

SOP (HDPE BUTT FUSION)

SS-WHS-SAF-000

Authorised By:
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TASK	HDPE Butt Fusion					
HAZARDS	Flying debris	<input type="checkbox"/>	Heat / cold	<input checked="" type="checkbox"/>	Electricity	<input checked="" type="checkbox"/>
	Cuts / laceration	<input type="checkbox"/>	Dust	<input type="checkbox"/>	Rollover	<input type="checkbox"/>
	Pinch / crush	<input type="checkbox"/>	Noise / vibration	<input type="checkbox"/>	Plant interaction	<input type="checkbox"/>
	High pressure	<input checked="" type="checkbox"/>	Chemical	<input checked="" type="checkbox"/>	Fire	<input checked="" type="checkbox"/>
PPE REQUIRED						

PRE-START CHECKS

1. Ensure all personnel are trained and authorized to perform HDPE butt fusion.
2. Inspect the fusion machine for any visible damage, leaks, or signs of wear.
3. Check that the heating plate and facer are clean and free of any debris.
4. Verify that the fusion machine is properly calibrated and functioning correctly.
5. Confirm that fire extinguishing equipment is readily available in case of emergency.

SAFE OPERATING PROCEDURE

1. Wear appropriate personal protective equipment (PPE) including safety glasses, gloves, and heat-resistant clothing.
2. Position the HDPE pipes in the fusion machine, ensuring proper alignment and support.
3. Start the fusion machine and allow it to warm up to the appropriate temperature.
4. Use the facer to remove any oxidized material from the pipe ends.
5. Heat the pipe ends evenly using the heating plate until they reach the specified fusion temperature.
6. Align the pipe ends and apply pressure to fuse them together, maintaining pressure until the joint cools and solidifies.
7. Monitor the fusion process closely, ensuring that all parameters are within the specified range.
8. If any issues or errors occur during fusion, stop the process immediately and troubleshoot the problem before resuming.

POST-OPERATION PROCEDURE

1. Allow the fused joint to cool completely before handling or testing.
2. Inspect the fused joint for any defects or signs of incomplete fusion.
3. Clean the fusion machine and surrounding area to remove any debris or spilled materials.
4. Record fusion parameters and any relevant data for quality control purposes.
5. Store fusion machine and accessories in a designated area, ensuring they are protected from damage and unauthorized use.