

INSTRUCTION

ISO pipe fitting instruction for assembly and dismantling



ASSEMBLY

1 Safety warning: Do not look directly at the pipe end.

2 Pipe cutter No. 6050

3 Chamfering tool No. 6000

4 Support liner No. 6031 for zero pressure and low pressure pipelines. Don't chamfer the pipe

5 Grip ring No. 6932 for PE pipes acc. to EN 12201-2
Grip ring No. 6931 for PVC pipes

6 Grip ring No. 6932 for PE pipes acc. to EN 12201-2
Grip ring No. 6931 for PVC pipes

7 **NO OIL !**
Moisten with water or lubricants (see M 7/2)

8 O-ring No. 6940

9 Assembly

10 Assembly

11 **PRESSURE TEST** on installed line and exposed, unfilled connections

DISMANTLING

1 Extractors No. 6010

2 Grip ring No. 6932 for PE pipes acc. to EN 12201-2
Grip ring No. 6931 for PVC pipes

3 O-ring No. 6940

4 Grip ring No. 6932 for PE pipes acc. to EN 12201-2
Grip ring No. 6931 for PVC pipes

5 **Assembly**

Max. torque for tightening the threads (observe pipe fitter rules acc. to national standards):

1/2"	3/4"	1"	1 1/4"	1 1/2"	2"
20 Nm	25 Nm	40 Nm	42 Nm	42 Nm	45 Nm

K 3/2



E. Hawle Armaturenwerke GmbH 4840 Vöcklabruck - Austria - Wagrainstraße 13
Tel.: +43 (0) 7672 72576 0 - Fax: +43 (0) 7672 78464 - E-Mail: hawle@hawle.at - www.hawle.com