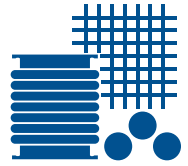


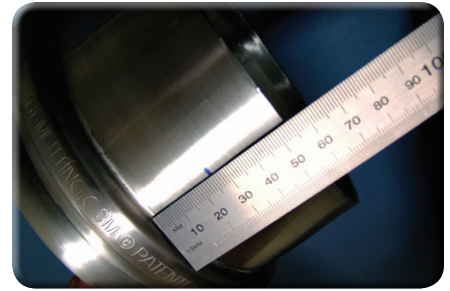
BFM® SPIGOT WELDING INSTRUCTIONS



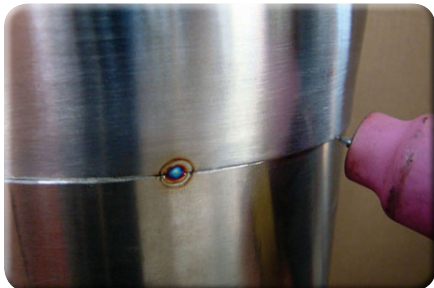
DO NOT cut the BFM® spigot and re-size before installation.



Size spigot to pipe. Pipe circumference may need to be expanded or reduced to fit the BFM® spigot.



If it is necessary to shorten the tail, do not cut the tail more than 1" (25mm) unless absolutely necessary. Welding any closer than 1" (25mm) to the head, could result in welding shrinkage effecting the tolerance of fit between the flexible connector cuff into the BFM® fitting. *Consult Siftex prior to cutting.*



Tack BFM® spigot to correct-sized pipe.



Peen the tacked joint to ensure correct fit.



Weld the BFM® spigot on. Dress and polish to required standards.



Be careful to ensure that the circumference of the formed end after fitting and welding, remains the same size as supplied, to ensure fitting tolerance of the connector.

