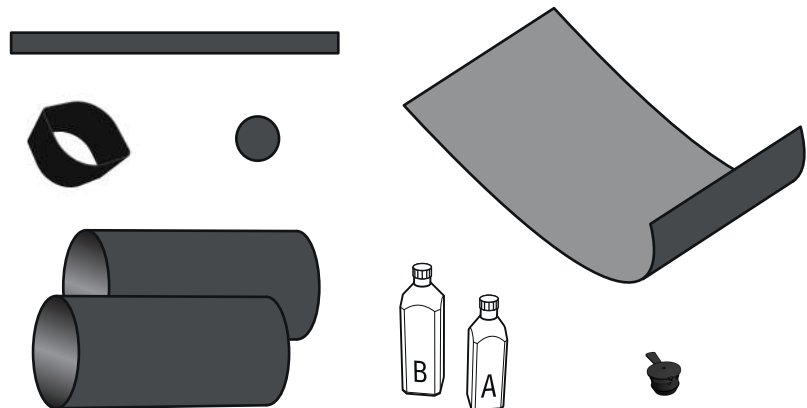
and

branch dimensions Ø 90-160 mm.



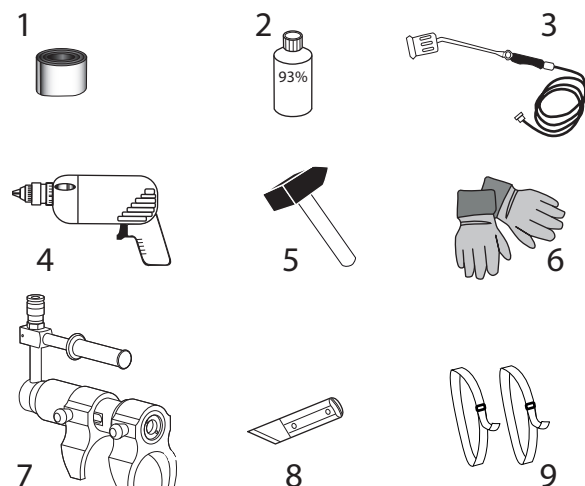
### Additional material:

1. Bitumen cover Sticker
2. Shrinking belt
3. Closure tape
4. vent plugs
5. foam packages



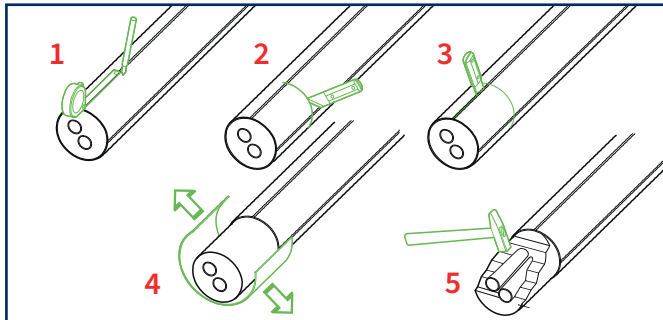
### Tools required:

1. Emery cloth, grain size 60
2. Alcohol, min 93%
3. Gas burner Ø 50 mm
4. Drilling machine
5. Hammer
6. Gloves
7. Pressing tool and T-piece connectors
8. Cutter
9. Straps



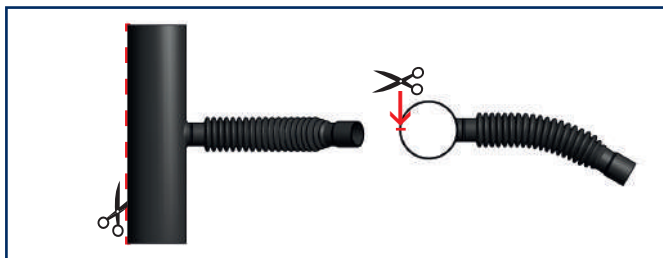
# Installation instructions

## Preparations

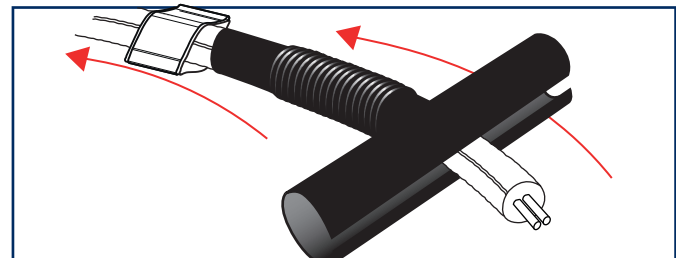


1. Cut off the insulation with a suitable stripping tool. The length depends on the type of coupling but in total stripped length is max. 900 mm.

