

Assembly Instruction



For standard fittings and assemblies of stainless and acid proof steel pipes use hardened pre installation studs.

Check the accuracy of the cones regularly using a cone gauge. Worn studs should be replaced.

We only recommend the use of seamless stainless steel pipe in AISI 316Ti.



N.B. Do not use welded pipe!

Cut the pipe square using a saw. On no account should pipecutters be used.



De burr the pipe internally and externally, but do not chamfer the edges.

When using thin-walled pipe, we recommend the use of reinforcing rings, sf 595.



Fix the pre installation stud relative to the pipe size into a vice.



Lubricate the pre installation stud, nut and ring with sf 5 GP Lubricant

Tube 100 g: sf 5GP 100
Can 250 g: sf 5GP 250
Can 500 g: sf 5GP 500
Can 1000 g: sf 5GP 1000



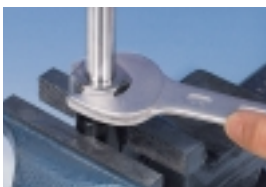
Slip the nut and ring over the tube end, narrow collar towards cut.



Turn union nut manually into the pre installation stud.
Press tube against stop on inside of cone.



Using the sf trademark on the nut, mark the pipe.



Turn nut with a spanner approx. one full turn, ensuring that the pipe remains stationary. The ring will cut into the pipe.

N.B. On the assembly of sf-brilliant Twin Cut rings it is possible to increase to between 1 1/4 - 1 1/2 turns.

■ Check



Loosen nut and check ring. The ring should be sitting parallel with the tube on the whole circumference. The distance from the ring to the end of the pipe should be constant. The ring should be able to turn but should not be able to move backwards or forwards.

N.B.: sf-brilliant Twin Cut rings fit quite loosely on the pipe, despite the additional 1/2 turn during assembly.

■ Final assembly onto the body:



Put pre installed tube into fitting body. Tighten the nut approx. 1/4 to 1/2 turn beyond the point of clearly perceptible resistance.
Use a second spanner to stop fitting body from moving.

On larger sizes, a spanner with sufficient lever length should be used.

Reinforcing Rings sf 595



Due to cost implications, thin walled pipe is regularly used. This pipe is not able to withstand the pressure of the cutting ring during assembly and to resolve this problem, we recommend the use of our reinforcing sleeves.

Assembly:



The reinforcing rings can be easily inserted into the tube.



The knurled part can be driven into the tube using a soft hammer.

A press fit results, without causing widening of the tube.

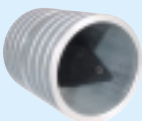


The reinforcing ring sits firm and supports the tube during assembly.

Plugs sf 589



The plug is inserted with the tapered side into the cone. The nut is screwed manually until the plug sits tight. Tighten the nut with a spanner approx. 1/8 turn. This is sufficient to make the seal. If the nut is overtightened the plug may be deformed, and it cannot be re-used.



Deburring Tool
RE 10-56



Pre installation stud
SF 592 ...



Hacksaw Guide
SF AV 6-42



Cone Gauge
KL