

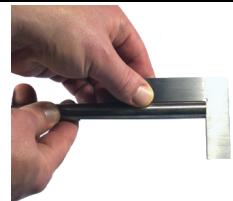
assembly instruction for cutting ring couplings according to DIN 2353 and DIN EN ISO 8434-1

1 general

- 1.1 For pipes with a small pipe wall thickness (in relation to the pipe diameter), pipe constriction can occur during installation, which in turn can lead to leakage. As a rule, the pipe constriction should not exceed 0.3mm up to an outer pipe diameter of 16mm and 0.4mm for pipes larger than 18mm. To prevent major pipe constrictions, use appropriate reinforcement sleeves.
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2 Mounting in the screwed connection piece

- 2.1 The pipe is cut off at right angles. Use a pipe saw jig for the cleanest possible cut. An angle tolerance of more than 0.5° is not permissible. Any deviations at the pipe end impair the function of the connection. Deburr the cut edges inside and outside. Carefully remove any chips and dirt that may be present.

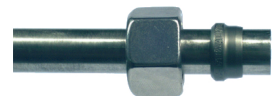


Note: Do not use a pipe cutter or grinder.

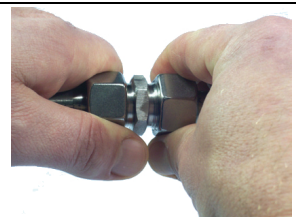
- 2.2 Lubricate the thread and the cone of the screw connection as well as the thread of the union nut.



- 2.3 First push the union nut and then the cutting ring onto the pipe, with the cutting edge pointing towards the end of the pipe.



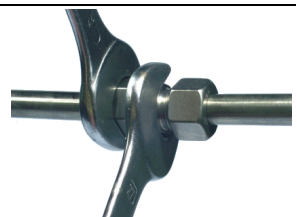
- 2.4 Guide the pipe to the stop of the fitting and tighten the union nut by hand. Press the tube against the fitting. Note: The tube must be in contact with the stop of the fitting, otherwise the tube will not be cut properly.



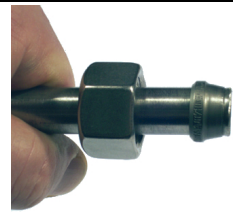
- 2.5 A marking line on the tube and nut makes it easier to keep track of the tightening distance already made when tightening.



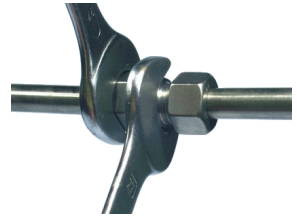
- 2.6 Tighten the union nut with the spanner by approx. $1\frac{1}{2}$ turns and hold the screw connection piece with a spanner. Note: A deviating tightening path reduces the pressure load capacity of the connection and leads to leaks.



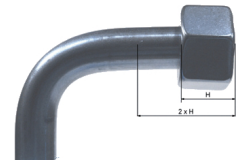
- 2.7 The connection must be loosened again in order to check that it has been properly mounted. The face of the cutting ring must be visibly filled with thrown-up material (collar throw-up).
Note: The cutting ring must be able to rotate on the tube.



- 2.8 After the check has been carried out with a positive result, the connection must be mounted again. For this purpose, max. ¼ turn is required for final assembly after hand-tight resistance.

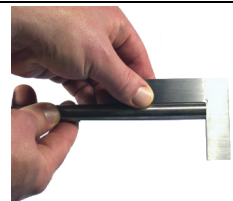


- 2.9 When mounting on pipe bends, the length of the pipe from the end of the pipe to the beginning of the bend must be at least twice the height of the union nut. The straight pipe end must not have any deviations in this area that exceed the dimensional tolerance of the pipe according to DIN 2391-1.

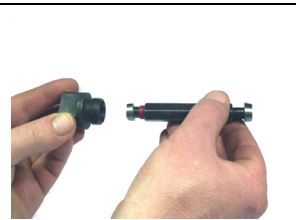


3 Pre-assembly in pre-assembly spigot, final assembly in screwed spigot

- 3.1 The pipe is cut off at right angles. An angle tolerance of more than 0.5° is not permissible. Any deviations at the pipe end impair the function of the connection. Deburr the cut edges inside and outside. Carefully remove any chips and dirt that may be present.
Note: Do not use a pipe cutter or grinder.



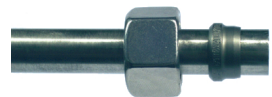
- 3.2 The cone of the pre-assembly connecting piece should be checked after every 50 assemblies using a cone gauge. After inserting the gauge into the cone, the upper edge of the gauge should be flush with the upper edge of the pre-assembly connecting piece or protrude slightly.



- 3.3 Grease the thread and the cone of the pre-assembly connecting piece as well as the thread of the union nut.



- 3.4 First push the union nut and then the cutting ring onto the pipe, with the cutting edge pointing towards the end of the pipe.



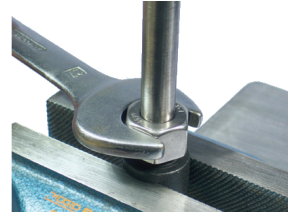
- 3.5 Guide the pipe to the stop of the pre-assembly fitting and tighten the union nut by hand. Press the pipe against the pre-assembly connecting piece.
Note: The pipe must be in contact with the stop of the pre-assembly spigot, otherwise the pipe will not be cut properly.
Then tighten further with a spanner until you can no longer twist the pipe by hand.



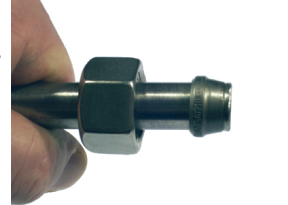
- 3.6 A marking line on the tube and nut makes it easier to keep track of the tightening distance when tightening.



- 3.7 Tighten the union nut with a spanner by approx. 3/4 of a turn. Note: A deviating tightening path reduces the pressure load capacity of the connection and leads to leaks.



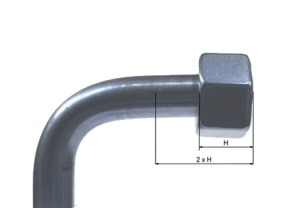
- 3.8 The connection must be loosened again in order to check that it has been assembled correctly. The face of the cutting ring must be visibly filled up to 80% by thrown-up material (collar throw-up). Note: The cutting ring must be able to rotate on the tube.



- 3.9 For the final assembly in the union connection, the union nut is screwed tight by hand until the union connection, cutting ring and union nut are felt to be in contact. Then tighten the union nut with a spanner approx. 1/4 turn beyond the point of the noticeable increase in force, while holding the screw connection piece with another spanner. Note: A deviating tightening path reduces the pressure load capacity of the connection and leads to leaks.



- 3.10 When mounting on pipe bends, the length of the pipe from the end of the pipe to the beginning of the bend must be at least twice the height of the union nut. The straight pipe end must not have any deviations in this area that exceed the dimensional tolerance of the pipe according to DIN 2391-1.



4 Finished assembly of factory pre-assembled screwed connections

- 4.1 Grease the thread of the union nut, cutting ring and thread of the screwed connection piece and tighten by hand until the screwed connection piece, cutting ring and union nut come to a tangible stop. Tighten the union nut approx. 1/4 turn beyond the noticeable increase in force, while holding the screwed connection piece with a spanner. Note: A deviating tightening value reduces the pressure load capacity of the connection and leads to leakage.



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