Distance between the pipes = 700 mm	
PE T-Casing joint Ø-111-91 to 91	1000
PE T-Casing joint Ø-142-126 to 126-111	1000
PE T-Casing joint Ø-142-126 to 91	1000
PE T-Casing joint Ø-182-162 to 162-142	1000
PE T-Casing joint Ø-182-162 to 126-111	1000
PE T-Casing joint Ø-182-162 to 91	1000
Distance between the pipes = 900 mm	
PE T-Casing joint Ø-225-202 to 202-182	1200
PE T-Casing joint Ø-225-202 to 162-142	1200
PE T-Casing joint Ø-225-202 to 126-111	1200
PE T-Casing joint Ø-225-202 to 91	1200

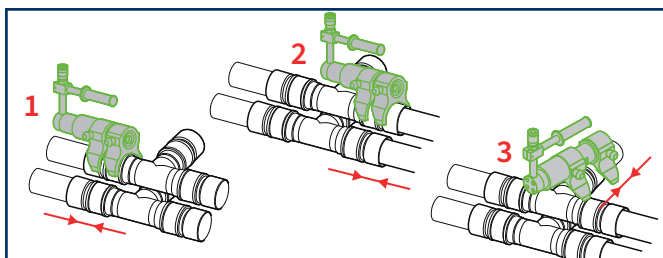


2. Cut open the T-piece on the opposite side of the outlet pipe.

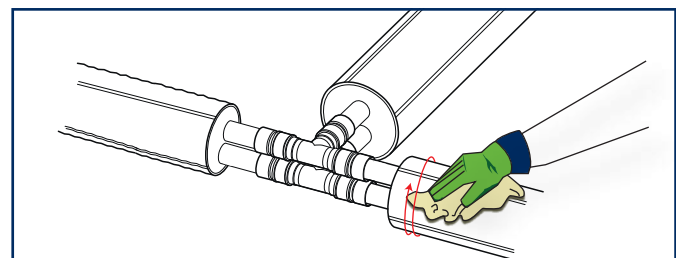


3. Preinstall collar and T-piece on the branch.

## Cleaning



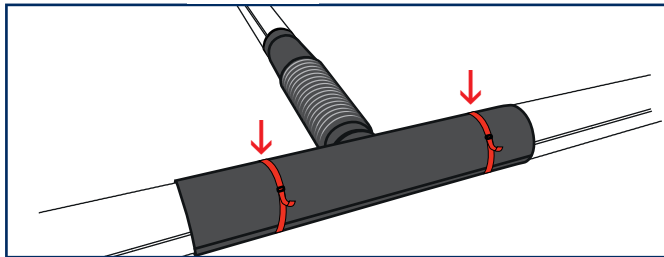
4. Now you can press the T-piece connectors together. Press first both connectors on one side and then on the other one. At least press the branch pipe to the connector.



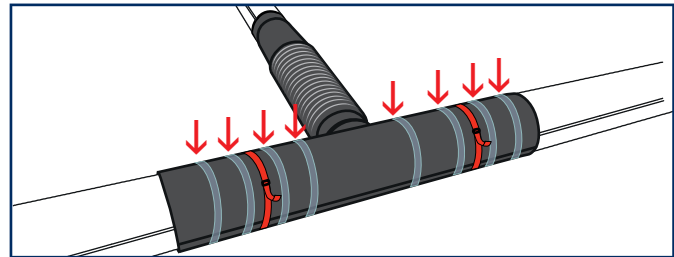
5. Clean all surfaces in the mounting area. Use alcohol on min. 250 mm of the outer casing ends.

# Installation instructions

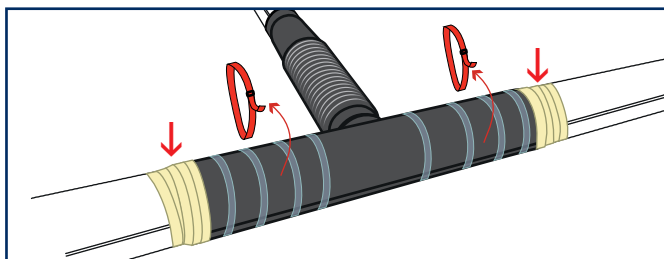
## Installing T-shoe



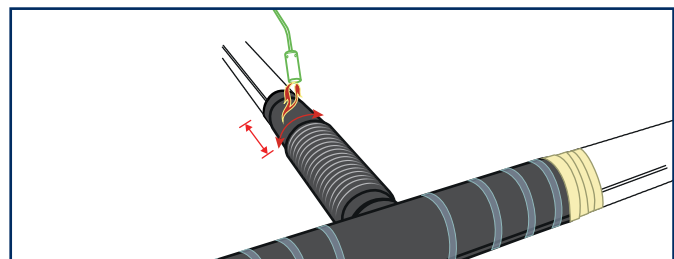
6. Pull the T-shoe over the main pipes. Fasten the T-shoe tightly around the pipe with min. 2 straps, one on each side of the branch.



