



6.1 General instructions for installing the pipe

- ▶ The pipes must be transported and stored with care in the original manufacturer's packing.
- ▶ When opening the coils take care not to damage the pipe (do not use sharp objects).
- ▶ The unrolling of the coils must take place in the opposite direction to rolling up, so starting with the pipe end on the outside of the reel.
- ▶ Do not use any pieces with folds, kinks or damage.
- ▶ The pipes must always be laid without twists.
- ▶ The pipes must be protected against any distortion, soiling and/or damage.
- ▶ The pipes must be installed using Henco tools.
- ▶ The pipes must be **cut square**, and the ends of the pipe must always be **calibrated** and **deburred** according to the specified instructions.
- ▶ Pipe bends can be formed by hand, but to achieve bends with a minimum radius an internal or external bending spring must be used.
- ▶ If brass fittings are used, these must be provided with a synthetic ring at the end of the insert sleeve to prevent any electrolysis between the aluminium and the brass.
- ▶ The bare pipe may not come into contact with sharp objects during and after laying. For example, piping running through ceiling holes may not be bent around sharp edges as there is a danger of kinking.
- ▶ If further bending of the pipes are required after installation of fittings, it is recommended that the pipe be retained by hand at the connection.
- ▶ After laying, the pipes must be protected against damage by other work taking place on the site. To ensure this the pipes best are provided with a protective sleeve or insulation available from the manufacturer.
- ▶ With building in, bare pipes may be used if insulated expansion bends are provided at least every 10 m. It is nevertheless advised to always provide the pipes with a sleeve or insulation from the manufacturer.
- ▶ When surface mounting, pipe brackets, expansion bends and expansion loops must be used as specified by the manufacturer.



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