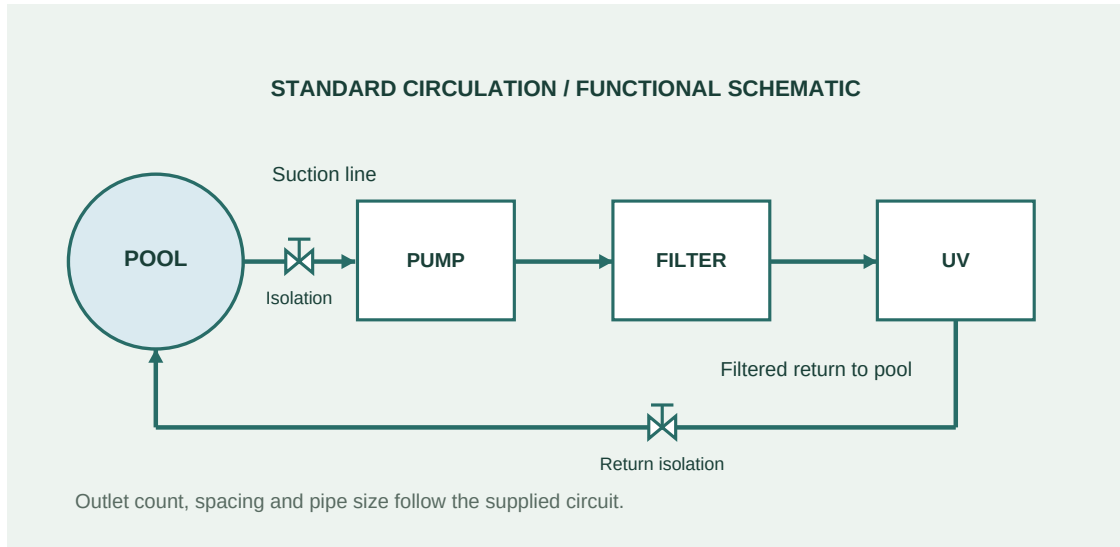


TRU BLU / PRACTICAL INSTALLATION SERIES

Plumbing & circulation

Identify the lines. Build serviceable joints. Check the complete circuit.



Work through this manual

Page	Stage
2	Read the circulation circuit
3	Heating branch & isolation
4	Measure, cut & prepare each joint
5	Support the pipes; preserve the seals
6	Wet-test and record the circuit

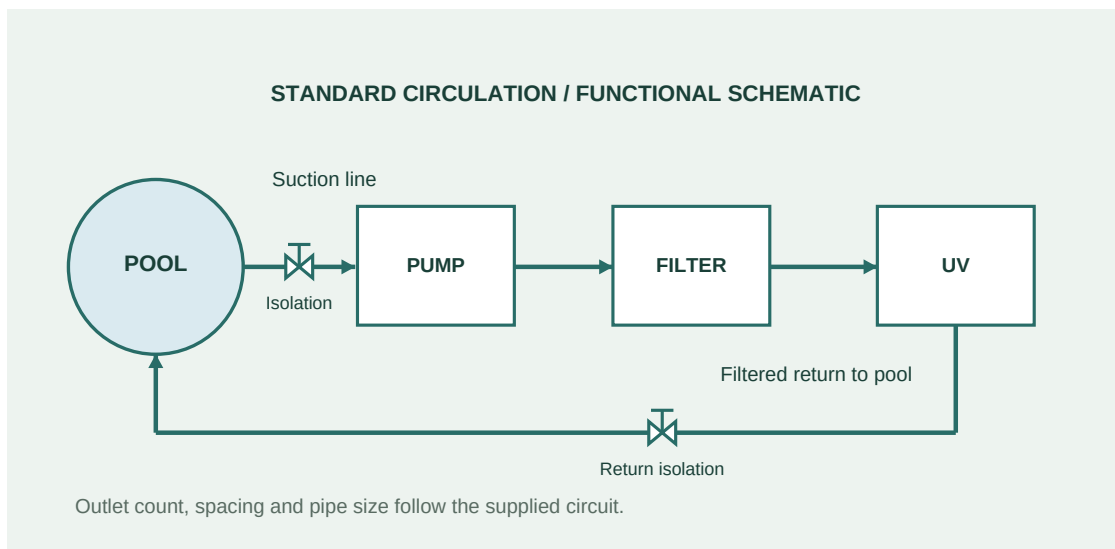
Have these ready

PVC pipe cutter or fine-tooth saw | Deburring tool, tape measure and marker | Material-compatible primer / solvent cement | Pipe clips, supports and clean cloths