7. Wrap around tear-resistant and heat-resistant (glass fibre) adhesive tape (at least 4 times per each side).

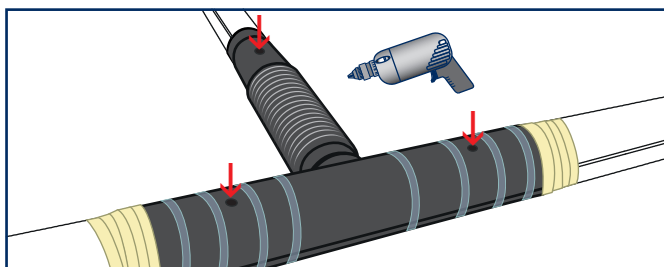


7. Now remove the straps and apply paper tape on the open ends of the t-shoe to prevent the foam from flowing out.

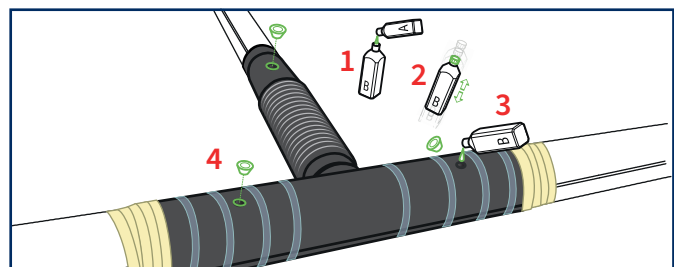


8. Shrink the outmost 200 mm of the branch pipe.

## Foaming



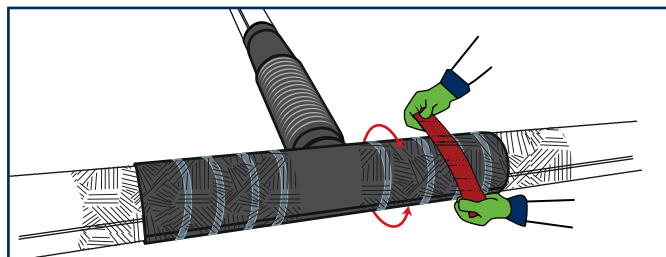
9. Drill 3 Holes on each side of the pipes (Ø24 mm).



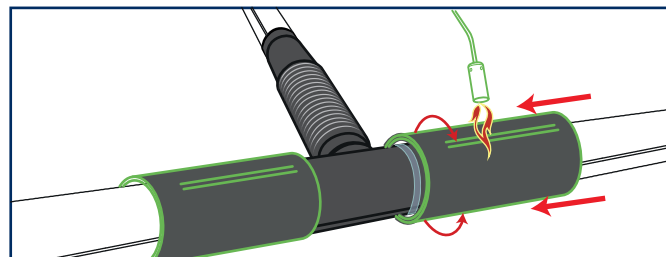
10. Foam the T-piece and insert a venting plug in the hole. Wait at least 30 min. for degassing. Cut of the lashes of the Venting plug and remove excess foam if necessary.

# Installation instructions

## Activating main pipe

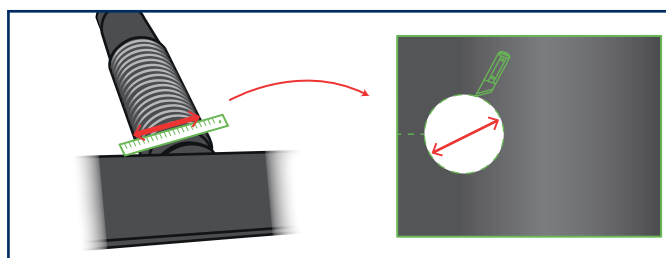


11. Grind the contact surfaces of the T-piece so grinding marks are visible outside the rim (This enables visual control of the activation by the inspection). Remove loose grind dust.

