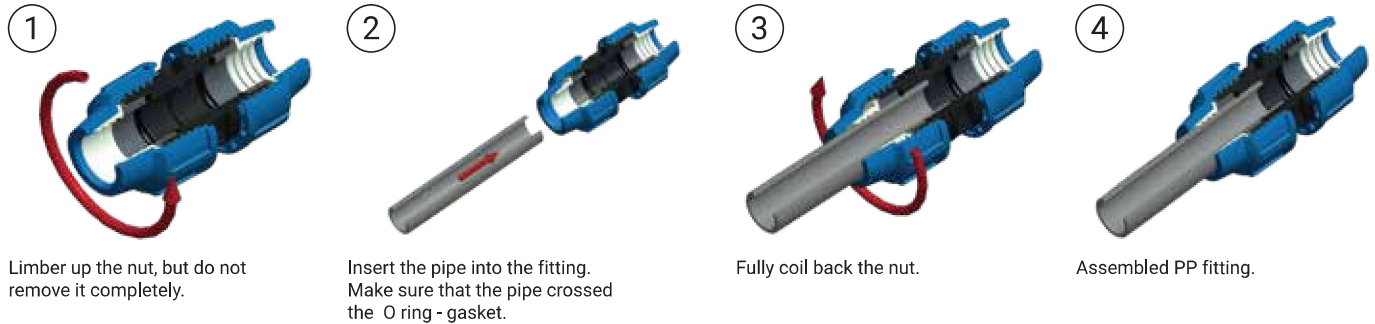
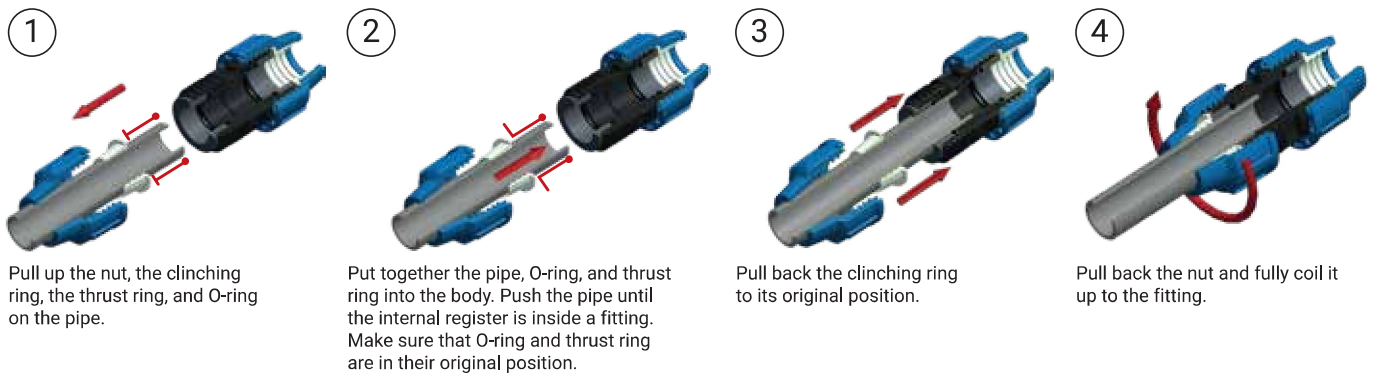


## ASSEMBLING INSTRUCTIONS

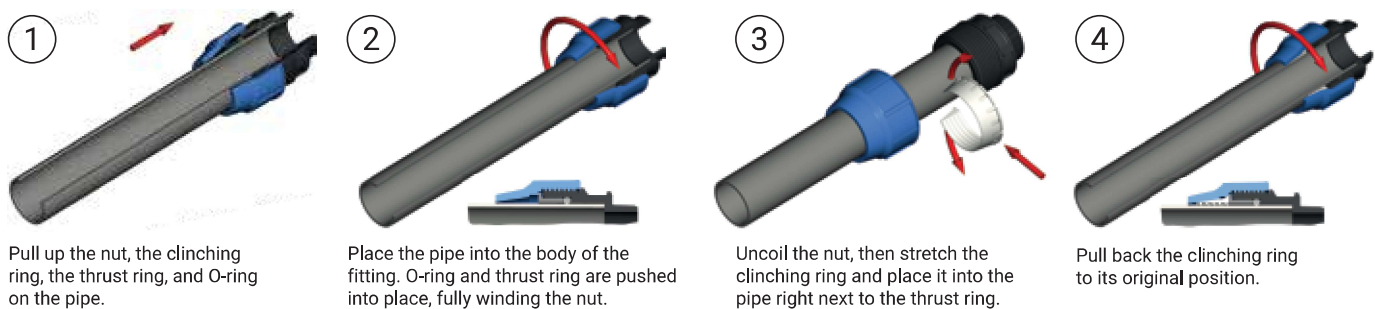
### Assembling instruction for fittings Ø16 - Ø40 mm



### Assembling instruction for fittings Ø50 - Ø110 mm



### Proposal for easier installation for fittings Ø90 - Ø110 mm



#### 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.