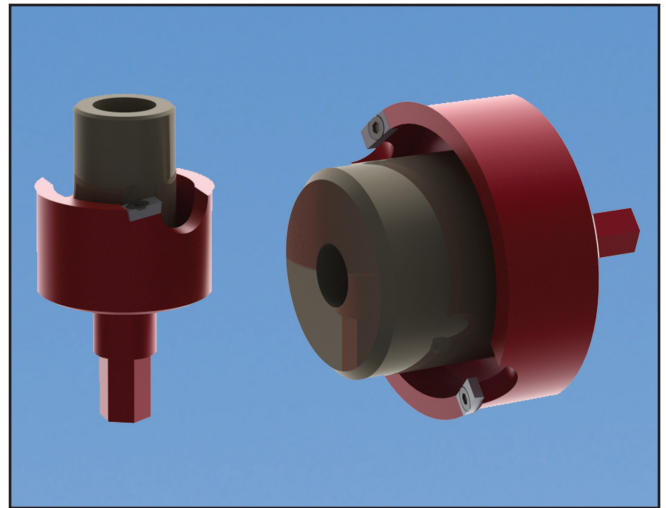


Poly-Flo® - Rib Removing Tool

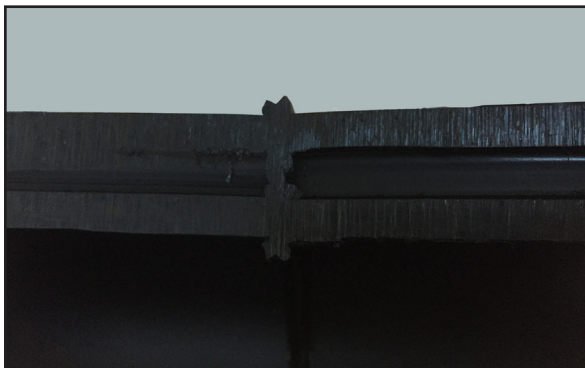
Installation of Poly-Flo® pipe may require welding lengths of pipe together. Because the pipe is co-extruded, the installer must consider how to orient the supporting ribs so that no sections become closed off during installation.

One method is simply to rotate the pipe so the ribs do not line up, thus allowing detection in all cavities.

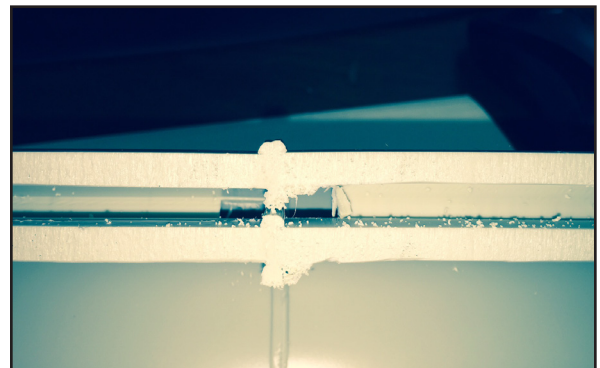
If this method is not convenient or practical, Asahi offers a mechanical solution to removing the ribs at the end of the pipe.



Size		Part Number
32 x 50	1 x 1-1/2	557880211
63 x 90	2 x 3	557880338

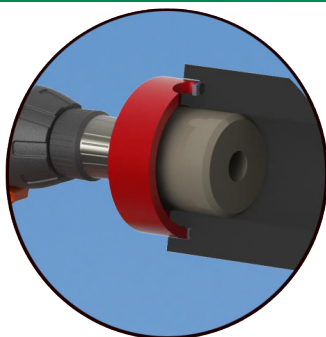


Without Rib Removal – possible to block annular flow within high side of weld parameter tolerance.



With Rib Removal – adequate annular flow, even with less than perfect welding.

Procedure



- 1) Secure pipe in clamp
- 2) Locate the rib removing tool by inserting the centralizer
- 3) Start the drill rotating before pushing the tool into the pipe
- 4) Check for visual conformance and continue welding

