

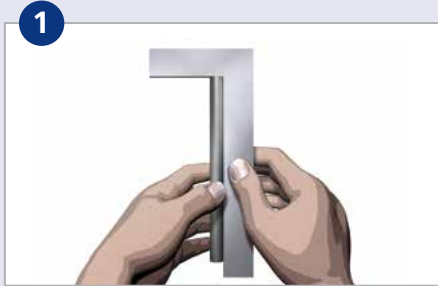


Make better connections!

Direct assembly into fitting body

Assembly instructions for carbon steel cutting ring

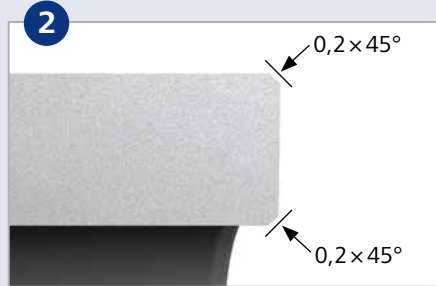
We strongly recommend pre-assembling with VOMO or machine driven!!!



1. Saw the tube off square.

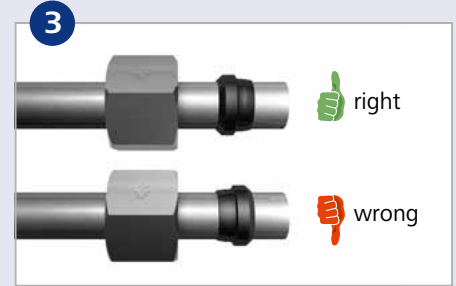
An angular deviation of $0,5^\circ$ relative to the tube axis is permissible.

Please note!!! Do not use pipe cutters.
Use reinforcing sleeve with thin wall tubes.



2. Lightly deburr the tube ends and clean thoroughly.

The tube end within the assembly length must be free from swarf, dirt and paint.



3. Assembly of cutting ring

Place nut and cutting ring on tube as shown.

Please note!!! Ensure that the cutting ring edge is facing the tube end.



4. Find point of resistance

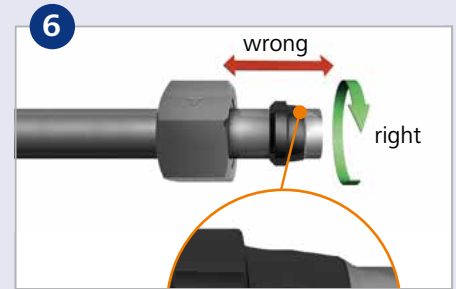
Push pipe completely into the connector. Tighten nut until the ring makes contact with the tube surface – this point can be felt by an increase in torque.



5. Final assembly

After the ring has contacted the tube, mark position of the nut. Tighten the nut by 1 turn. Ensure to use spanner extension as required.

Please note!!! Fitting body to be used one time only. If pre-assembling is required please use VOMO.



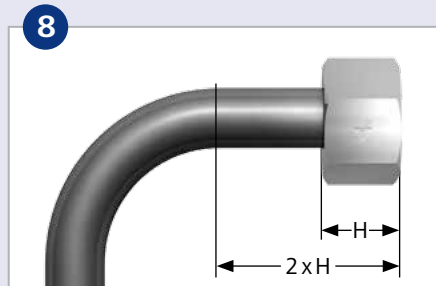
6. Control

Check penetration of cutting edge. A visible ring of material should fill the space in front of the cutting ring end face. Cutting ring may turn on tube but should not be capable of moving in an axial direction.



7. Repeated assembly

Each time the fitting has been loosened, re-assembly must be performed with the same torque as initial assembly. Hold the body rigid. Recommended to use spanner extension as required.



8. Minimum length of straight tube end for tube bends

For tube bends, the length of the straight tube end up to the start of the bend radius must be at least twice the nut length. The straight segment of the tube up to $2 \times H$ must not be oval or tapered.