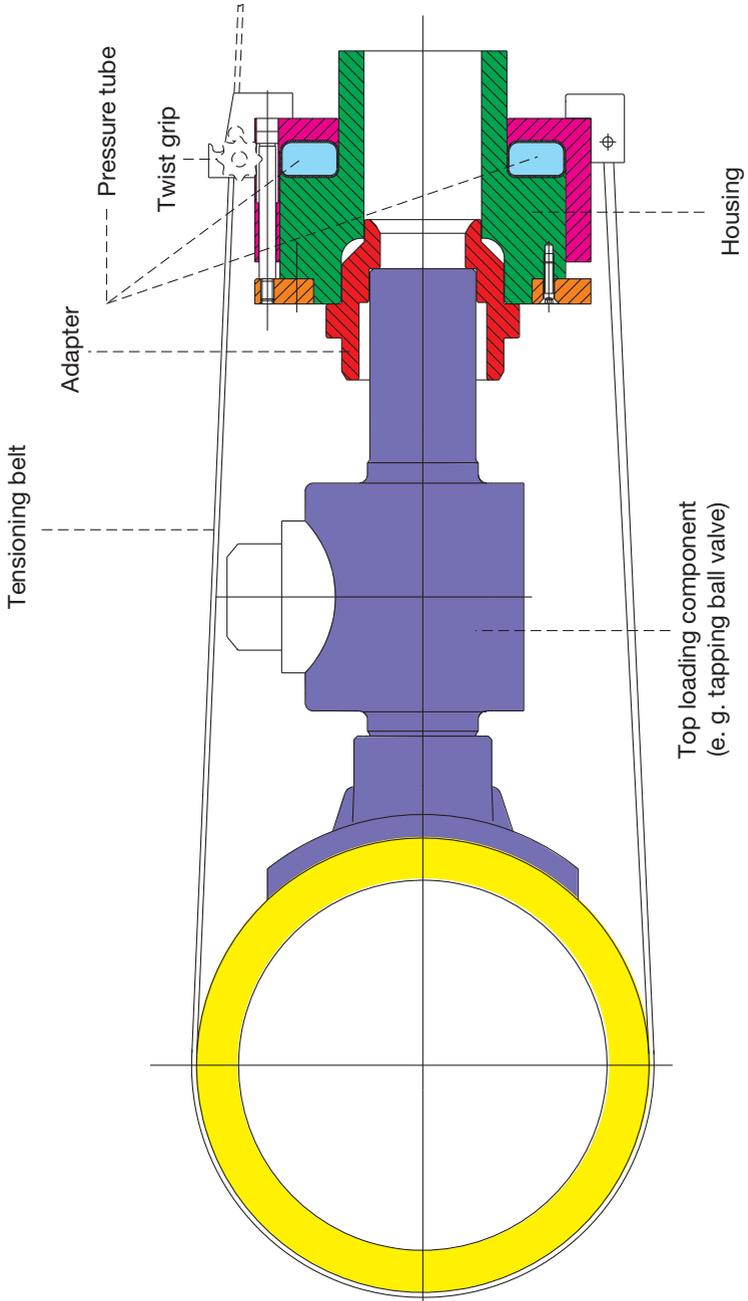


FRIALEN® Assembly and Operating Instructions

for FRIATOP clamping unit (Top-Loading)



The FRIATOP clamping unit



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1. Areas of application

The FRIATOP clamping unit developed for FRIALEN® saddle fittings is pneumatically operated and is suitable for use when fusing on saddle fittings of the special TL type (see illustration on page 2).

All the saddles identified as “TL” types in the latest FRIALEN®-price list (e.g. DAA-TL / SA-TL / AKHP-TL / VAM-TL / SPA-TL / VSC-TL) for pipes above 250 mm diameter can be used. Please get the possible applications and dimensions from our price list.



WARNING!

When processing the FRIAFIT® sewage saddle ASA-TL with pipe d 560, the clamping pressure at the manometer of the air pump may not exceed approx. 2bar.

The clamping unit is also suitable for fitting house connection fittings and branch connectors on HD-PE relining pipes (U-liners / C-Liner / Swage lining / Roll down) in conjunction with special FRIALEN® relining saddles from DN 100 upwards (on enquiry).

