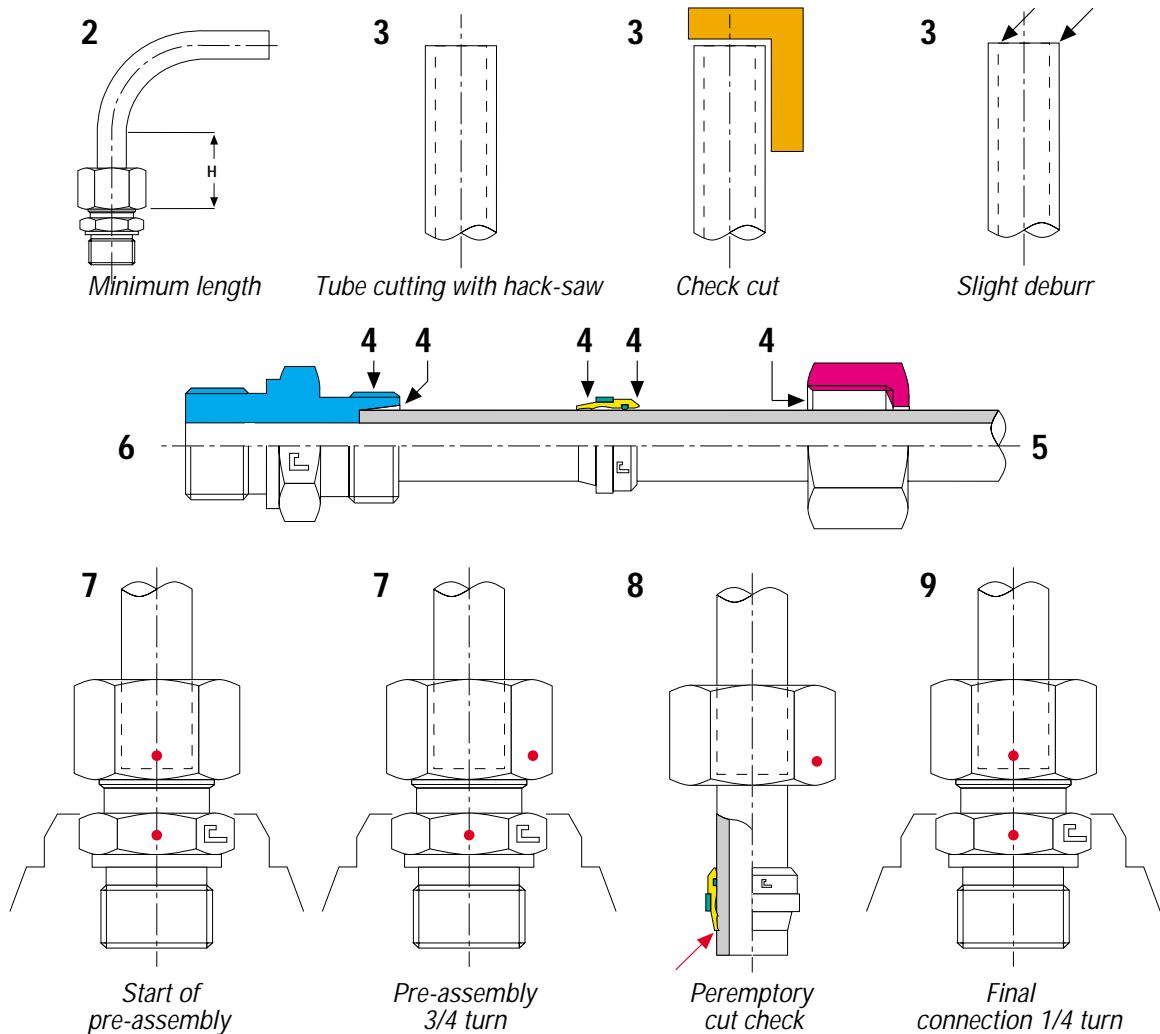


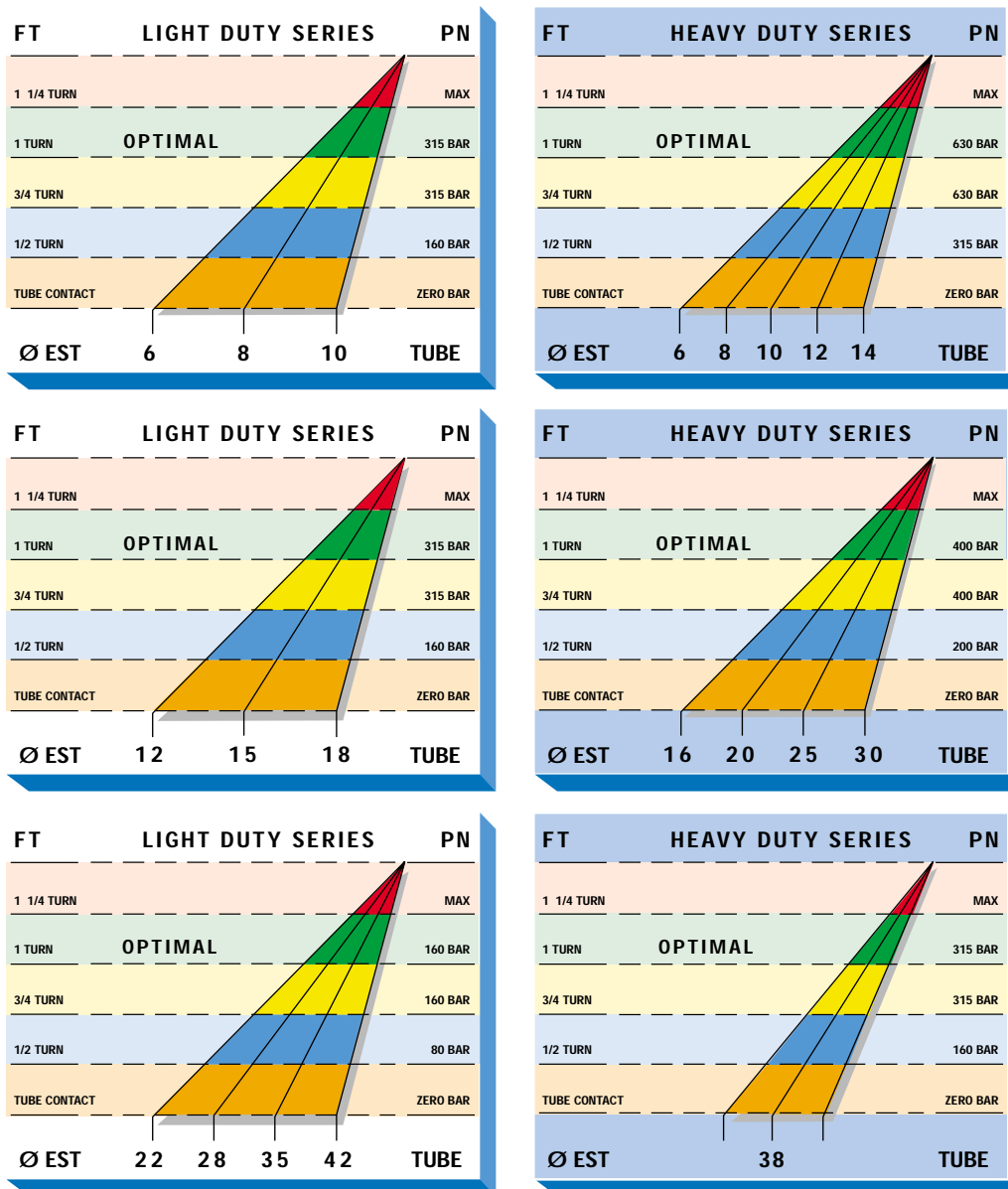
ASSEMBLY INSTRUCTIONS ACCORDING TO DIN 3859-2 FOR B3 - B4

1. Before pre-assembly, make sure that all the tools to be used are in perfect working order. Replace any inefficient tools.
2. The segment of tube to be pre-assembled must have a straight section at least twice the length of the nut (length H). Roundness must comply with DIN 2391.
3. Cut the tube square by using an appropriate hack-saw (do not use roller type tube cutters). Check that the cut is properly made at 90°. Remove any internal and external burrs.
4. Oil the 24° cone, the thread of the body, the cutting ring and the nut with suitable products. = →
5. Fit the nut and the cutting ring on the tube as shown. The larger diameter of the cutting ring must face the nut.
6. Insert the tube on the 24° cone until it comes into contact with the stop. Tighten the nut by hand until the cutting ring rests firmly on the nut. Then tighten the nut with a wrench until the cutting edge of the ring is in contact with the tube and prevents rotation of this.
7. Holding the tube against its stop and making it sure it does not rotate, tighten the nut by 3/4 of a turn. This way, the cutting edge of the nut cuts into the outer part of the tube for the necessary depth and raises an edge in front of its cutting edge while the second cutting edge clinches the tube at the same time.
