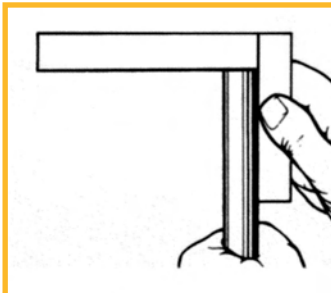


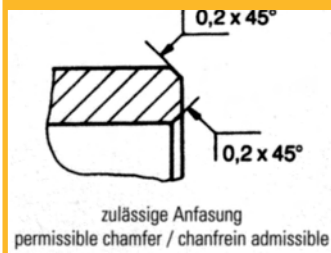
ASSEMBLY INSTRUCTIONS .. 1

PROFILE RING AND DIN 2353 CONNECTORS



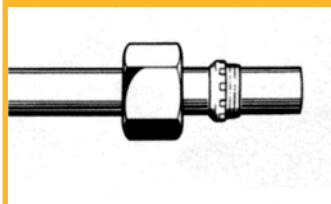
1. Saw Cut at right angle!

Remove 10mm from the manufacturers cut end (to eliminate delivery related faults)
Saw the tube at right angles $\pm 1/2^\circ$. DO NOT use pipe cutters. Use a saw or sawing machine.

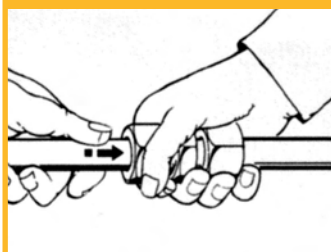


2. Lightly deburr the tube ends and clean the tube!

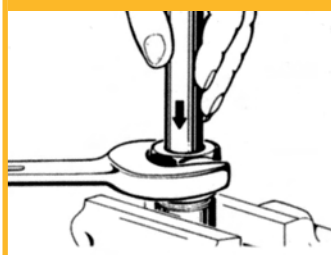
Remove burr and clean inside and outside. The clamping and reshaping area should be free from scratches, dirt, grease, oil and paint.
use an environmentally friendly solvent to remove grease or oil.



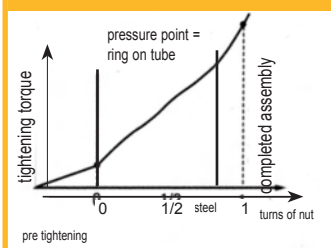
3. Place nut and profile ring on tube as shown!



4. Press the tube into fitting body up to tube abutment. Tighten nut by hand.



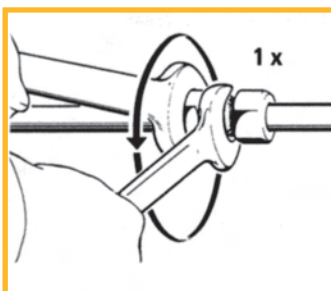
4.1 In difficult installation circumstances or with large diameter tubes, the appropriate fitting body must be fixed in a vice.



5. Tighten the nut until the Profile ring grips the tube which is felt by a noticeable increase in torque (pressure point).

ASSEMBLY INSTRUCTIONS .. 2

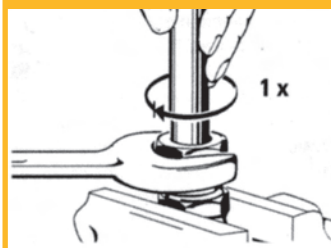
PROFILE RING AND DIN 2353 CONNECTORS



6 Final assembly by 1 turn

Important:

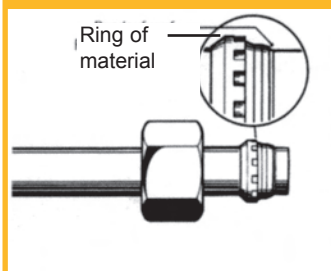
Hold fitting body firmly by means of a spanner



6.1 Note

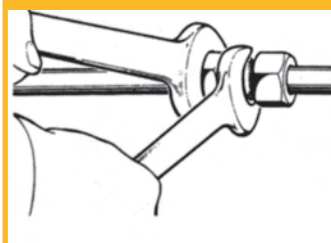
In difficult installation circumstances or with large diameter tubes, the final assembly must be carried out in a vice with the fitting body that is to be used.

CAUTION! Incorrect amount of tightening turns will directly affect the pressure rating and performance.



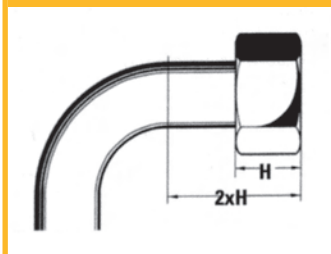
7 Check

Check penetration of cutting edge. A ring of material must be visible in front of the profile ring's cutting edge. Profile ring may turn on the tube, but not be capable of axial movement.



8. Re assembly

Each time the fitting is re assembled, the nut must be re tightened firmly, using the same torque as required for final assembly.



9. Minimum length of straight tube

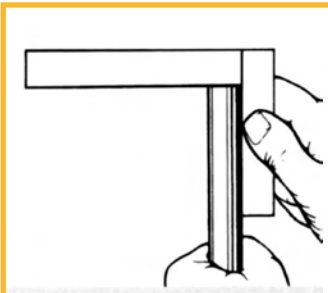
For tube bends, the length of the straight tube end up to the start of the bending radius must be at least twice the nut length.



The leaks stop here!

