DPS – PPR Training

1. **Place the right-sized sockets onto the fusion tool.**

Durable Pipe Solutions fusion tools can handle PPR pipes ranging from 16 to 63mm, while our bench-mounted models can handle pipes up to 160mm.

2. **Plug in the fusion tool to begin heating the sockets.**

Durable Pipe Solution fusion tools will likely take several minutes for the tool to heat the sockets to the necessary temperature. Be very careful around a hot fusion tool, and make sure everyone in the area knows it's on and hot. The sockets reach temperatures of over 250 °C and can cause severe burns.

3. **Trim your pipe to length with a smooth, clean cut.**

While the fusion tool heats, mark and cut your pipe to the desired length. When you use your used trigger pipe cutter according to the directions, these will create smooth, even cuts.

4. **Clean the PPR pieces with the recommend cleaner.**

Durable Plastic Solutions tool kit will recommend, and will come with, a specific cleaner to use with PPR pipes. Use this cleaner as directed on the outside of the pipe and the inside of the fitting to be joined. Let the pieces dry for a few moments.
5. Mark the welding depth on the joining end of the pipe.

Your Durable Plastic Solutions tool kit come with a template for marking the proper welding depths onto various diameters of PPR pipe.

6. Confirm that the fusion tool is fully heated.

The target temperature is typically 260 °C (500 °F).

a. Protect your skin from the very hot fusion tool.

Always wear the necessary ppe.

Temperatures of over 80 °C can cause severe skin burns in less than a second, and the fusion tool heats up to 260 °C.

b. Press the PPR pieces straight into their sockets.

If you have a table-mounted fusion tool, hold the pipe in one hand and the fitting in the other so you can insert them simultaneously. If you have a handheld fusion tool, insert one piece then the other in rapid succession. Hold and insert the pieces straight in line with the sockets, not at an angle. Push the pipe into the female socket until you reach the depth marking you put on it. Push the fitting onto the male socket until it touches the ridge or line marked on the socket.

c. Pull the PPR pieces straight off/out of the sockets.
Just like when you put them in place on the sockets, don’t remove the pipe or fitting at an angle to prevent deforming the joint.
Pull the pieces off as soon as the alarm sounds or they’ve reached their heating time.

d. Push the pipe and fitting straight together immediately.

As soon as you remove fitting and pipe from the fusion tool, insert the pipe straight into the fitting until it reaches the depth line marked on it. Don’t insert the pipe at an angle, and don’t twist either piece — just push the pipe straight in.