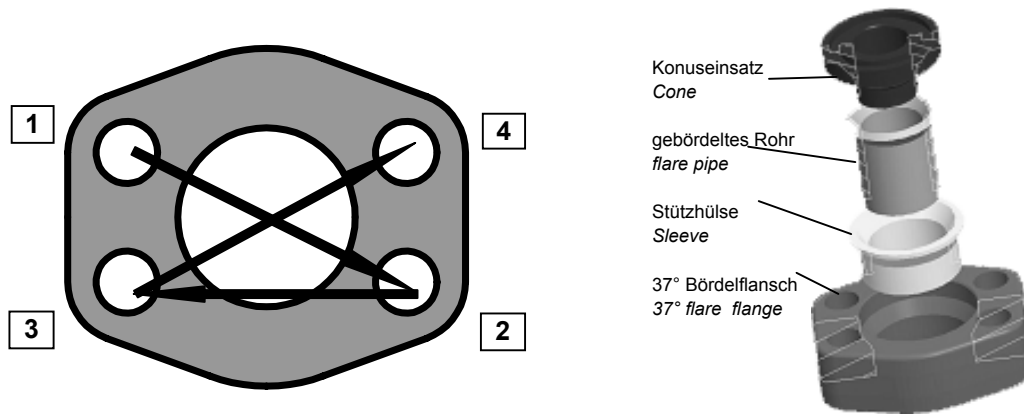


# Assembly Instructions for Flanges

## 37° flare flange SAE J 518 C - ISO 6162

1. The seal face of the flange and the insert must not have any impurities, ridges, unevenness etc
2. All O-rings must be lubricated with the system fluid or a suitable medium.
3. The flange is attached to the pipe. The pipe is then thoroughly bent and cleaned in compliance with the instructions.
4. The cone insert is carefully attached to the bent pipe.  
A plastic hammer is used if necessary.
6. The lubricated screws are at first only tightened by hand, and then gradually diagonally (see no. 7) until the maximum assembly torque (as per the tables) is reached.
7. Indicator position for the fastening torque parameters of the screws.



## Maximized fastening torques for screws

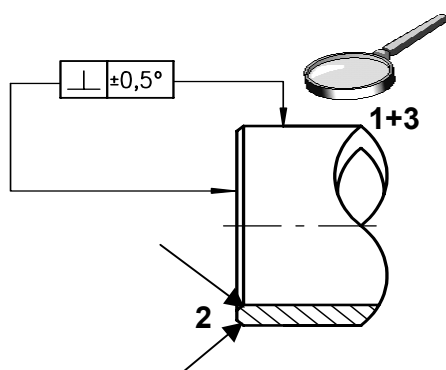
We recommend using screws that comply with DIN 912 8.8

Flange sizes		Model series					
		3000 PSI		6000 PSI		Low-pressure flange 50bar	
	size	Screw	Nm	Screw	Nm	Screw	Nm
O8	1/2"	M8	24	M8	24	-	-
12	3/4"	M10	50	M10	50	-	-
16	1"	M10	50	M12	92	-	-
20	1 1/4"	M10	50	M14	130	-	-
24	1 1/2"	M12	92	M16	210	M12	92
32	2"	M12	92	M20	400	M12	92
40	2 1/2"	M12	92	-	-	M12	92
48	3"	M16	210	-	-	M16	210
56	3 1/2"	-	-	-	-	M16	210
64	4"	-	-	-	-	M16	210
80	5"	-	-	-	-	M16	210

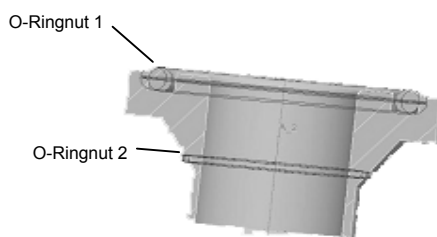
# Abmaße der 37° Rohrbördelung

## Rohrvorbereitung

- \* Rohr rechtwinklig absägen (zulässige Winkelabweichung  $\pm 0,5^\circ$ )  
*Cut the tube square (permissible angular-tolerance is  $\pm 0,5^\circ$ )*
- \* Das Rohr auf die Freiheit von Längsriefen (1) am Innen.- und Außendurchmesser überprüfen  
*Check the pipe inside and out about longitudinal scratches (1)*
- \* Das Rohr mit einer Entgratvorrichtung oder mit einem Handentgrater innen und außen entgraten (2)  
*Lightly deburr (2) inside and out the tube edge*
- \* Innen und außen das Rohr von Spänen befreien  
*Clean the pipe ends internal/external*
- \* Gebördelte Rohr mit einem Tuch reinigen und der Sichtkontrolle unterziehen (3)  
*The flared pipe is inspected and cleaned with a cloth*
- \* Legen Sie die O-Ringe sicher in die Konusnut ein (4)  
*Installed the o-ring carefully into the groove*



### Beispiel: FCA



#### Wichtig:

- \* Nut für O-Ring ist gratfrei!
- \* O-Ring ist nicht defekt und verhärtet!

Reihe Size	Rohr $\varnothing \times S$ Tube $\varnothing \times S$	Bördeldurchmesser D Flare diameter D
1/2"	18 x 2,0	23,5
	20 x 2,0	26,0
	25 x 3,0	26,0
3/4"	20 x 2,0	26,0
	25 x 2,5	30,5
	25 x 3,0	30,5
	30 x 3,0	36,5
1"	30 x 3,0	36,5
	38 x 4,0	45,0
	38 x 5,0	45,0
1 1/4"	38 x 4,0	45,0
	38 x 5,0	45,0
1 1/2"	38 x 4,0	45,0
	38 x 5,0	45,0
	50 x 5,0	58,0
2"	50 x 5,0	58,0
	60 x 5,0	69,0
	60 x 6,0	69,0
	60,3 x 3,9	69,0
	76,1 x 4,0	82,8
2 1/2"	70 x 3	82,0
	75 x 3	82,8

