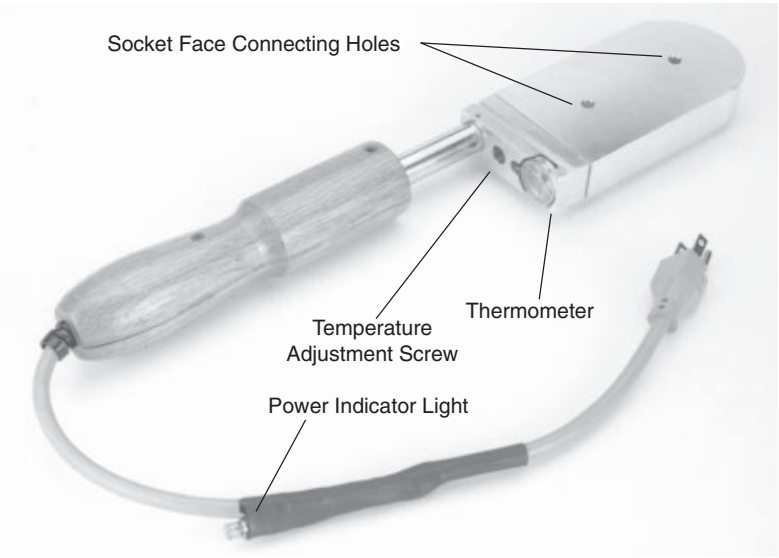
VANGUARD HEAT FUSION TOOL ADJUSTMENT

MODELS FHVT48 (single head) and FHVTD48 (double head)

Vanguard's heat fusion tools, designed for fusing polyethylene piping and fittings, offer reliability, compact design and temperature control for success in the heat fusion process. Features include a precision machined heater body, well-insulated handle, accurate thermometer, temperature adjustment, heavy-duty construction and a power indicator light. Vanguard's fusion tools also are designed for use with an optional light-weight bench mount which is easily attached to almost any work area.



(MODEL FHVTD48 Shown Above)

TOOL ADJUSTMENT

Tool heat-up time is approximately 12 to 15 minutes. When the thermometer dial reads about 550°F, the tool should be ready for use. Although all tools are adjusted at the factory to maintain proper fusion temperature (500°F to 525°F) on Vanguard socket faces, the surface temperature of the socket faces will differ from that shown by the tool thermometer. To ensure proper socket face temperature, it is necessary to check them with a digital pyrometer or with heat sensitive temperature indicating crayons (use 500°F and 525°F). Do not make marks on any face surface that will contact the pipe or fitting.

The mark from the 500°F temperature indicating crayon should become completely molten, and the 525°F crayon should remain relatively solid. Temperature indicating crayons are available from Vanguard (part number FHS500 and FHS525).

If the socket face temperatures are too hot, decrease the tool temperature by turning the temperature adjusting screw clockwise. If the temperature is too cool, turn the adjustment screw counter-clockwise. Because of the sensitivity of the thermostat, the temperature adjustment screw requires only minimal movement to either increase or decrease the temperature.

Proper temperature control is essential for good fusion. Poor joints are likely to result from a tool face that is either too cold or too hot. If a tool fails to perform properly, return it to Vanguard for adjustment and/or repair. Repair work is to be performed only by the factory.

IMPORTANT:

- Use a power supply not in use with other tools. Single face heating tools draw 400 watts, while double face tools draw 500 watts. Allow a minimum of 5 amp service.
- Loose socket faces impair heat transfer.
- Inadequate power supply and inadequate power cord may cause loss of amperage resulting in heat loss.
- Other tools on the same power source may cause loss of amperage and heat.

GUARD AGAINST ELECTRIC SHOCK. Prevent body contact with grounded surfaces. Rubber gloves and non-skid footwear are recommended when working outdoors, where damp or wet ground may be encountered. A Ground Fault Circuit Interrupter protected power line must be used in these conditions.

Vanguard
Piping Systems, Inc.
901 N. Vanguard St., McPherson, KS 67460
620-241-6369 or 800-775-5039
www.vanguardpipe.com

QTPN01VS 3.02