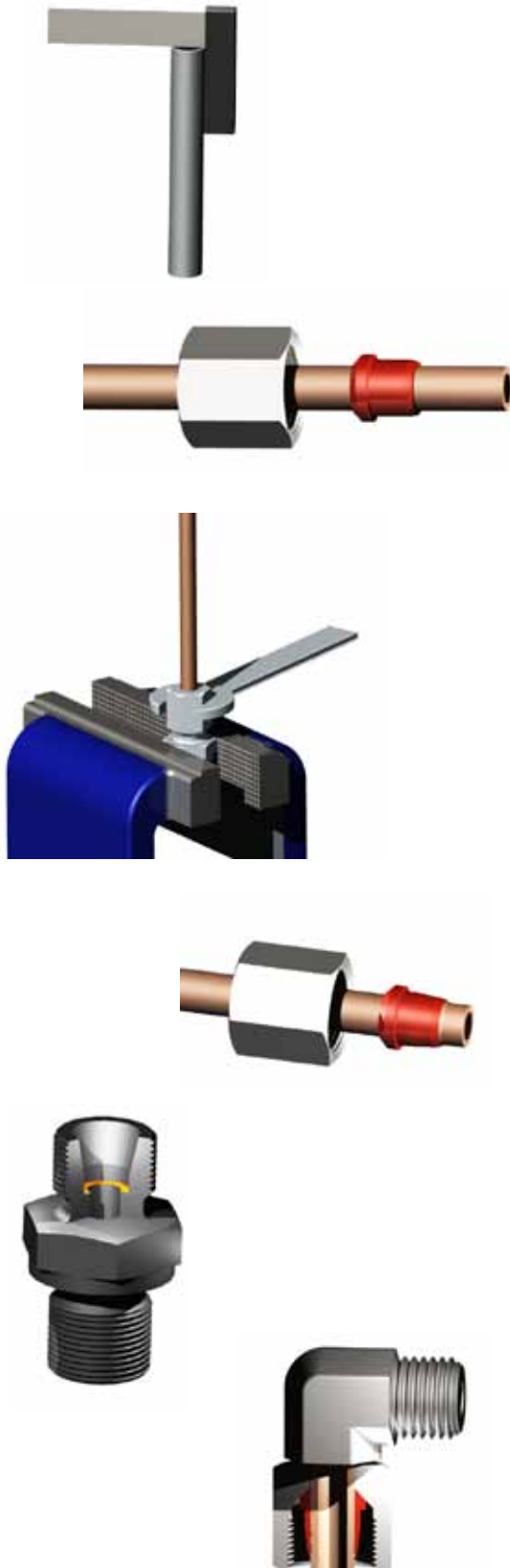




## ASSEMBLY INSTRUCTIONS



1. Cut the tube at a 90 degree angle (do not use roller, type tube cutters), remove all internal and external burrs.
  2. Oil the 24° cone, the thread of the fitting body, the cutting ring and the nut.
    - a. For carbon steel fittings, use mineral oil.
    - b. For stainless steel fittings, use a special high-performance lubricant.
  3. Fit the nut and the cutting ring on the tubes as shown. The larger diameter of the cutting ring must face the nut.
  4. Insert the tube on the 24° cone until it comes into contact with the stop. Tighten the nut by hand until the cutting ring rest firmly on the nut. Then tighten the nut with a wrench until the cutting edge of the ring is in contact with the tube and prevents rotation if this.
  5. Holding the tube against its stop and making sure it does not rotate, tighten the nut by  $\frac{3}{4}$  of a turn. This way, the cutting ring cut into the outer part of the tube for the necessary depth and raises an edge in front of its cutting edge while the second cutting edge clinches the tube at the same time.
  6. Loosen the nut and check that there is a clearly raised edge all round the tube. The edge must cover 80% of the front of the cutting ring. This check is peremptory for the safety of all concerned!! If the raised edge is not satisfactory, pre-assembly must be repeated. The cutting ring can rotate on the tube.
  7. Reassemble the nut on the fitting until a certain resistance is encountered and then tighten for a further  $\frac{1}{4}$  turn.
- A. Final installation of works pre-installed fittings: Screw the nut by hand as hard as you can, then the nut should be tightened approximately  $\frac{1}{2}$ – $\frac{3}{4}$  turn more. This information apply to all our pre-installed fittings.
- B. All the pre-assembly of stainless steel fittings must be performed with a pre-assembly tool (blocks or machines).