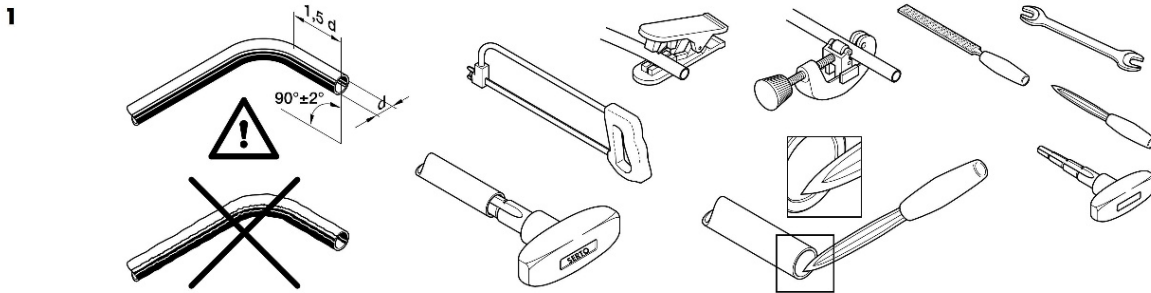


## Installation instructions for Serto-connections

Brass / Stainless Steel / Aluminum / Steel

### 1. Preparation

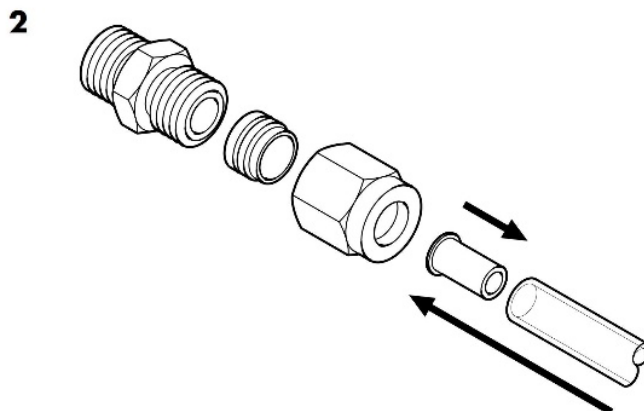
Cut the tube \* to length and deburr it. The tube must be straight and free from blemishes for approximately  $1.5 \times d$  from the end. The union is pre-lubricated. For easier assembly and re-assembly of bigger sized unions, it is recommended to use a suitable lubricant, for example AC 850 (lubricate thread and compression ferrule).



### 2. Reinforcing the tube and pushing it in

Stiffener sleeves are required to reinforce plastic tubes and thin walled tubes. Align tube and union. Insert the tube as far as the stop.

Details see paragraph **tubes**.

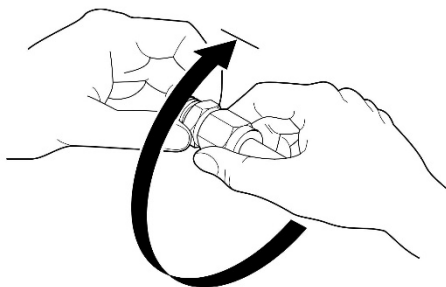


### 3. Compression, stress relieving

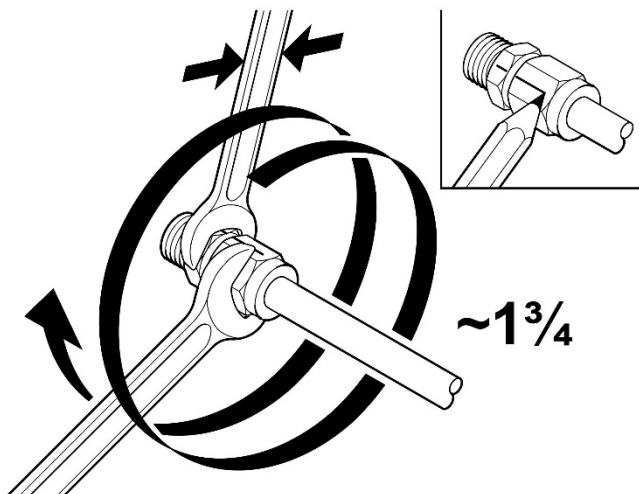
3.1 Screw on the union nut by hand until finger tight.

3.2 Tighten down the union nut approx. **1¾ rotations** using an open-ended spanner (mechanical stop). At the same time, push the tube against the fitting. (Making a mark will assist in correct rotation.) Hold adaptor from turning with a second wrench.

3. / 3.1



3.2



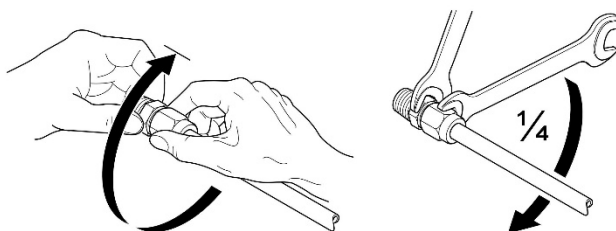
### Repeated fitting of the union

When refitting the same tube union, screw the union nut back on by hand until finger tight and tighten down the union nut with an open-ended spanner ¼ rotation for the final fit.

**In case of repeated assembly, parts must be lubricated.**

Wiederholte Montage

Repeated fitting of the union

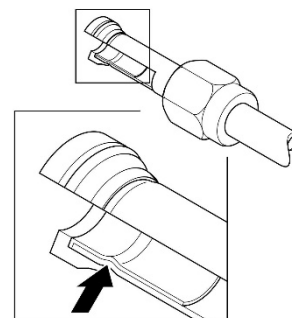


### Checking of fit (optional)

A distinct bead or deformation must be visible on the inside of the tube.

### \* Tubes

Tubes with a clean smooth surface and with an outside diameter tolerance of  $\pm 0.1$  mm should be used.



### Turnable compression ferrule

It is of no detriment to the efficiency of the connection if, after assembly, the ferrule can be turned on the tube, or the tube in the union nut.