



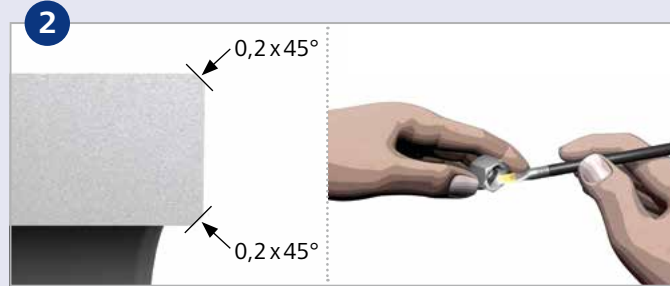
## Make better connections!

### Assembly instructions for stainless steel cutting ring

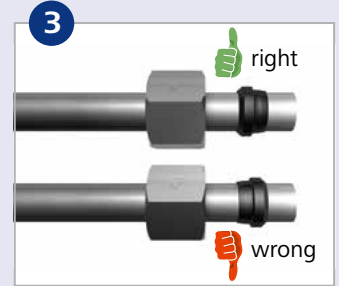
Pre-assembly with VOMO (hardened tool)



**1. Saw the tube off square.**  
An angular deviation of 0,5° relative to the tube axis is permissible.  
**Please note!!!** Do not use pipe cutters. Use reinforcing sleeve with thin wall tubes.



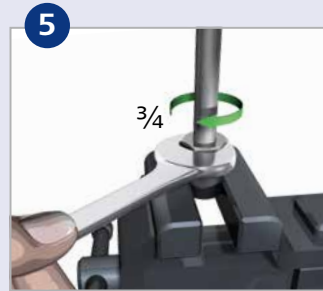
**2. Lightly deburr the tube ends and clean thoroughly.**  
The tube end within the assembly length must be free from swarf, dirt and paint.  
• Lightly grease the thread of the system nut and the thread and cone of the fitting with e.g. Volz-Fettpaste 325.  
• We strongly recommend using our new coated system nut "Low Friction"



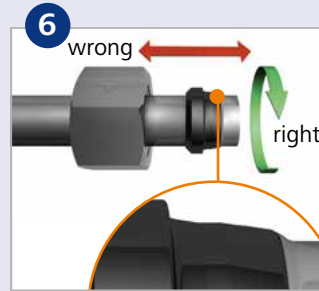
**3. Assembly of cutting ring**  
Place nut and cutting ring on tube as shown.  
**Please note!!!** Ensure that the cutting ring edge is facing the tube end.



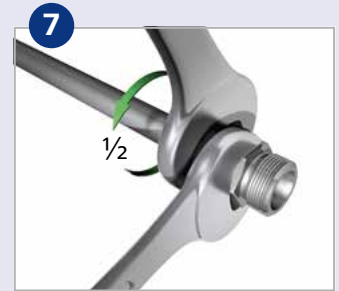
**4. Pre-assembly**  
Push pipe completely into the connector. Tighten nut until the ring makes contact with the tube surface – this point can be felt by an increase in torque.



**5. Pre-tighten**  
After the ring has contacted the tube, turn the nut another 3/4 turn.



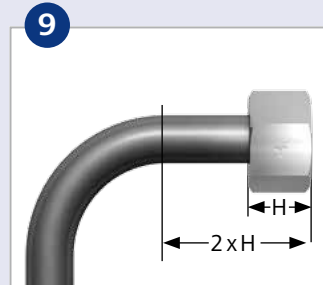
**6. Control**  
Check penetration of cutting edge. A visible ring of material should fill the space in front of the cutting ring end face. Cutting ring may turn on tube but should not be capable of moving in an axial direction.



**7. Final assembly**  
Screw the nut on until a definite increase in torque is felt. Hold fitting body firmly and turn the nut another 1/2 turn.  
**Please note!!!** Deviating from the number of turns of the nut reduces the nominal pressure and the service life of the connection.



**8. 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. Threads must be lubricated. Recommended to use spanner extension.



**9. 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 x H must not be oval or tapered.