

# Installation Instructions

## Rionfuse CF

### Polypropylene and PVDF Chemical Waste Systems

#### ⚠ WARNING



Please read carefully before proceeding with installation. Your failure to follow any attached instructions or operating parameters may lead to the product's failure.



Keep this Manual for future reference.

#### ⚠ DANGER



Electricity, electrocution and shock hazards.

### STEP 1

#### Preparing the Pipe

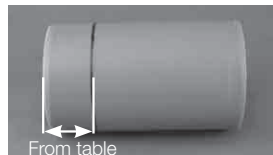
Prepare the ends of the pipe and fitting using the following method; field pipe cuts must be deburred. Following the coupling insertion depth chart, mark the coupling insertion depth from the end of the pipe/fitting to insure that the coupling is properly positioned during the fusion cycle. Then, using 60 grit emery cloth, abrade the marked ends of the pipe and fitting to remove the natural "sheen" of the plastic.

#### Coupling Insertion Depth Marking

Pipe Diameter <i>in.</i>	Mark Distance from Pipe End <i>in.</i>
1 - 1/2	1
2	1
3	1 3/8
4	1 3/8
6	2
8	2 5/8
10	2 5/8
12	2 5/8



Abrade surface



Mark coupling depth

### STEP 2

#### Joint Assembly

Insert the prepared ends of the pipe/fitting into both hubs of the Rionfuse CF coupling. Double check the markings to verify proper seating of the pipe.



Insert into coupling and verify proper seating



Rionfuse CF

### STEP 3

#### Connecting Lead Cables

The installer must make sure the joint is properly supported during the fusion cycle and afterwards as the joint cools. With the Rionfuser unit connected to a dedicated power source and powered ON, connect the lead cables to the coupling.

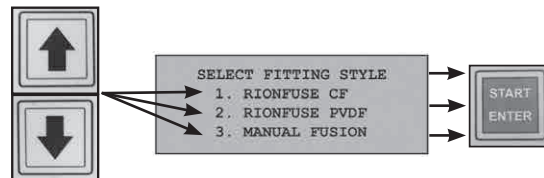


Connect lead cables

### STEP 4

#### Selecting Fitting Style

The unit will now prompt the installer to "SELECT FITTING STYLE". Scroll UP or DOWN to highlight the proper fitting style being fused, then press START to select the fitting style.



Fitting style selection screen

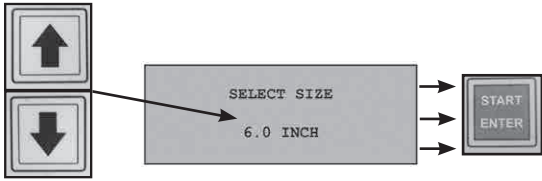
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## STEP 5

### Selecting Pipe Size

Next the unit will prompt the installer to select the size of the joint being fused. Scroll UP or DOWN to highlight the correct size, then press START to select size.

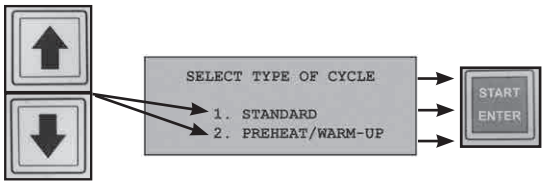


Fitting size selection screen

## STEP 6

### Selecting Heat Cycle

The unit will ask if a pre-heat cycle is needed for the joint. If the fusion is to be attempted in temperatures below 40°F, please consult Orion Fittings before proceeding; all other fusions should be performed in the STANDARD cycle. Select the STANDARD cycle by pressing the START button.



Fusion cycle type selection screen

## STEP 7

### Verifying Welding Parameters

The screen will display "VERIFY WELDING PARAMETERS" and an audible beep will sound to indicate the fusion unit is ready to begin welding. Verify the welding data displayed on the screen matches the joint being fused. If the information is incorrect, press the STOP/BACK button to return to any of the menu options to correct the fusion parameters. Once the parameters have been verified, press START to begin the fusion weld.

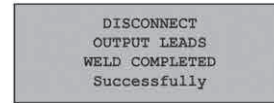


Fusion cycle type selection screen

## STEP 8

### Successful Weld Completion

After pressing START, the Rionfuser will begin the weld. After the welding cycle has completed, another audible beep will sound to indicate that the fusion weld is complete. If the beeping pattern is an equal, consistent beeping, the joint was successful. If the beeping pattern is irregular, it indicates that an error has occurred during the fusion cycle (if an error code is received during fusion, please contact your local Orion rep for troubleshooting information). Once the joint is completed, the lead cables can be removed and the process repeated for the next joint.



Successful weld completion screen

POLYPROPYLENE RIONFUSE CF COUPLING		
Pipe Size <i>in.</i>	Fusion Time <i>min.</i>	Fusion Current <i>amps</i>
1 - 1/2	2:00	8.25
2	2:00	8.25
3	3:00	14.25
4	3:00	14.25
6	4:30	19.00
8	4:45	19.00
10	7:20	17.00
12	8:00	16:50

PVDF RIONFUSE CF COUPLING		
Pipe Size <i>in.</i>	Fusion Time <i>min.</i>	Fusion Current <i>amps</i>
1 - 1/2	2:00	8.25
2	2:00	8.25
3	3:00	14.25
4	3:00	14.25
6	4:45	18.00

MULTIPLE JOINTING RIONFUSE CF	
Pipe Size <i>in.</i>	Maximum number of couplings <i>num.</i>
1 - 1/2	4
2	3
3	3
4	2
6	1
8	1
10	1
12	1

**WARNING:** This product contains chemicals known to the State of California to cause cancer and birth defects or other reproductive harm.  
For more information: [www.watts.com/prop65](http://www.watts.com/prop65)

**Warranty:** Our products are carefully inspected for manufacturing defects. However, it is not always possible to detect hidden defects. Our products are warranted only to the extent that we will replace them without charge if they are proved to have manufacturing defects within one year of the date of delivery to the site where they are to be used, or installed, and provided we have been given an opportunity to inspect any product alleged to be defective and the installation or use thereof.  
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