Use with your supplied pool construction detail and equipment instructions. Dimensions on functional diagrams are not drilling templates. DIY assembly is supported; electrical work requires a licensed electrician.

01 / PLUMBING & CIRCULATION

Read the circulation circuit

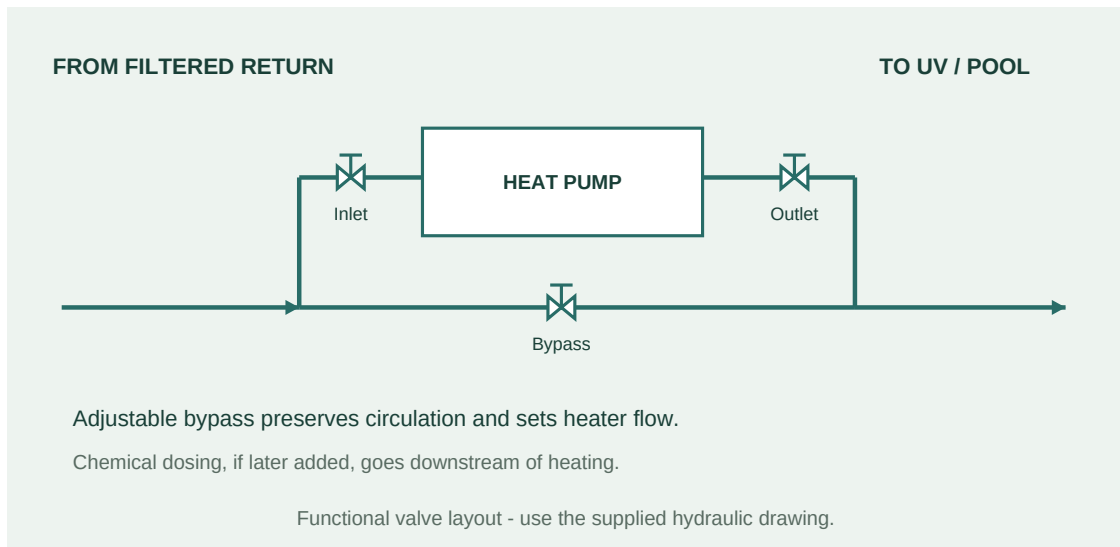


1. Identify the supplied suction arrangement and return connection on the pool. Keep the whole engineered suction layout intact.
2. Trace suction to the pump inlet; pump discharge to the filter inlet; filtered water through the UV return circuit and back to the pool.
3. Mark flow arrows on the pipework and label accessible valves. The diagram shows function, not the drilling position or number of suction outlets.
4. If heating is selected, use the heater branch shown on the next page and the installation drawing supplied with the kit.

No spa-jet circuit is included in the standard package. Do not add a pump or outlet branch without the corresponding system design.

