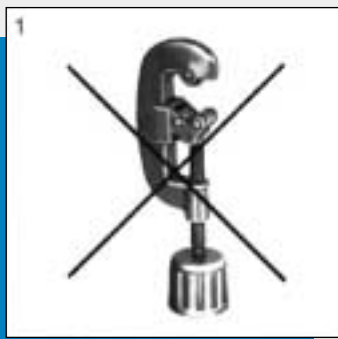
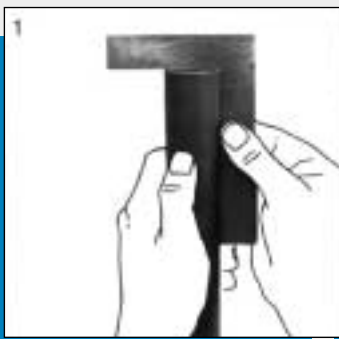
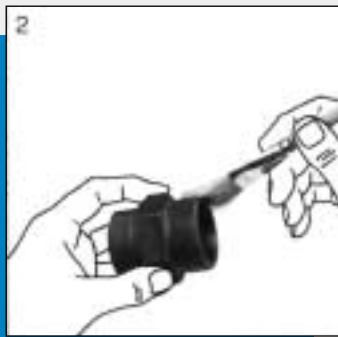
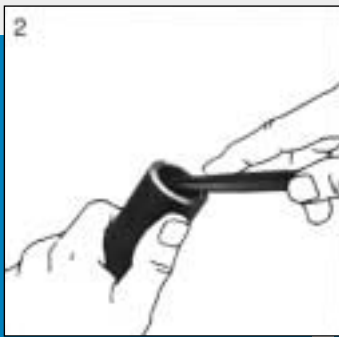


Assembly Instructions for DIN Tube Couplings with Cutting Ring.



Preparations

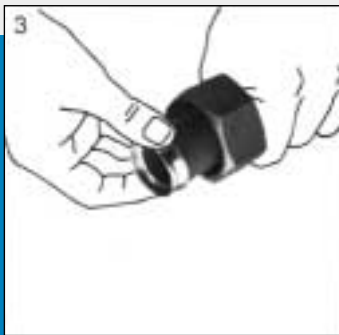
1. Saw off the tube square. Do not use roll cutters, as they will reduce the tube cross-section and will generate extensive burr. When determining the tube length, the depth of the cone has to be added.



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.