

Assembly instruction for arco cutting ring fittings

Assembling in the fitting body



<p>1.</p>	<p>2.</p>	<p>3.*</p>
<p>Saw off metal tube square. Max. angletolerance 0,5°. Do not use tube cutters! Deburr inside and outside edge lightly. Clean. For thin-walled tubes please use reinforcing sleeves.</p>	<p>Thread and cone of the union as well as the thread of the nut must be threaded with an lubrication medium. Slip nut and cutting ring on the tube. Ensure that the thicker end of the cutting ring face the nut.</p>	<p>Push the tube against the shoulder in the cone of the body. Then screw nut manually on to the fitting body until fingertight. Tighten nut with spanner 1,5 turns.</p>
<p>4.</p>	<p>5.*</p>	<p>6.*</p>
<p>Loosen nut and check the cut. A visible collar has to fill the space in front of the cutting ring edge. It is no fault if the cutting ring can be rotated on the tube.</p>	<p>Final- or Repeat-assembling. After loosing the nut, tighten again without increased effort. Body to be held firmiy by a spanner.</p>	<p>Insert the sleeve into the pipe up to the knurl. Knock in the sleeve completely using a hammer (plastic or hard rubber). The knurl forces itself into the tube wall and secures the sleeve. Do the assembling (look at the assembling instruction in the catalogue).</p>

3.* Final assembling in the body:

Push the tube firmly against shoulder in the cone, tighten nut with spanner about 1,5 turns. The tube must not be rotated.

Pre-assembly in a pre-assembly body:

Push tube firmly against shoulder in the cone, tighten nut with spanner about 1 turn.

After disassembly:

The tube ends have to be inserted in the same cones of the bodies in which the assembly was carried out.

5.* Final assembly of all pre-assembled fittings:

Tighten nut about ¼ turn beyond the point of a clearly perceptible resistance. This is valid as well for all pre-assembled fittings delivered by the manufacturer.

6.* Assembling with reinforcing sleeve:

If due the requirements of the internal pressure the wall thickness in relation to the external is too low, there can be constrictions of the tube. To avoid this reinforcing sleeves should be used.