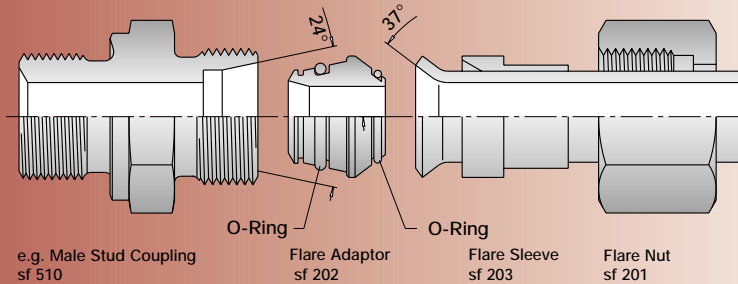


■ Flare Fittings

Technical information on the connection of a 37° Flare Fitting to a threaded coupling to DIN 3853 with 24° cone



■ Operation:

In order to connect a 37° flared pipe to a 24° inside cone, a flare adaptor, sf 202 should be used. This adaptor has the respective angles of the fitting and of the pipe and is fitted with an O-Ring on both sides so that a high quality elastomer seal to both sides is made. The Flare Nut has a metric thread, allowing connection to the standard compression fitting. The pipe has to be flared in accordance with ISO 8434-2, Table 5, ensuring that the O-Ring on the Flare Adaptor is fully covered by the flare. The flare dimensions are given in the table below.

■ Assembly:

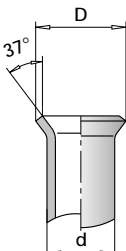
Press the Flare Adaptor sf 202 by hand into the 24° Cone as shown in the diagram above. Slide the Flare Sleeve, sf 203 and the Flare nut, sf 201 onto the flared pipe and hand tighten onto the Stud Coupling. Then tighten the Nut with a spanner approximately 1/4-1/2 turn. The coupling should be held with a second spanner.

Material AISI 316Ti

O-Rings are made of Perbunan (NBR), Viton available on request.

■ Flaring the pipe:

We recommend the use of electro-hydraulic flaring machines with hardened flaring cones in order to obtain an accurate flare and hence a perfect fit. The tolerances for the respective pipe sizes are shown in the table below:



d	6	8	10	12	14	15	16	18	20	22	25	28	30	35	38	42
Dmin	9,5	11,5	13,5	15,5	18,5	19,0	20,0	23,0	25,5	26,0	31,5	32,5	37,5	40,0	46,0	48,5
Dmax	10,0	12,0	14,0	16,0	20,0	20,0	21,5	24,0	27,0	27,5	33,0	33,0	38,5	42,5	47,0	49,5