2. Description of the FRIATOP clamping unit

It consists of four parts:

- Pneumatic clamping unit
- Component adapters (2)
- Air pump

3. Assembling the FRIATOP clamping unit

3.1

The adapter is fitted into the clamping unit before this is tensioned and forms the connection with the FRIALEN® component. It has various steps depending on the type of saddle fitting being fused on. If a FRIALEN®-SPA-TL is being fused on, the screw cap of the fitting is located directly into the unit without the adapter.

The same applies to the VSC-TL.

3.2

Preparation of the area



WARNING!

The proper, uninterrupted and uniform scraping of the pipe surface is absolute necessary to prepare for electrofusion welding. Any deviations may result in the joint becoming untight. Please observe the FRIALEN® installation instructions for fittings and further manufacturer-specific instructions, if any.

3.3

Place the saddle component onto the pipe.



WARNING!

Only trained personnel may operate the FRIATOP clamping unit. The operator has responsibility towards third parties within the working area. The operator must make available the operating instructions to the user and must ensure that the user has read and understood the instructions.

3.4

Fit the adapter and the clamping unit onto the saddle component. The different steps in the adapter fit the various types of saddle component. Lay the tensioning belt around the pipe (**do not twist !**).

3.5

Thread the loose end of the tensioning belt into the rollers on the twist grip. Pull the belt taut by turning the twist grip clockwise.

3.6

Check that the clamping unit is in the untensioned state (no air pressure at the valve) and then connect the air pump to the valve.

In the unpressurised state the ten-sioning figures $\frac{2}{1}$ are visible in the window of the rim of the housing.

3.7

If necessary make a final correction to the seating of the saddle on the pipe.

3.8

Pump up the clamping unit (the pressure gauge on the pump should indicate between 3 and 4 bar). The expansion of the cylinder will press the saddle onto the pipe. The gap between the pipe and the saddle must be completely closed by the pressure applied.



WARNING!

A visual check must be made by the user!

3.9

In the pressurised state the tension number is read off in the window next to the handle and marked for safety on the piece of pipe. This will give a check on any fall off in pressure during fusion. If this drop in pressure is no greater than one scale graduation then the fusion has been carried out in accordance with the standard. If the pressure drop is greater than this the fusion process must be broken off and the reason investigated. Afterwards, and when the proper cooling time has elapsed, a second fusion can be carried out.

4. FRIALEN® fusion

Connect the fusion cable from the fusion unit to the contacts on the saddle and start the fusion process.

During the fusion process the tension number should be checked.



WARNING!

For the sake of general safety always stay at a distance of one meter from the point of fusion during the fusion process.

5. Removing the FRIATOP clamping unit

After the fusion has finished always maintain the joint pressure in accordance with 3.8 for a 10 minute cooling period. After this the pressure can be taken off by venting the unit to air and the unit dismantled.

6. Before drilling through please allow to cool down for the times listed below

Cooling times

d 250 - d 560 mm = 60 min

for special relining saddles TL/RE

> d 98 - d 130 mm = 30 min

> d 130 - d 160 mm = 45 min

> d 160 - d 220 mm = 60 min

> d 245 - d 560 mm = 60 min



WARNING!

If the cooling down time is not adhered to the saddle can come away from the pipe in the area of the fused joint. A permanently safe fused joint cannot be guaranteed.

7. Warranty

The warranty is 6 months. It will not apply if there are signs of force being used or of usage which is not in accordance with the operating instructions.

8. Functional safety

The FRIATOP clamping unit has been checked for safe operation before being shipped. The equipment requires very little maintenance. We recommend a half yearly check on all functional parts. The unit should be protected from dirt.

If you have any queries on this information the following will be glad to advise you

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9. UPDATES for Assembly Instructions

These technical statements are checked regularly in terms of up-to-dateness. The date of the recent revision is specified on the document. Visit www.friatools.com, in the left navigation menu you will find the submenu "Downloads". Here you will be able to read and even print out up-to-date operating instructions (pdf file). We also would be pleased to send them to you.

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