

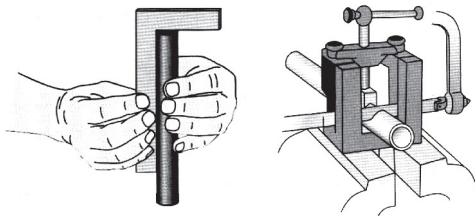
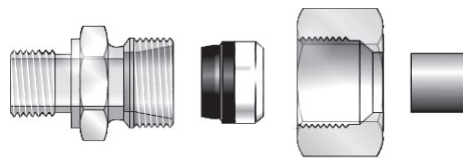
Identifying Fitting Types

Assembly instructions DIN 3859-2

Vitillo fittings with cutting ring include the following parts:

- 1) Union body
- 2) Double edge cutting ring
- 3) Nut

The seal between the union and the tube is obtained by tightening the nut, so that the double edge cutting ring, sliding along the bevel housing of the union, will uniformly cut into the tube and, at the same time, anchors between the tube and the bevel wall

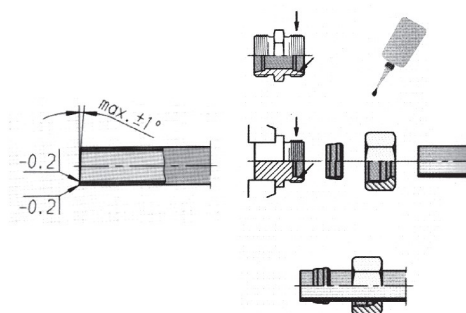


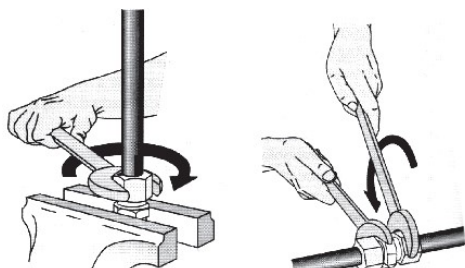
Slightly deburr the inside and outside of the pipe, without damaging the mating surface (max. bevel $0.2 \times 45^\circ$), making sure to remove all the metal particles. Lubricate with oil seat, threads and double edge cutting ring. Avoid grease.

A proper assembly of the fitting is a basic condition to obtain a good performance.

Please, follow our assembly instructions:

Rectangular saw off the pipe. An angular offset of $1/2^\circ$ is permissible. Do not use a tube cutter because this would leave a considerable burr and an angular cut at the tube ends. Use a sawing machine.

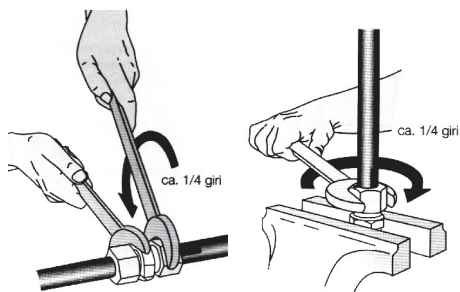
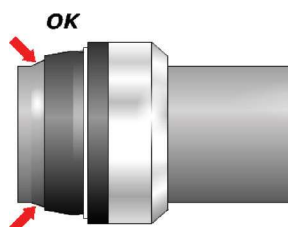




Place nut and cutting ring on the endside of the pipe.

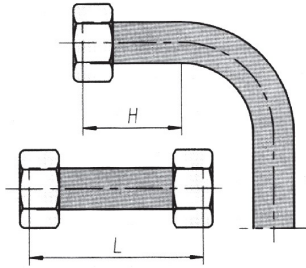
Attention: to avoid a faulty assembly, be careful that the cutting edges of the ring face towards the tube end. Insert the pipe into the union until it reaches the stop and fully tighten the nut by hand. Tighten the nut with a spanner about 1 and 1/4 or 1 and 1/2 turns, putting reference marks on nut and tube if needed. The pipe must no longer turn within the union.

Loosen nut end inspect cut, checking the penetration of the cutting edge. The ring may rotate now. If the cut is not uniform, repeat the operation, tightening further.



Every time the fitting is disassembled and subsequently reassembled, the nut must be re-tightened with the same force as used for the initial installation. The ends of dismantled pipes must be refitted to the same unions used for the tightening procedure.

Identifying Fitting Types



Minimum length of straight pipe in elbows: at least twice the thickness of the nut.

Minimum length of the pipe between two unions: at least 2.5-3 times the thickness of the nut.

For final assembly of all the prefitted unions, after appropriate lubrication screw the prefitted nut by hand onto the body of another union until the point of resistance is met, then tighten by a further 1/2 turn.

