ASSEMBLING INSTRUCTIONS

Assembling instruction for fittings Ø16 - Ø40 mm



Limber up the nut, but do not remove it completely.



Insert the pipe into the fitting. Make sure that the pipe crossed the O ring - gasket.



Fully coil back the nut.



Assembled PP fitting.

Assembling instruction for fittings Ø50 - Ø110 mm



Pull up the nut, the clinching ring, the thrust ring, and O-ring on the pipe.



Put together the pipe, O-ring, and thrust ring into the body. Push the pipe until the internal register is inside a fitting. Make sure that O-ring and thrust ring are in their original position.



Pull back the clinching ring to its original position.



Pull back the nut and fully coil it up to the fitting.

Proposal for easier installation for fittings Ø90 - Ø110 mm



Pull up the nut, the clinching ring, the thrust ring, and O-ring on the pipe.



Place the pipe into the body of the fitting. O-ring and thrust ring are pushed into place, fully winding the nut.



Uncoil the nut, then stretch the clinching ring and place it into the pipe right next to the thrust ring.



Pull back the clinching ring to its original position.

IMPORTANT

- The end of the pipe has to be chamfered and cleaned from chips.
- From Ø20 mm to Ø40 mm is enough to coil the nut by hand.
- If the nut is not fixed completely, there can be dripping or flowing at the O ring-gasket or the pressure can set off the pipe from the fitting.
- The threaded end of the PP fitting has to be covered with PTFE (polytetrafluoroethylene) tape or braid.
- The threaded end of PP fitting has to be coiled in completely (useful thread length).
- Above 50 mm diameter, a wrench or tool has to be used to reach the perfect bonding.

• Torque values for tightening nut:

DN	16	20	25	32	40	50	63	75	90	110
Nm	6.5	8	15	18	28	40	65	110	140	240

- Fittings Ø90 110 mm:
- Position the pipe app 5 mm from the internal register, while tightening the nut, it will push together the clinching ring thrust ring, O-ring, and the pipe to the right position.
- Tighten the nut and make sure that the nut exceeds the last thread of the body, until a 1 2 mm gap is left next to the fitting edge.