



ASSEMBLY INSTRUCTIONS FOR PIPETEC SCREW FITTINGS

Neither pressing tools nor pressing jaws are required for assembling compression fittings. Leak-tightness is achieved simply by tightening the union nut. The clamping ring is crimped onto the pipe using the cone on the inside of the union nut.

► NOTE

Perfect functioning of the pipe connection can only be ensured by using fittings with the DVGW-certified Pipetec aluminium multilayer composite pipe. Please note how important it is to ensure correct and expert calibration and deburring using a suitable tool. Always protect fittings with insulation or suitable adhesive tape to protect them from direct contact with concrete, screed, construction foam, mortar, etc. Make sure installation is stress-free! Brass threads that are sealed too tightly (especially when using hemp) can lead to tension in the brass. This can lead to stress corrosion cracking due to assembly.


1

CUTTING THE PIPE TO LENGTH

The pipe must be cut to the desired length using a suitable tool. The cross-sectional area of the cut must be perpendicular to the pipe. Diagonal cuts must be avoided.

Handsaws, jigsaws and blunt tools are not suitable for cutting to length.


2

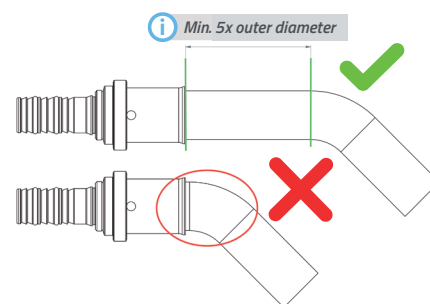
CALIBRATING AND DEBURRING THE PIPE

The pipe end must be calibrated and deburred after trimming. To do this, the calibrator must first be inserted into the pipe up to the stop. Deburring is then completed by turning the calibrator. Turning removes material from the interior of the pipe, creating a chamfer on the end of the pipe. This chamfer makes it easier to insert the fitting and protects the O-rings from damage.


3

ASSEMBLY OF FITTINGS

Union nut and clamping ring must be positioned on the pipe as per the illustration. The nipple of the basic body is then fully inserted into the pipe. Clamping ring and union nut are pushed into the basic fitting body up to the stop. The union nut can then be tightened by hand.


4

TIGHTENING THE CONNECTION

The union nut must be tightened using a suitable tool until the corresponding resistance is reached. Then check the connection. It is essential to carry out a pressure and leak test (see page 94).

The recommended tightening torques for our screw fittings are:

Size 16 pipe	> 20 Nm
Size 20 pipe	> 30 Nm
Size 26 pipe	> 45 Nm
Size 32 pipe	> 75 Nm