8. Loosen the nut and check that there is a clearly raised edge all round the tube. The edge must cover 80% of the front of the cutting ring. This check is peremptory for the safety of all concerned!!! If the raised edge is not satisfactory, pre-assembly must be repeated.
9. If pre-assembly has been carried out correctly, fit the tube on the machine, close with a wrench until a certain resistance is encountered and then tighten for a further 1/4 turn with wrench to wrench contrast.
10. All the pre-assembly of stainless steel fittings must be performed with pre-assembly tool (blocks or machines).



The assembly of B3 and B4 rings must be done with the same procedures and tools. The two rings are completely interchangeable with Italian and foreign products under the same norm. Assembly of the system may be repeated without damage to the parts involved.

OPERATING PRESSURES - TORQUE DIAGRAM - TWISTING FACTOR



- 1) Assembly on the fitting according to DIN 3859 P.II P.3.4 1 1/2 turn from blocking by hand.
- 2) Assembly on the hardened block according to DIN 3859 P.II P.4.5 1 1/4 turn from blocking by hand.
- 3) CAST assembly instructions respect in full the above norm as 1/2 turn is used for the clearances recuperation and from 3/4 to 1 turn for the tightening of the tube.

- Area not to be used.
- Final tightening area.
- Pre-assembly area.
- Tightening start area.
- Clearances recuperation area.