

## CONNECTIONS

Endot PE-2406 gas service pipe and tubing is connected by heat fusion (Butt or Socket), or by mechanical type compression fittings. Consult the fitting and /or fusion equipment manufacturer for instructions.

### HEATING CYCLES FOR HEAT FUSION OF ENDOT PE-2406 GAS PIPE AND TUBING

#### BUTT FUSION TIME CYCLES

Pipe Size	Heat Time (Seconds)	Cooling Time (Seconds)	Bead Thickness (Inches)
1/2" CTS	6 – 7	60	1/16
1" CTS	8 – 10	60	1/16
1/2" IPS	6 – 7	60	1/16
3/4" IPS	7 – 9	60	1/16
1" IPS	10 – 12	60	1/16
1 1/4" IPS	12 – 14	60	1/16
1 1/2" IPS	14 – 18	60	1/16
2" IPS	14 – 18	60	1/16

Do Not remove joint from tool for an additional 3 minutes

Do not stress joint for at least 10 minutes after removal from tool.

#### SOCKET FUSION TIME CYCLES

Pipe Size	Heat Time (Seconds)	Holding Time (Seconds)
1/2" CTS	6 – 7	20
1" CTS	8 – 10	20
1/2" IPS	6 – 7	20
3/4" IPS	8 – 10	20
1" IPS	10 – 12	30
1 1/4" IPS	12 – 14	30
1 1/2" IPS	13 – 15	30
2" IPS	16 – 19	30

Do Not remove cold ring for an additional 3 minutes

Do not stress joint for at least 10 minutes after cold ring has been removed.