



STEP 1 – TURN OFF POOL EQUIPMENT

Turn OFF the following equipment and allow it to remain OFF during installation.

- Pool Pump
- Automation System
- Associated Equipment



STEP 2 – INSPECT FUSION 44X

Verify the following:

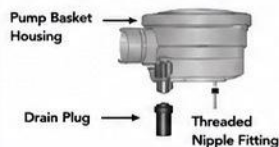
- ✓ No shipping damage
- ✓ Tubing connections are secure
- ✓ Electrical connections are secure
- ✓ Probe assembly is properly installed



STEP 3 – CONNECT TO PUMP BASKET

1. Locate drain plug underneath pump basket housing.
2. Remove drain plug.
3. Install supplied threaded nipple fitting.
4. Hand tighten securely.
5. Do not overtighten.

PUMP BASKET CONNECTION



IMPORTANT:

If cyanuric acid exceeds 100 ppm
OR salt exceeds 3,000 ppm,
drain your pool or at least
halfway before installing
Fusion 44X.



STEP 4 – CONNECT PROBE ASSEMBLY

1. Plug the other side of the supplied hose into the top of the Fusion 44X probe.
2. Insert the probe into the gallon cap assembly.
3. Hand tighten securely.
4. Do not overtighten.

PROBE CONNECTION



STEP 5 – VERIFY TUBING CONNECTIONS

- Confirm all factory-installed tubing remains securely connected.
- Do not alter, remove, or shorten supplied tubing.

IMPORTANT

Maintain the regulator and tubing loop at least 24 inches above the pool water level at all times. This prevents water migration into the Fusion 44X system.



STEP 6 – CONNECT POWER

Plug Fusion 44X into a properly grounded 110V power outlet automatically.

VERIFY METER READINGS

After the unit powers on, verify the display readings are within the normal ranges below.

READING	NORMAL RANGE	DESCRIPTION
4.5 – 5.5		Power Supply Voltage
2.0 – 3.5		Hydrogen Production Range
12 – 19		Probe Function Value

If readings fall outside these ranges, contact Fusion 44X Technical Support.



STEP 7 – START POOL PUMP

1. Turn the pool pump ON.
2. Set the Fusion 44X timer to run whenever the pool pump is running.
3. Verify the Fusion 44X powers on and off with the pool pump schedule.

IMPORTANT:

Fusion 44X should operate whenever the pool pump is running.



VERIFY OPERATION

Observe the return fittings inside the pool.

You should see fine champagne-style microbubbles entering the water.

Visible microbubbles indicate proper operation.



RECOMMENDED PUMP RUN TIMES

POOL SIZE	DAILY RUNTIME
5,000 – 13,000 Gallons	6 – 10 Hours
14,000 – 28,000 Gallons	8 – 12 Hours

INITIAL STARTUP PERIOD (FIRST 7–14 DAYS)

- Run pump according to recommended schedule
- Maintain normal filtration
- Brush pool surfaces as needed
- Vacuum weekly
- Empty skimmer baskets regularly
- Remove debris weekly

Water clarity may continue improving during startup.

TARGET WATER CHEMISTRY

PARAMETER	TARGET RANGE
pH	7.2 – 7.8
Total Alkalinity	80 – 120 ppm
Phosphates	0 – 100 ppb

Note: Cyanuric acid (stabilizer / CYA) exceeds 100 ppm or salt exceeds 3,000 ppm. Drain your pool or at least halfway.

ROUTINE MAINTENANCE



WEEKLY

- Check meter readings
- Verify microbubbles are visible
- Test pH
- Test Total Alkalinity
- Empty skimmer baskets



MONTHLY

- Inspect tubing connections
- Verify unit operation
- Confirm pump runtime settings
- Inspect power connections



PROBE REPLACEMENT

Replace the Fusion 44X probe approximately every

1,600 – 2,000
operating hours.

Replacement probes available at
Fusion44X.com



ACID REQUIREMENTS

Use only **31%–32%** Muriatic Acid.

One gallon typically lasts approximately

220 Fusion 44X
running hours.

Replace acid gallon when depleted. Do not substitute alternative acid products unless approved by Fusion 44X.

⚠ WARNING

ACID REQUIRES VENTING

Do not store in an enclosed area.

Do not place near electrical equipment.

Keep away from all electrical devices and connections.