

## ASSEMBLY INSTRUCTION DS AND S CUTTING RING

### Direct assembly in the tube fitting

Pipes made from rustproof steel must be mounted in pre-assembly connecting pieces [VM] or by means of assembly devices. The use of EMB lubricant paste is mandatory in any case.

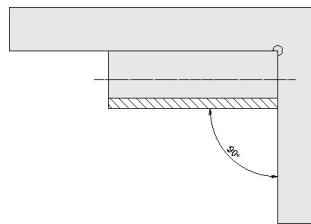
#### 1. Minimum dim. H+L

Series	LL				L										S									
	4	5	6	8	6	8	10	12	15	18	22	28	35	42	6	8	10	12	16	20	25	30	38	
Tube OD	4	5	6	8	6	8	10	12	15	18	22	28	35	42	6	8	10	12	16	20	25	30	38	
H min.	24	25	25	26	31	31	33	33	36	38	42	42	48	48	35	35	37	37	43	50	54	58	65	
L min.	30	32	32	33	39	39	42	42	45	48	53	53	60	60	44	44	47	47	54	63	68	73	82	

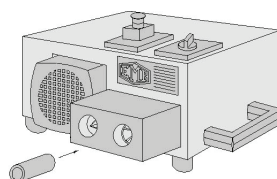
#### 2. Saw off the tube to be laid at a right angle.



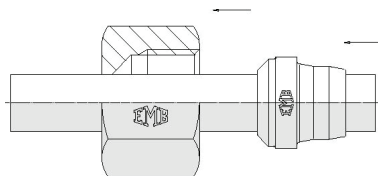
Do not use a tube cutter!



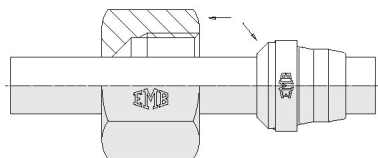
#### 3. Deburr the pipe inside and outside, for example using the EMB OPTIGRAT 642.



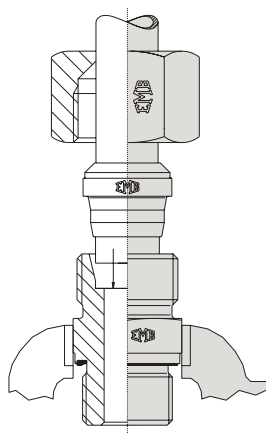
4. Push the screw connection parts over the end of tube as illustrated.



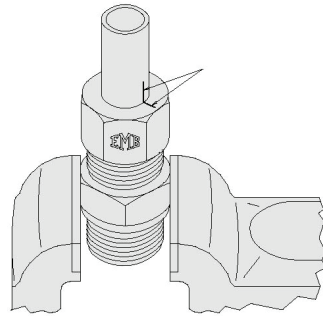
5. The shoulder of the cutting ring must be facing the union nut.



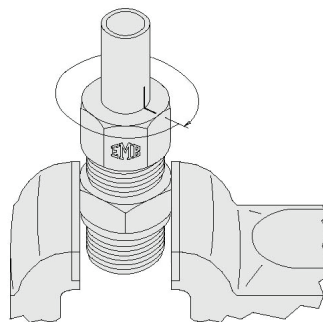
6. Insert the pipe in screw sockets and push firmly into position in the interior cone.



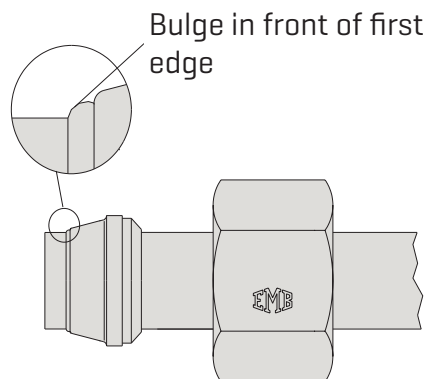
7. Then tighten the union nut until the tube cannot be turned anymore in the screw connection – the cutting ring is clamped onto the tube.



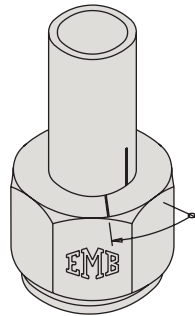
8. A marking applied to the union nut with a pen makes it easier to determine whether the prescribed turn has been carried out.



9. Now tighten the union nut 1 turn, the EMB cutting ring hereby cuts evenly into the tube and forms a visible material throw-up before its edge.



10. After it has been tightened, loosen the connection again; check whether the space before the edge is filled out. The ring may turn.



11. After loosening the connection, the union nut must once again be tightened until there is a noticeable increase in force [pressure point]. Afterwards, screw in  $30^{\circ}$  -  $60^{\circ}$  using a suitable wrench.

#### Tube quality

We recommend the use of seamless precision steel tube with dimensions in accordance with DIN EN ISO 10305 Part 4, Material: E235, NBK.

Tubes made from rust and acid-proof material must be seamlessly cold-drawn, scale-free and heat-treated in accordance with DIN EN 10216-5 - X6 CrNiMoTi17-12-2-CFD and exhibit tolerances in accordance with DIN EN ISO 10305-1.