02 / PLUMBING & CIRCULATION

Heating branch & isolation

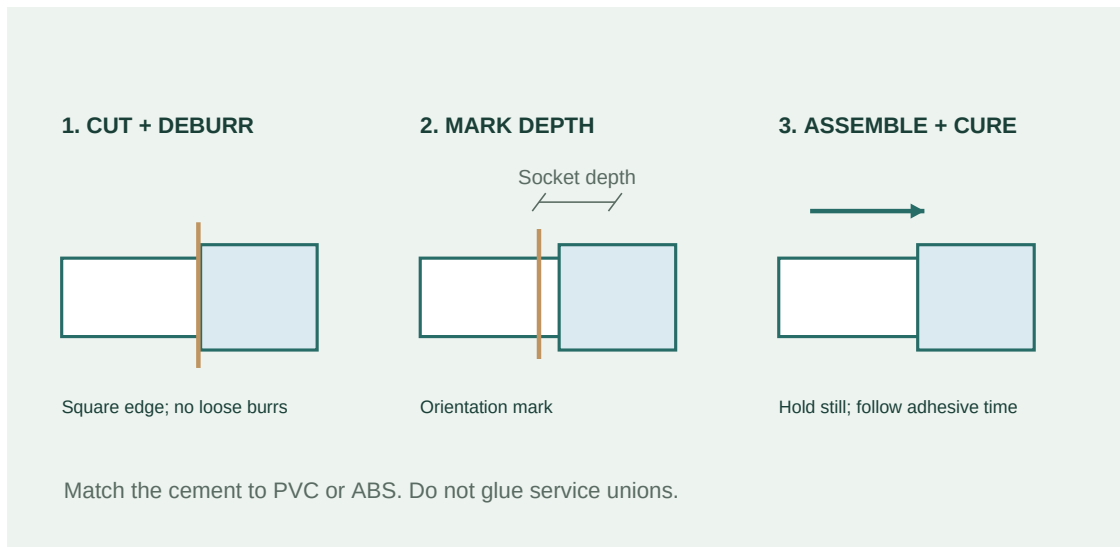


1. Install the heat pump in the filtered return circuit with the specified adjustable bypass. Match the actual IN and OUT markings.
2. Provide service isolation and unions where shown, with room to remove each unit without cutting surrounding pipework.
3. Keep the UV upstream of any additional sanitising device. Any later chemical dosing belongs downstream of the heat pump.
4. Leave the bypass controls accessible and label their commissioning setting. Isolating the heater must not accidentally stop all normal pool circulation.

This is a functional three-valve bypass illustration. A supplied three-way-valve layout may differ while serving the same purpose.

03 / PLUMBING & CIRCULATION

Measure, cut & prepare each joint

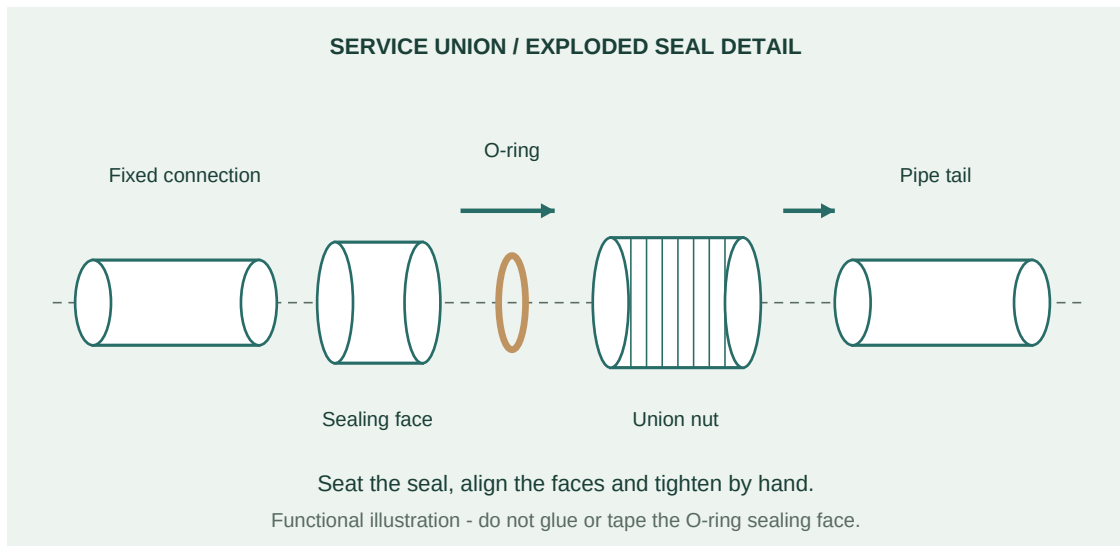


1. Lay out equipment and dry-fit pipe lengths before gluing. Account for the socket insertion depth at both ends of each piece.
2. Cut square, remove burrs inside and out, and clean mating surfaces. Mark the insertion depth and final orientation on the pipe.
3. Check the adhesive for the materials being joined. Ordinary PVC pressure joints and ABS shell fittings must not be treated as interchangeable.
4. Apply, assemble, hold and cure each solvent joint to the adhesive instructions. Keep the joint still while it sets; do not fill early.

