

Installing instruction

Brass/Stainless steel/Steel

Brass chemical nickel-plated see separated instructions.

1. Preparation

Cut the tube to length and deburr it. The tube must be straight and free from blemishes for approximately 1,5 d from the end. The union is lubricated. Thus lubrication with lubricating oil, MoS₂, Teflon etc. is recommended for the assembly and reassembly of bigger sized unions (thread, compression ferrule).

2. Reinforcing the tube and pushing it in

Stiffener sleeves* are required to reinforce plastic tubes and thin walled tubes

Copper	from d 10 mm with s < 1,0 mm from d 12 mm with s < 1,5 mm
Stainless steel	from d 6 mm with s < 0,5 mm from d 10 mm with s < 1,5 mm
Plastic	all

Align tube and union. Insert the tube as far as the stop.

3. Compression, stress relieving

- 3.1 Screw on the union nut by hand until finger tight. At the same time, push the tube against the fitting.
- 3.2 Tighten down the union nut 1 1/2 rotation using an open ended spanner. (Making a mark will assist in correct rotation.)
- 3.3 Slightly release the nut once again to take the radial stress off the tube.
- 3.4 Screw on the union nut until finger tight again and tighten down the union nut with 1/4 rotation for the final fit. (Hold adaptor from turning with a second wrench.)

4. Checking of fit

Release the union nut completely. A distinct bead or deformation must be visible on the inside of the tube.

5. Repeated fitting of the union

When refitting the same tube union, screw the union nut back on until finger tight and tighten down the union nut with an open ended spanner 1/4 rotation for the final fit.

In case of repeated assembly, parts must be lubricated.

Tubes*

Tubes with a clean smooth external surface and with an outside diameter within the tolerance ± 0.1 mm should be used. (See also table «Minimum wall» in the appendix.)

Turnable compression ferrule

It is of no detriment to the efficiency of the connection if, after assembly, the ferrule can be turned on the tube, or the tube in the union nut.

Pre-assembly stud

SO 56000, stainless steel, tuffride treatment, for stainless steel and brass M-Programme.

SO 6000, CrNi steel hardened, for steel.