



TOOLS AND EQUIPMENT



- Pipe cutter
- Soft, lint-free cloths
- Chamfering tools
- Socket depth gauge
- Felt pen
- Gloves
- Personal Protection Equipement



CHOOSE YOUR WELDING POLYMER



HTA and HTA-F
KRYOCLIM
GIRAIR
U-PVC K62

Cleaner+	x	x	x	x
HTA FUSION	x			
CSTB certified adhesive*				x
HPFIX		x		
GAFIX			x	

* Cold water

SERVICES

Telephone hotline, training sessions,
production of drawings and bills of materials,
a BIM library, induction training on site:
an entire team is there to help.



Telephone hotline

To answer your questions:

+33 (2)41.63.73.25



On-site technical assistance

A team at your side to support
you in getting your job started.



Training centre

Helping contractors and
specifiers to understand GIRPI
system installation techniques.



Custom-made fabricated items

A workshop at your disposal
to produce special parts.



safety for your pipeworks

an **OAliaxis** company

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INSTALLATION ACCESSORIES

A STEP BY STEP GUIDE TO GOOD COLD WELDING



safety for your pipeworks

PREPARING THE JOB

CHECKLIST:



HAVE ALL THE ITEMS YOU NEED IN YOUR POSSESSION:

- Pipes and fittings
- Welding polymers, cleaner
- Tools
- PPE Personal Protection Equipment



CHECK YOUR EQUIPMENT BEFORE STARTING:

- Do I have the right welding polymer?
- Is it still in good condition?
- Do I have cleaner and clean rags?
- Check the use-by dates



CHECK AMBIENT WORKING CONDITIONS:

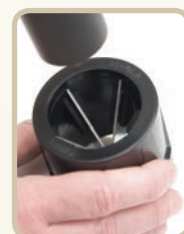
- Installation temperature between:
 - -5°C and +40°C for the HTA® Fusion welding polymer
 - +5°C and +35°C for other welding polymer
- Avoid strong sunlight, rain, wind
- Work in a clean, well-ventilated location

Step 1

PREPARE



Make a clean, square cut using an adapted pipe cutter.



Chamfer using an adapted chamfering tool.

TIPS

Chamfering facilitates joining and allows for an even distribution of the welding polymer between the pipe and fitting to be joined.

CHAMFER SIZE

PIPE Ø	CHAMFER LENGTH
Ø 16	1 - 2 mm
Ø 20 - Ø 50	2 - 3 mm
Ø 63 - Ø 225	3 - 6 mm

3

Deburr / trim the inside of the pipe.



4

Check: the pipes and fittings must be clean and dry, with no scratches or impact marks.



Measure and mark the socket depth of the fitting using the gauge.



TIPS

Remember to mark the orientation of the fittings.



PROHIBITED

The following actions may jeopardise the quality of the welds.

- Do not store the pipes in unprotected or exposed areas, e.g. directly on the ground, exposed to rain, sunlight, etc.
- Do not apply the welding polymer with an unsuitable tool (piece of wood, rag, finger, glove, etc.).
- Do not cut the pipes using metal saws, disk saws, etc.
- Do not dilute the welding polymers with water or solvents.
- Do not chamfer using grinders, sanders, angle grinders, etc.
- Do not apply sustained forces (twisting, pulling) during the first minutes following assembly. Do not adjust a fitting's orientation after assembly.
- Do not connect fittings to pipes that have not been chamfered and deburred / trimmed.
- Do not allow the welding polymer to dry between application and joining.
- Do not assemble fittings or pipes that are wet, dirty or dusty.

Step 2

JOIN



Clean the parts to be welded, first female then male, using CLEANER+. Use a clean, lint-free piece of cloth. Leave to dry or wipe dry using a soft, lint-free piece of cloth.

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Shake the pot for 5 seconds

to mix the polymer when doing the first welds of the day. The more the polymer is shaken, the more fluid it will be. If you find that it is too fluid, leave it to settle for a few minutes.



8

Apply the welding polymer

in a thin, uniform coat. To obtain better adherence, carry out 4 to 8 rotations (depending on the diameter) on the Female parts first, and then the Male parts.



TIPS

To avoid droplets, remove any surplus polymer by scraping the applicator on the neck of the pot.

250 ML POT > For Ø16 to Ø50

1 L POT > For Ø40 to Ø160

Applicators optimised for the size of the pipes are provided with the pots. Larger sized applicators are also available for diameters above 110 mm, on ref PAB1L



TIPS

- Work in a team of 2 for Ø ≥ 90.

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Immediately push together

the Male and Female parts up to the mark, push straight without twisting, and hold for 5 seconds.



TIPS

Leaving the welding polymer bead as it helps check that the weld is done.

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Clean off drips using a clean, lint-free piece of cloth.

Remember to close the pot after each use.

After joining, make sure that the recommended drying times are respected before loading the network with pressurised water, whether for new installations or for renovations. For further information, refer to the label on the pot of welding polymer.