For Spa Electrics Pro-Suction, the manufacturer specifies clear Type-N cement at the fitting and advises against Type-P. Use the correct pressure-pipe adhesive elsewhere.

04 / PLUMBING & CIRCULATION

Support the pipes; preserve the seals

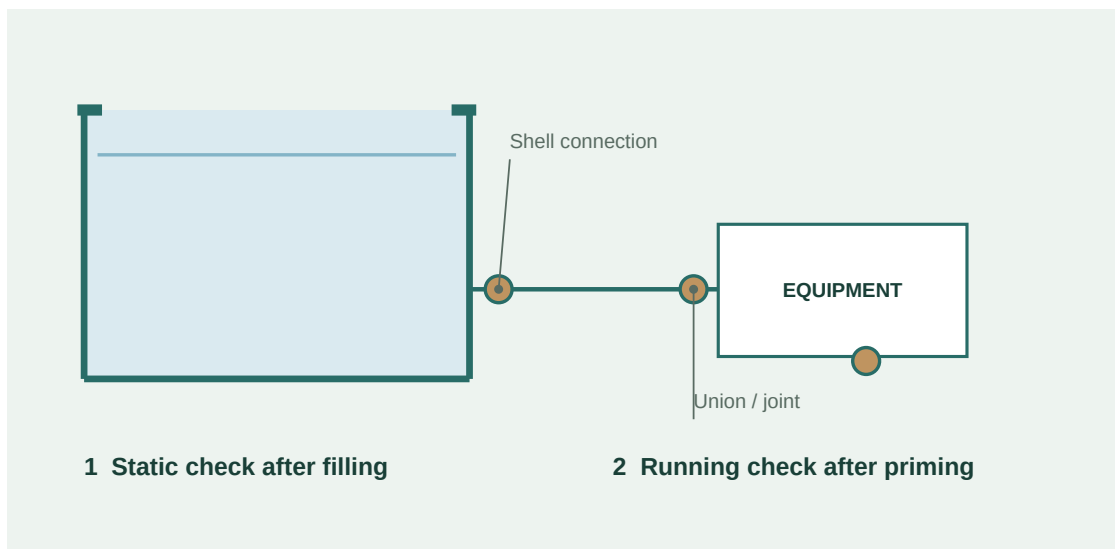


1. Support pipe weight independently near equipment and changes of direction. A union or shell fitting should not be pulled sideways to make an awkward run fit.
2. For Davey O-ring barrel unions, inspect the seal and groove, use compatible O-ring lubricant where instructed, align the mating faces and tighten by hand.
3. Leave unions, isolation handles and drain points accessible. Mark buried routes and photograph them before covering.
4. Check the pipe sizes against the circuit detail. Davey CrystalClear requires 50 mm pipe where piping length exceeds 15 m.

Do not put solvent cement, silicone or thread tape on an O-ring union sealing face.

05 / PLUMBING & CIRCULATION

Wet-test and record the circuit



1. Complete required inspections before pipework is covered. Allow every adhesive and sealant its specified cure time.
2. Fill to the operating waterline, inspect the shell fittings under static water load, then prime and run the pump to inspect the moving-water circuit.
3. Check suction for persistent air entry and returns for leaks. Inspect every union, fitting and supported joint with access unobstructed.
4. Stop and isolate before correcting a leak. Depressurise filter equipment before opening it. Never use compressed air to test the filter.

Job check / record	Result
Suction / return pipe size	_____
Adhesive and cure completion	_____
Static leak check	_____
Running leak check	_____
As-built photographs / valve labels	_____

Start equipment only with the correct water supply and valve positions.

Technical references

Spa Electrics Pro-Suction installation manual 20200602. | Davey CrystalClear installation instructions 402620-6.

[Spa Electrics fitting manuals - open official instructions](#)

[Davey equipment manuals - open official instructions](#)