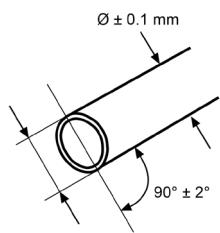
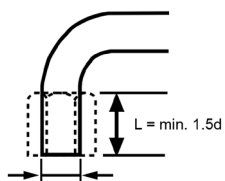


INSTALLATION INSTRUCTION

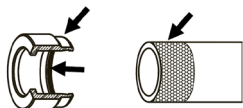


Precision tube with smooth surface, without blemishes or deformation in the union region, cut cleanly to length and deburred.

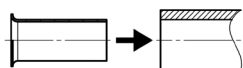
Recommendation: Drawn aluminium tubes with diameter tolerances according to DIN EN 754, **sawn off square**.



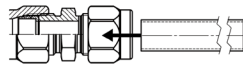
For the union is a **straight, unblemished tube end** needed with a length 'L' of at least 1.5d.



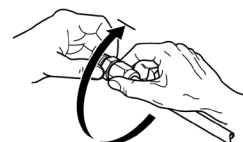
Lubricate compression ferrule and pipe end with the special oil AC 850.



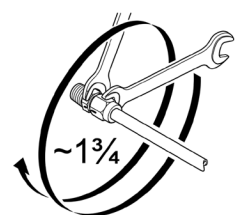
For **plastic tubes**, insert aluminium stiffener sleeve, see "Recommended stiffener sleeves" below.



Insert the tube into the union as far as the stop.

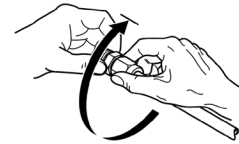


Screw on the union nut by hand until finger tight.

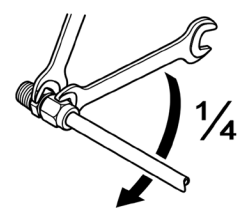


Tighten down the union nut approx. **1 3/4 rotation** using an open ended spanner. At the same time, push the tube against the fitting. Seal off the adapter thread in traditional plumbing manner. SERTO tube connections themselves seal by metal/metal contact. The **sealing surfaces** must therefore **not be damaged**. In case of repeated assembly parts must be lubricated.

FOR TUBE UNION ASSEMBLY OR REPEATED FITTING

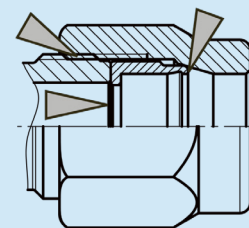


Parts must be lubricated! Use for instance the SERTO special oil AC 850. Screw the union nut on until finger tight and tighten down the union nut with an open ended spanner 1/4 rotation for the final fit.



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

Recommended lubrication points



RECOMMENDED STIFFENER SLEEVE

	Union mm					
	8	10	10	12	12	15
Tube/hose	8 / 6 x 1.0	10 / 8 x 1.0	10 / 7 x 1.5	12 / 10 x 1.0	12 / 9 x 1.5	15 / 12 x 1.5
Stiffener sl. alu	SO 10003-8-6	SO 10003-10-8	SO 10003-10-7	SO 10003-12-10	SO 10003-12-9	SO 10003-15-12