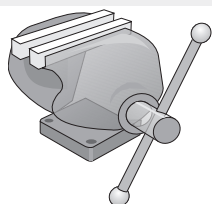


EO progressive ring PSR/DPR

E



Pre-assembly with hardened tool VOMO

- Reliable method for repair jobs
- Only economic for assembly of small quantities
- ⚠ Stainless steel EO progressive rings must be pre-assembled using a hardened tool (VOMO)
- For tubes over 25 mm, EO-KARRYMAT/EOMAT is recommended

1



- ⚠ For stainless steel assembly threads must be lubricated
- Use EO-NIROMONT special high-performance lubricant for stainless steel fittings

2



Ok?

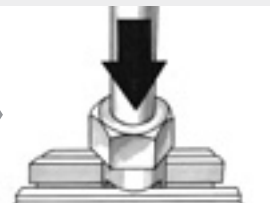
- Control (see checking instructions)
- Cones of pre-assembly bodies must be checked regularly (after 50 pre-assemblies) with cone gauges (KONU)
- Clean and lubricate assembly cone and thread regularly

3

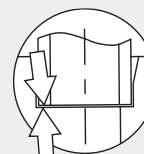


- Use pre-assembly tool VOMO
- Fitting body may be used one time only (not for stainless steel)
- Screw on nut until finger-tight

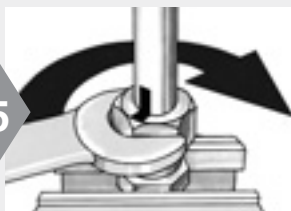
4



- ⚠ Press tube-end firmly into the assembly cone



5



- ⚠ Mark position of the nut
- Tighten the nut by 1½ turns
- ⚠ Recommended to use spanner extension for sizes over 20 mm O.D.

6



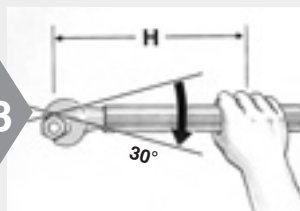
- Assembly check:**
- Loosen nut
 - ⚠ Check to make sure that a visible collar covers the front of the first cutting edge
 - ⚠ It does not matter if the ring can be rotated on the tube-end

7



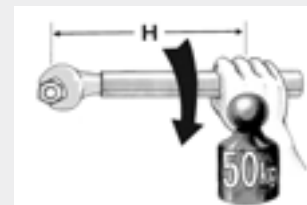
- Assemble fitting until wrench-tight (without spanner extension)
- ⚠ Mark position of nut

8



- ⚠ Then tighten fitting firmly by 30° (½ flat)
- ⚠ Recommended to use spanner extension for sizes over 20 mm O.D. (see chart)
- Assembly torques are available on request

Spanner length



Size	Spanner length H [mm]
22-L	400
28-L 20-S	500
35-L 25-S	800
42-L 30-S	1000
38-S	1200