MOUNTING INSTRUCTIONS

General

- Specify the pipe lenghts exactly and cut off rectangularly.
- Burr the pipe extremity and clean it metallically bright.
- Apply the soldering flux where soldering is to be carried out.
- When soldering, use the auxiliary means recommended by DILO and observe the instructions of the soldering materials supplier.
- Do not touch the soldered parts until the solder has solidified and cooled down (Do not quench the soldering area with water).
- Remove the soldering material by rinsing with water and by pickling is.
- Dry union before mounting.
- When mounting only use the connecting components not being damaged by impacts or by overflowed soldering material.
- It must be strictly observed that the tubing system is tension-free supported and that the tubing sections align to each other. Possible divergences can be straightened with the DILO straightening tool.
- Before final mounting, check that all DILO-groove and tongue parts are clear of impurities.
- In order to reduce the friction, the tube unions should be greased with suitable grease at the threads and contact surfaces of the clamping nut, especially when made of austenitic materials. Thus the torque is better converted into axial force and galling of the threads is avoided. When selecting the grease, observe the operating temperatures, the media, the corrosive degree and the materials.
- A fast and strong tightening of the clamping nut guarantees perfect tightness. (Observe torque)

The standard version of the screw-in stub of the DILO screw-in unions is equipped with O-ring sealing.

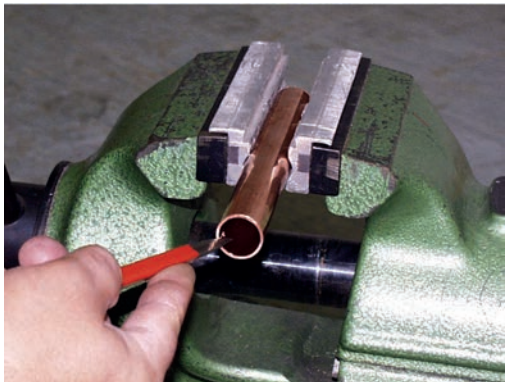
When mounting DILO screw-in unions we recommend using softmetal-sealings (e. g. copper plates opposite the housing or block) for sealing of screw-in stub DIN 3852-1 form B and DIN EN ISO 1179-4.

When all these instructions are observed the mounting will be simple and time-saving. Pipes which are too short or not precisely aligned will require extra work.

MOUNTING INSTRUCTIONS

Mounting illustration:

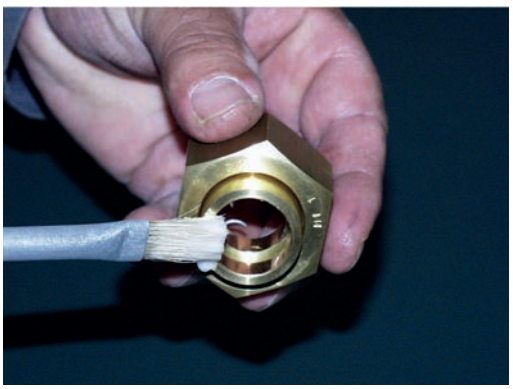
1. Rectangularly saw off the pipes



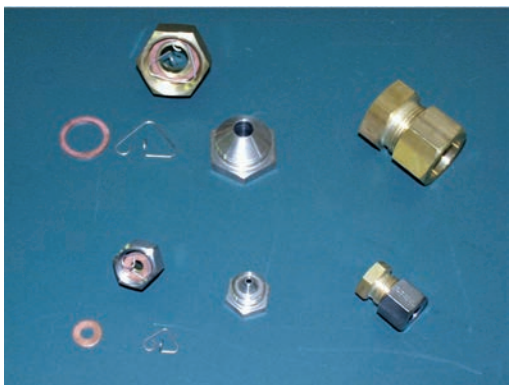
2. Deburring of the pipe extremities inside and outside

3. Clean to a bright metallic finish

4. Apply the soldering flux on the pipe



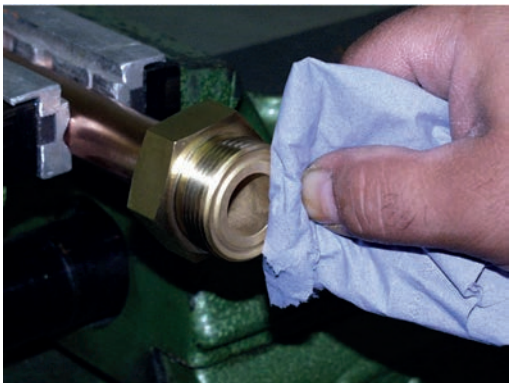
5. Apply the soldering flux at the part to be soldered



