

Dn 110 – Dn 160 FITTING ASSEMBLING INSTRUCTIONS

EQO *air* - EQO *h2o* - EQO *nitro* - EQO *gas* - EQO *vac* - EQO *airHP* - EQO *oiHP* - EQO *nitroHP*

1. Needed tools and materials

1.1. Tools for pipe cutting :

Mitre saw – band saw – hand saw – sabre saw



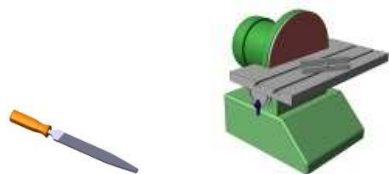
1.2 Tool for the internal deburring of the pipe :

Blade deburring tool



1.3 Tool for external bevelling of the pipe :

Bevelling machine – flat file – disk sander



1.4 Lubricant :

Vaseline grease – soapy water – oil (in case of EQOoil fittings)



1.5 Marker :

indelible pen or paint based marker

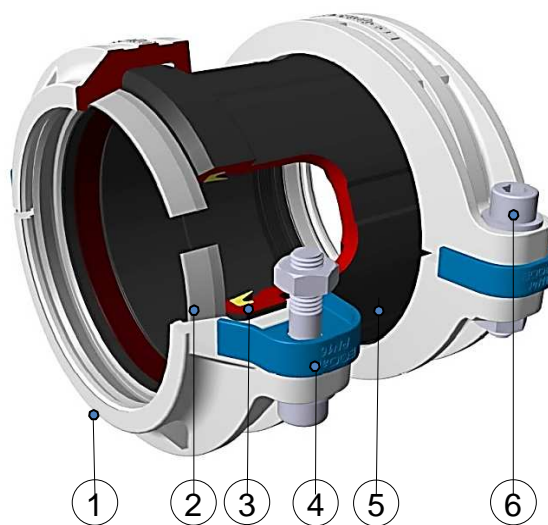


1.6 Wrenches:



17 mm (2x DN 160 and 140) 8 mm (Dn 110 only)

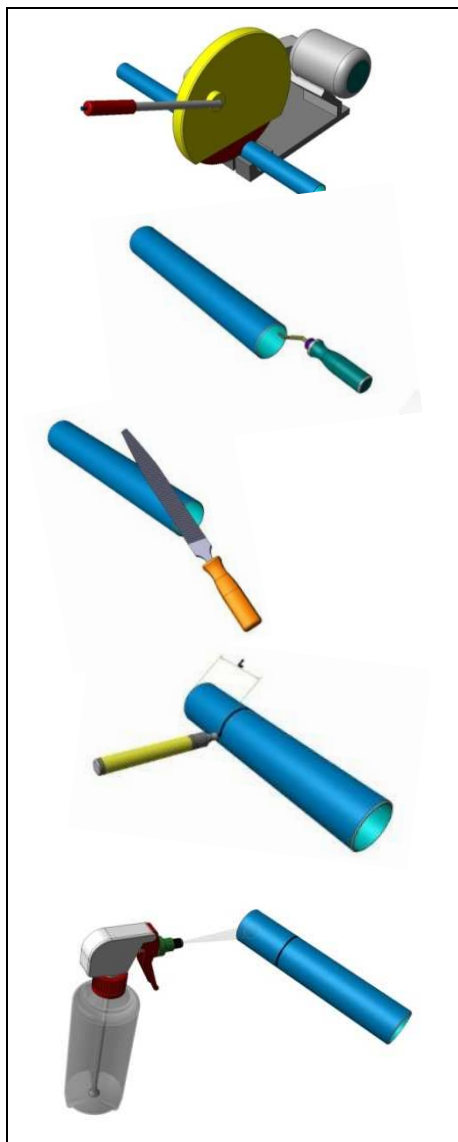
2. Assembly with correct component positioning



1. Half Blocking Ring
2. Clamping ring
3. Lip Seal
4. Identification Mark Holder (not always present)
5. Body
6. Bolts

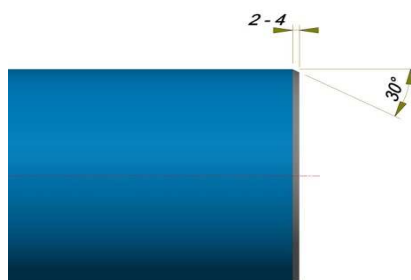
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3. Preparation

- 3.1 Verify the integrity of the pipe section to be inserted in the fitting.**
Any scratches on the paint, if not deep, can be eliminated using 300-600 fine emery paper. Deep dents or scratches can be eliminated only by changing the branch position or by replacing the pipe section interested.
- 3.2. Verify the correct positioning of the components inside the fitting.**
Fittings are supplied assembled and they have not to be disassembled. In case of accidental disassembly, check the correct assembly sequence and the position of all components which has to be the one of the ensemble figure at point 2 only.



The bolts has to be kept loose.

- 3.3. When necessary, cut the pipe with a neat 90° cut. Carefully deburring the internal and external sharp resulting edges and make an external sharp of 2÷4 mm length x 30° tapered.**
In any case, the pipe bars used in the original supply length are to be deburred internally and externally

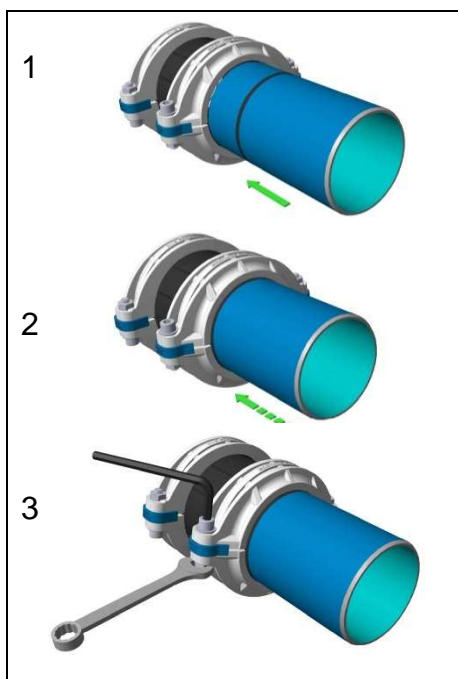
- 3.4. Mark the pipe so to have a reference for its correct insertion into the fitting to make sure it exceeds the gasket.**

The following table shows the correct reference lengths

Dn	110	140	160
L(mm)	55		134

- 3.5 Lubricate the marked pipe section.**
Use soapy water or any other lubricant compatible with the transported fluid.

In case of doubt, please contact our technical service : giacomo@eqofluids.com.



4. Assembling

- 4.1. Deeply insert the pipe into the fitting up to align the reference mark with the external nut surface, as showed in fig.1 and 2.**
- 4.2. Tighten all the bolts at a torque value of 15 N/m**

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Warnings and recommendations

Assembling instructions contain images only referring to the **EQO *air*** line, but they refer to all **EQO *fluids*®** products, only keeping in mind the following details :

- a. During the testing the applied pressure has to be at least 1,5 the value of the maximum service pressure. This has to be done in conditions of absolute safety for the staff and the equipments connected.
Said equipments, having, in case, lower pressures than the pipes testing one, (for instance, safety valves, pneumatic tools, etc.) have to be duly isolated or disconnected from the installation.
- b. After testing or after first putting under pressure, it is advisable to check and tighten all fitting bolts.
- c. If using a lubricant to help the pipe insertion, its compatibility with the transported fluid is to be carefully checked.

More technical information can be found on our website: www.eqofluids.com