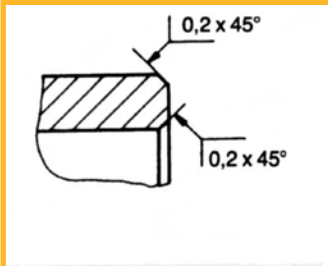
ASSEMBLY INSTRUCTIONS .. 1

FOR USE WITH PRE ASSEMBLY ADAPTOR | STEEL AND STAINLESS STEEL



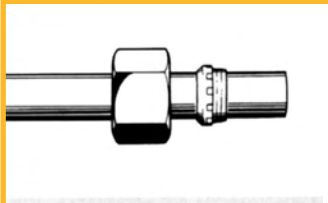
1. Saw Cut at right angle!

Remove 10mm from the manufacturers cut end (to eliminate delivery related faults)
Saw the tube at right angles $\pm 1/2^\circ$. DO NOT use pipe cutters. Use a saw or sawing machine.



2. Lightly deburr the tube ends and clean the tube!

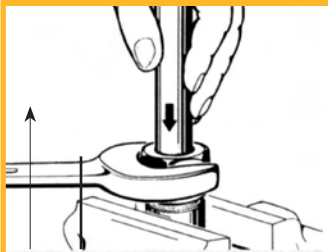
Remove burr and clean inside and outside. The clamping and reshaping area should be free from scratches, dirt, grease, oil and paint. use an environmentally friendly solvent to remove grease or oil.



3. Note

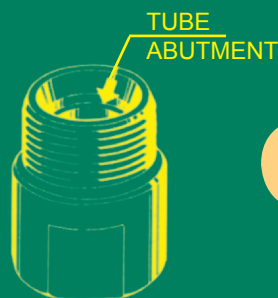
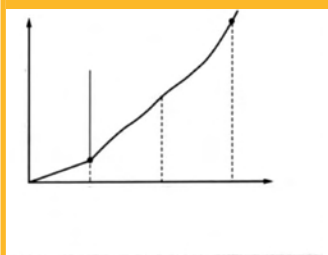
Prior to assembly all stainless steel (1.4571) joint components must be prepared with ABF anti seize grease.

4. Place nut and profile ring on tube as shown

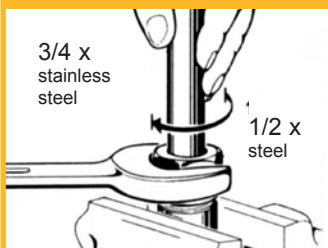


5. Pre Tightening

Hold the tube firmly against the abutment in the pre assembly adaptor and tighten nut until the profile ring grips the tube which is felt by a noticeable increase in torque (The pressure Point).



PRE ASSEMBLY ADAPTORS seeconnector section

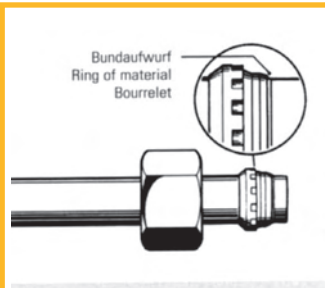


5.1 Pre assembly

For steel fittings tighten nut 1/2 turn, for stainless fittings (1.4571) tighten nut 3/4 turn beyond the pressure point.
CAUTION! Incorrect amount of tightening turns will directly affect the pressure rating and performance.

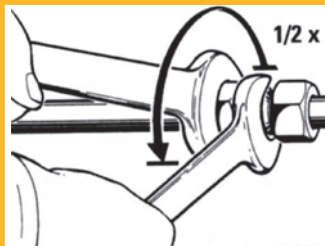
ASSEMBLY INSTRUCTIONS .. 2

FOR USE WITH PRE ASSEMBLY ADAPTOR | STEEL AND STAINLESS STEEL



5.2 Check!

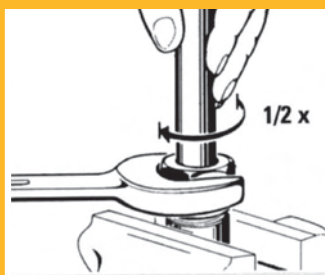
Check penetration of cutting edge. A ring of material must be visible in front of the profile ring's cutting edge. Profile ring may turn on the tube, but not be capable of axial movement.



6. Final assembly in the fitting body

Tighten nut until a noticeable increase in force is required. Tighten nut by 1/2 turn beyond this point to reach final assembly. Important: Hold fitting body firmly by means of a spanner.

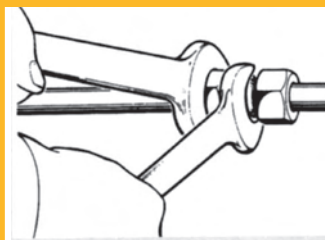
Note: Prior to assembly all stainless (1.4571) joint components must be greased with ABF anti seize grease.



6.1 Note

In difficult installation circumstances or with large diameter tubes, the final assembly must be carried out in a vice with the fitting body that is to be used.

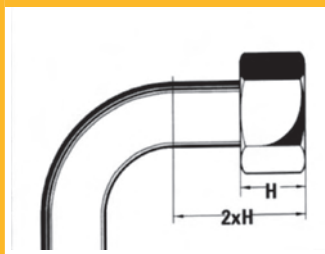
CAUTION! Incorrect amount of tightening turns will directly affect the pressure rating and performance.



7. Re assembly

Each time the fitting is re assembled, the nut must be re tightened firmly, using the same torque as required for final assembly.

Note: Prior to assembly all stainless (1.4571) joint components must be greased with ABF anti seize grease.



8. Minimum length of straight tube

For tube bends, the length of the straight tube end up to the start of the bending radius must be at least twice the nut length.



The leaks stop here!