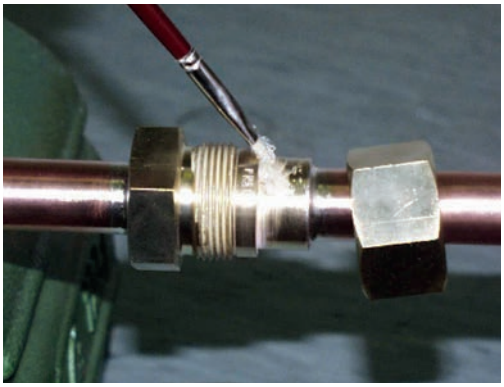
6. Use of auxiliary materials

MOUNTING INSTRUCTIONS

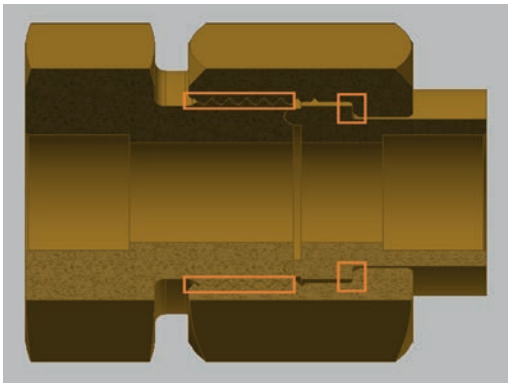
7. Observe the instructions of thesoldering materials supplier



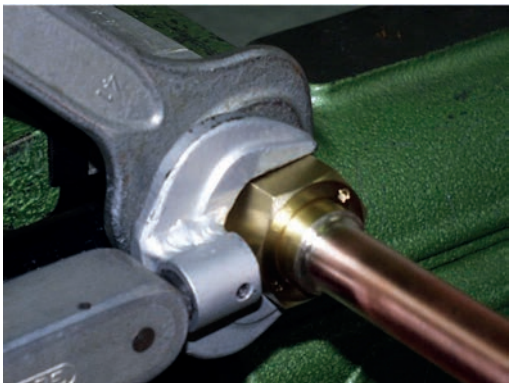
8. Before assembling clean the DILO tongue and groove part



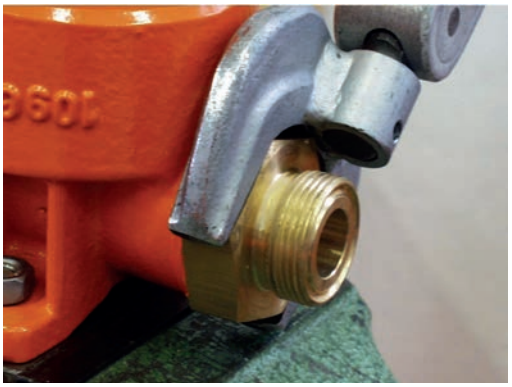
9. Lubricate with appropriate lubricants



10. Lubricating points at a DILO tube union



11. Tighten fast and strongly the clamping nut by counteracting force according to torque table



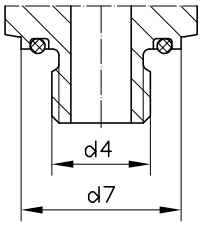
12. A screw in plug is sealed into a housing or block with an O ring or copper seal ring.

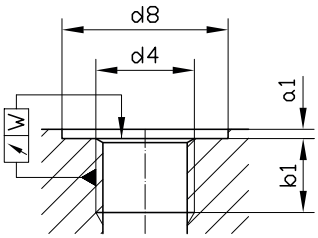
MOUNTING EXAMPLE

Screw-in stub with O-ring sealing

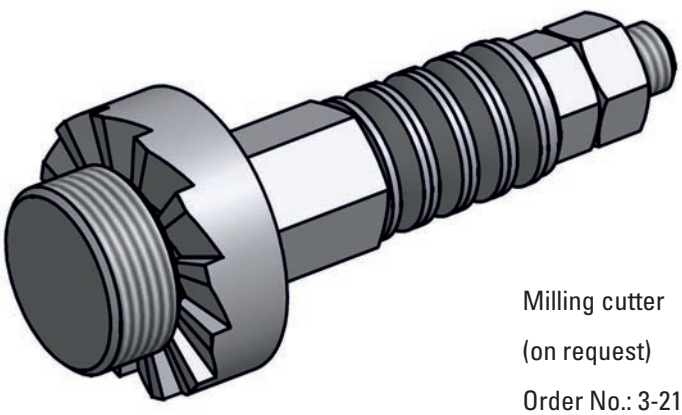
Torque see torque diagram
Screw-in thread

Screw-in hole see table
Make screw-in hole according to DIN 3852-1form X and DIN EN ISO 1179-1
Use milling cutter for tight seat





DN	d4	d7	d8	a1	b1	W
8	M16 x 1,5 G 3/8 A	26	27	1,5	14	0,1
12	G 1/2 A	36	37	2,5	16	0,1
20	M33 x 2 G 1 A	49	50	2,5	20	0,2
40	G 1 1/2 A	65	66	2,5	24	0,2



Milling cutter

(on request)

Order No.: 3-216-...