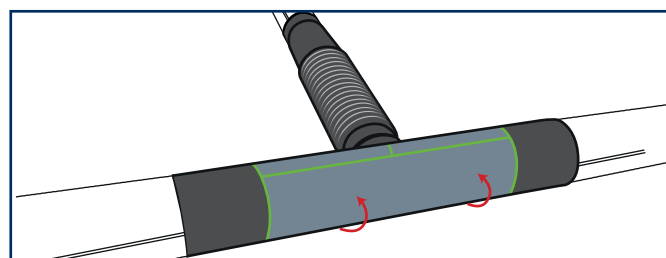


12. Pull the two shrinking hoses (450 mm) over the lap and the vent plugs and start to shrink them down.

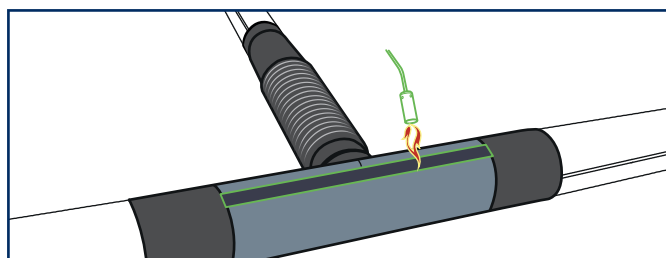
## Installing shrink wrap



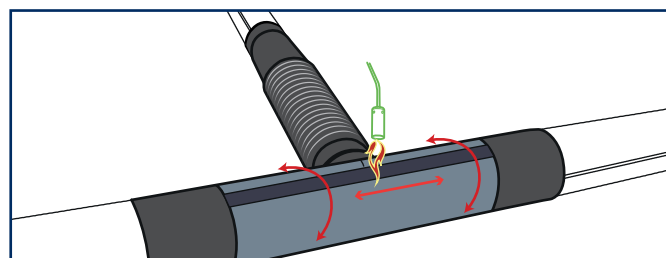
13. Cut out a hole (dimension = outer Diameter of the branch pipe)



14. Place the shrink matt around the main pipe. Turn the wrap so that the end goes around the pipe and closes at the top. The wrap must fit loosely around the pipe with an overlap of min. 50 mm.



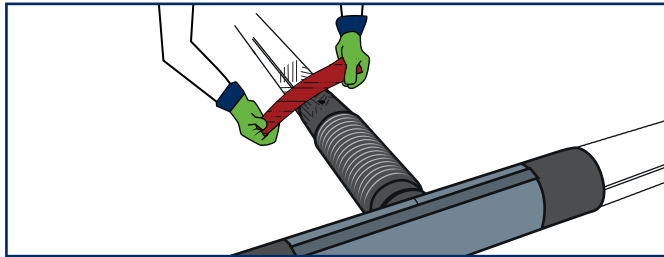
15. Centre the closure patch on the wrap joint with the adhesive side facing down. Heat the closure patch with a strong flame until the structure of reinforcement becomes visible on the topside. Press down the closure patch.



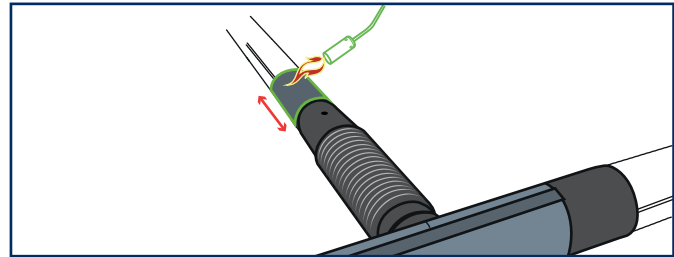
16. Shrink the wrap from the centre toward the ends, ensuring that the sealing compound spreads to both ends and that the full shrinking effect has been utilised.

# Installation instructions

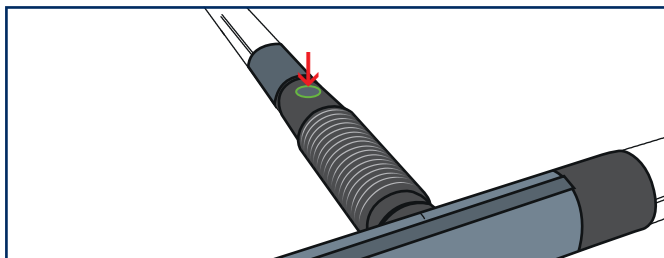
## Finishing the branch



17. Activate the branch pipe and outer casing with emery cloth at least 150 mm on to the casing and the joint. Grind the contact surfaces of the collar on the branch pipe and the outer casing with emery cloth, so grind marks are visible outside the collar. Remove any loose grind dust.



18. Remove packing and paper from the collar. Check that all paper is removed. Make sure that the middle of the collar is over the end of the shoe when you start shrinking.



19. While cooling down, sandpaper the vent plug on the branch pipe, warm it up with a gently flame and stick the bitumen cover sticker on it.

