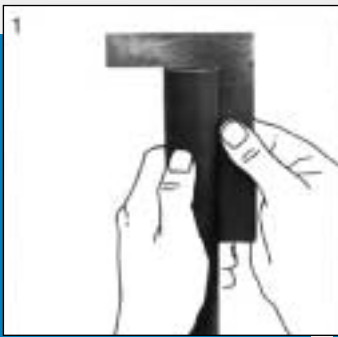
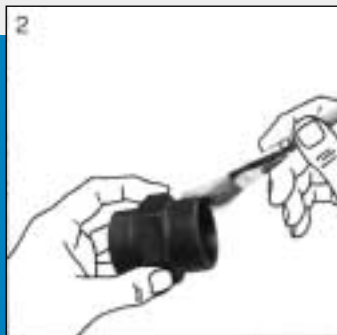
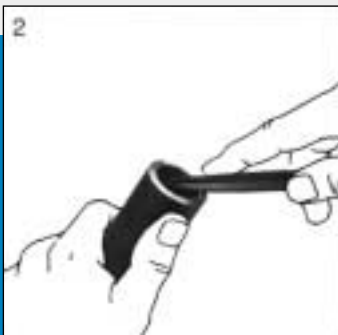


Assembly Instructions for DIN Tube Couplings with Cutting Ring.



Preparations

1. Saw off the tube square. Do not use roll cutters, as they will reduce the tube cross-section and will generate extensive burr. When determining the tube length, the depth of the cone has to be added.



2. Deburr slightly the ends of the metal tube inside and outside (do not point), and then remove dirt and chips. Oil coupling thread, body cone and outside cone of cutting ring lightly.

Pre-Assembly in the coupling body

3. Place the nut and the cutting ring on the tube. The cutting edge of the cutting ring faces the tube end.
4. Clamp the coupling body in a vice. Press tube against the stop in the coupling body and tighten nut as much as possible by hand. The ring will now be firmly gripped between tube, nut and inner cone.

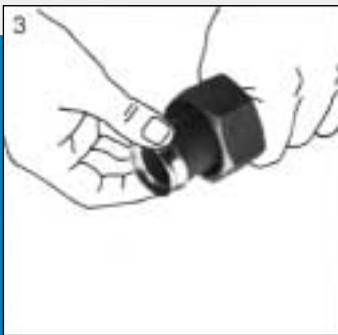
After tightening by hand, tighten nut with a spanner (if necessary provided with a tube extension).

– up to tube O.D. 18 mm approx. 1-1/2 turns

– above tube O.D. 20 mm approx. 1-1/4 turns

A mark facilitates the observation of the prescribed number of turns.

The ring will cut during assembly into the tube causing a clearly visible wall of metal ahead of it.



DIN Metric Fittings

5/6. Loosen nut and inspect cut. The wall of metal should cover approx. 80%-90% of the ring face thickness. It is possible to rotate the cutting ring in this position.



Final Assembly

7. For final installation take the pre-assembled tube always with the coupling, in which it has been pre-assembled. Then, tighten the nut with the spanner, until a clear increase of force results. For final tightening, continue to tighten by another 1/4 turn. If possible, counter-hold the coupling by means of a spanner during final assembly.



Repeated Assemblies

In case a coupling shall be loosened and then be reassembled, again the nut has to be tightened, until a clear increase of force results.

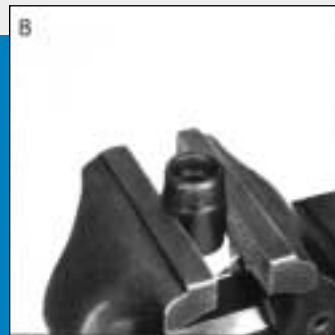
Repeated assemblies can be performed as frequently as desired on the tube connection.

Please request our Assembly Poster for your workshop.

Quantity-Production Assemblies

If larger quantities of tubes have to be assembled, we recommend the utilization of:

8. DIN Manual Pre-Assembly Tools for vice assembly. The assembly procedure is the same as described under items 4-6. The manual pre-assembly tools are hardened and are toleranced within the optimum range so that efficient tube connections are always achieved.



9. DIN Pre-Assembly Device for electrical drive (400 volts). Detailed assembly instructions are available upon request.