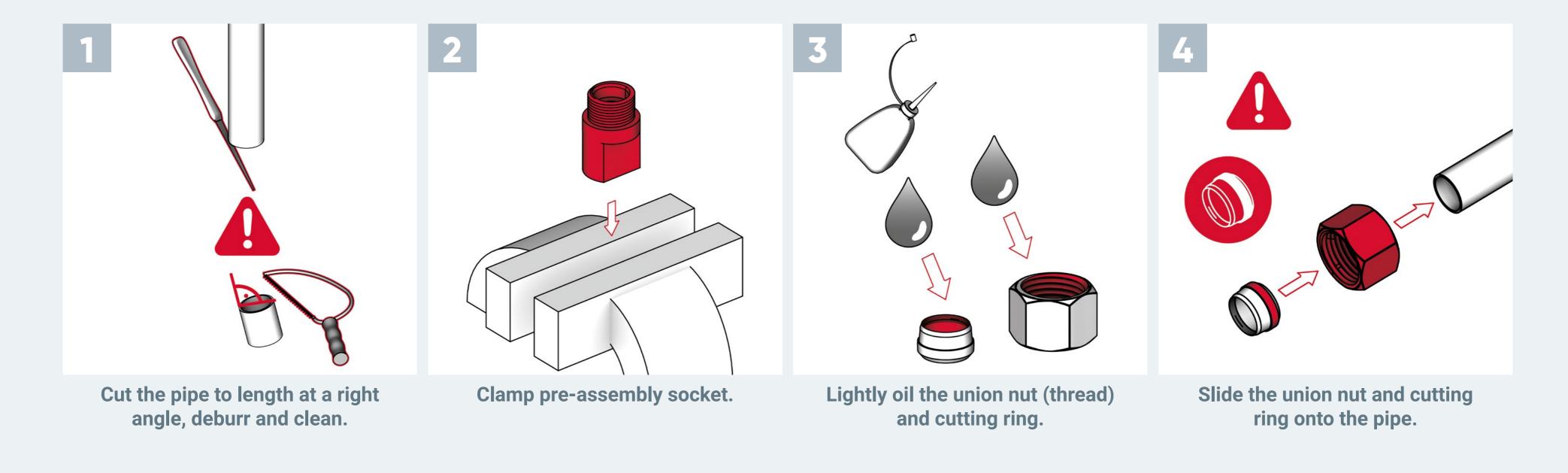
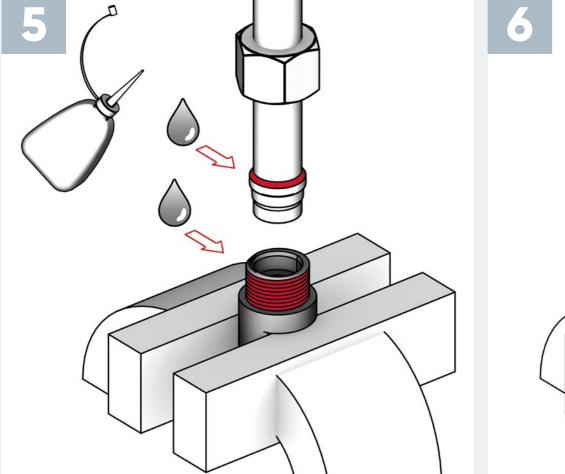
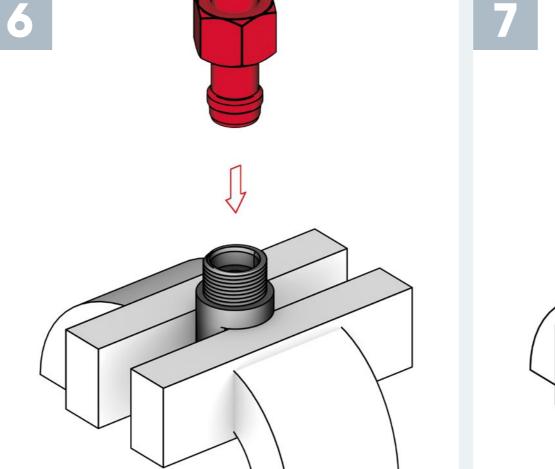


