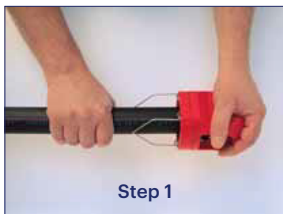


## Features and Benefits

<i>Efficient</i>	forms a fast, end load resistant, watertight joint, with no bore restriction.
<i>Compatible</i>	with GREENLINE, REDLINE™, RURAL BLACK, BLACKLINE PN16 and ALKATHENE™ 20mm and 25mm diameters.
<i>Versatile</i>	range allows joints to be formed with other pipe materials by way of male and female couplings with BSP threads or PLASSON Universal Coupler (code 2512).
<i>Durable</i>	manufactured from a high impact resistant polypropylene material.
<i>Economical</i>	rapid assembly, push-fit and tighten. PLASSON fittings from 20mm to 63mm diameter do not require to be disassembled before making a connection.
<i>Quality</i>	manufactured and tested to AS/NZS 1460 "Fittings for polyethylene (PE) pipe for pressure applications".

## Assembly Instructions (20mm - 63mm)\*



### General Instructions

Follow these assembly instructions for a leak proof connection to last a lifetime. Before assembly ensure:

- That the end of the pipe to be inserted into the fittings is free of scratches and other imperfections.
- That both the end of the pipe and the fitting itself are clean of sand, mud, stones, etc.
- Do not overtighten nut when closing. NEVER use wrenches or spanners with handle lengths longer than 46cm – excessive torque during tightening can spread nut cone and result in pull outs.
- If fittings are reused, ensure split ring is sharp and bites into pipe to avoid pull outs. Alternatively replace split ring.

**Note:** We strongly recommend the use of PTFE tape in threaded connections.

1. Cut the pipe square and remove burrs. It is good trade practise to both chamfer (with a file or chamfering tool) and lubricate (use Medlube or an approved equivalent) the pipe ends. Chamfering and lubrication will ease insertion, however these steps are optional.

2. Undo the nut up to the last thread. Do not remove nut from body.

3. Twist the pipe into the fitting through the nut and split ring until it meets the first resistance – pushing against the captive O-ring. Push and twist the pipe past the O-ring until it stops at pipe stop inside the fitting – the final stop.

4. Firmly hand tighten nut. Use a wrench for a further half turn past hand tight for final tightening of fittings diameters 40mm and greater.

The full hydraulic seal is achieved when the pipe passes through the O-ring. Nut tightening is only to achieve pullout resistance – the hydraulic seal is automatically created when the pipe is pushed past the captive O-ring.

\*Contact your local Iplex Pipelines Sales Office for PLASSON assembly instructions for 75mm and 90mm diameter fittings