

6 ASSEMBLY INSTRUCTIONS

6.3 Making a screwed connection

6.3.1 Step by step



When opening the coil never cut into the packing paper with a sharp object.



Always cut the pipe 90° square. For all diameters, and in particular Ø26 and greater, use of the RS32 or RS63 pipe cutter is recommended.



Calibrate the pipe with the Henco kalispeed. Slide the calibrator right into the pipe and then rotate it so that the cutter forms a continuous bevel to both the inner and outer edge of the pipe. Remove all swarth.



Slide the nut and the split olive over the pipe.



Insert the adaptor or socket in the pipe and push to the end. Make sure a synthetic ring is always fitted to prevent electrolysis. To facilitate sliding you can lubricate the nut with silicone oil. Do not use mineral oil!



Now turn the nut on the nipple, tap or collector until the force recommended by the manufacturer is reached. Always do this using two flat open jawed spanners.



Specified force for making a screw coupling		
Pipe type	Number of turns after tightening finger-tight	Corresponding turning torque in Nm
14x2	1	45
16x2	1	50
18x2	1	55
20x2	1	60
26x3	1/2	65

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