Instructions for assembling a HANSA-FLEX cutting ring screw connection in steel

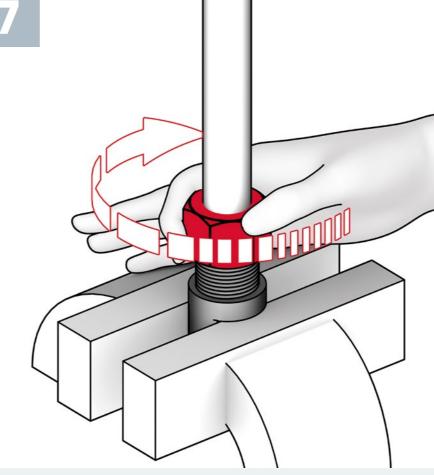




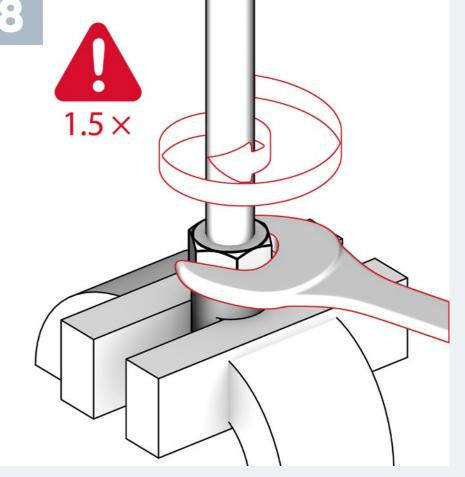
Lightly oil the pre-assembly socket and cutting ring edge.



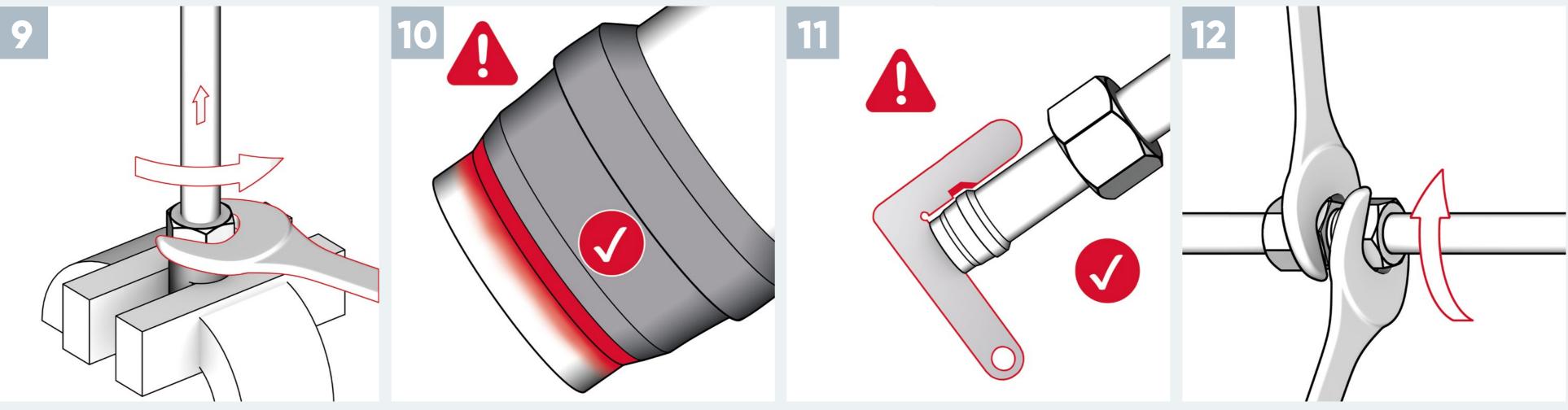
Push the pipe into the pre-assembly socket as far as it will go.



Tighten the union nut until the force required to turn it increases noticeably.



Tighten union nut 1.5 turns (complete assembly).



Release union nut, remove pipe.

Check cutting ring for correct seating and shoulder height (approx. 80 % of the front cutting edge covered).

Check cutting ring for correct seating using the cutting ring gauge (SRD-LEHRE).

Repeat assembly with ¼ turn after noticeable increase in force.



Assembly of a stainless steel cutting ring fitting deviates.

You can find more technical information at www.hansa-flex.com/technical-information

CUTTING RING ASSEMBLY

www.hansa-flex.com/technical-information