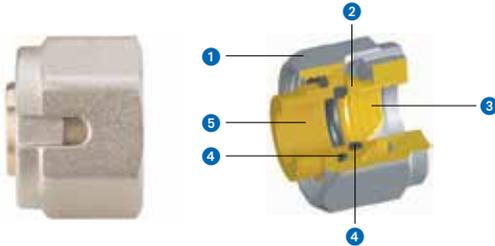


Emmeti 28100318 10mm and 28100330 15mm PB and PEX Monoblocco Seal Installation Instructions



Construction

- 1 Nut in nickel-plated brass ST UNI EN 12165 CW617N
- 2 Collar in brass ST UNI EN 12164 CW614N
- 3 Serrate hose-clamp in brass ST UNI EN12164 CW614N
- 4 O-ring seal in EPDM
- 5 Adapter in brass ST UNI EN 12164 CW614N

1 Condition of Materials

- 1.1 Before installation all seal fittings should be inspected to ensure that components are in place and correctly assembled. The seal fitting components are supplied fully pre-assembled, making a one-piece unit. The componentry of the connectors are held in place by counter threading into the nut during manufacturing, and sit loose inside the nut assembly.
- 1.2 Confirm this by visual inspection. They are designed to be loose once threaded into the connector.
 - 1.2.1 On the back of the fitting you should see an grey o-ring seal.
 - 1.2.2 Through the front of the fitting you should see a ridged split olive and a second o-ring seal.
- 1.3 Do not disassemble fitting at this time. Please ensure the fitting is free from obvious damage.
- 1.4 The pipe to be used with the fitting should be clean and free from external scratches, cuts, nicks, 'kinks, or other damage. The pipe must be round (**not oval**). Please use the pipe manufacturer supplied pipe reamer to ensure that it is.

2 Jointing

- 2.1 These seal fittings are installed by using the technique described here. You require a spanner or wrench, metric 27mm, for tightening. We provide an exact spanner, code 01306054. For interaxial spaces on manifolds of less than 50mm, you should use a spanner with a minimised shoulder dimension or use the procedure described below.

3 Making a Joint

- 3.1 The pipe should be cut, using an appropriate plastic pipe cutter, as described by the pipe provider.
 - 3.1.1 Make sure the cut is perpendicular to the pipe axis. Pipe should never be cut with a hacksaw, wheeled tube cutter, pliers or Stanley knife. These leave a roughened or out-of-square pipe, which will potentially not seal correctly.
 - 3.1.2 The cut pipe should be checked for burrs and any roughness removed. Visually inspect the pipe – it should also be free from grit, dirt or swarf.
- 3.2 All pipe should then be fitted with a standard pipe insert or support sleeve, supplied by your pipe provider.
- 3.3 The correct depth of insertion into the seal fitting must be marked on the pipe before assembly.

Monoblocco Seal Installation Instructions

- 3.4 Placing the pre-cut, ready to use pipe alongside the fitting, and marking the appropriate depth can do this. To obtain a good seal, there is flexibility in the precise insertion depth required.

Nominal fitting size	Correct insertion depth
10mm	20mm
15mm	20mm

- 3.5 The joint is then made by pushing the pipe firmly into the seal fitting, using the following technique: -
- 3.5.1 Grasp the pipe in one hand and the seal fitting in the other, using the flat of your hand to push the seal fitting fully onto the prepared pipe end.
- 3.5.2 Push until the marked point is reached. Resistance will be felt as the split olive and grey o-ring seal make contact with the outside diameter of the pipe. Push past this until you reach the positive pipe stop.
- 3.5.3 Visually confirm the pipe and pipe insert is sitting flush with the back face of the fitting.
- 3.5.4 Further confirmation can be gained by rotating the nut only, until the viewing window in the nut is at the split in the ridged grip ring. If the viewing window shows the pipe the whole length of the split, the outside diameter of pipe has reached the grey o-ring seal.
- 3.6 Present the pipe with seal fitting attached to the male thread of the fitting or manifold it is being attached to. Thread the connector by hand onto the nut, until it can be tightened no further.
- 3.7 Use a standard spanner or wrench, or the special spanner to further tighten. No excessive pressure should be used. Under tightening will leave the split ring and o-ring seal not fully engaging with outside diameter of pipe.
- 3.8 During tightening the grooved ridges on the split ring tighten until the split is closed. This prevents over tightening, but excessive tightening will distort or break this.

4 Connecting Pipe with limited interaxial space

- 4 If you are connecting the pipe and seal fitting to a manifold with limited interaxial space between each connection, please use the following procedure:
- 4.1 Connect the pipe and seal fittings in sequence, starting with the first port at one end of the manifold, and work towards the other end of the manifold.
- 4.2 Screw the nuts onto the manifold one by one in order.

5 Dismantling a Joint

- 5.1 Before dismantling, isolate the affected seal fitting or fittings, or drain the complete system.
- 5.2 To remove the pipe with seal fitting from the fitting or manifold, unscrew the nut, using appropriate tools, or the special spanner.
- 5.3 Once the pipe and seal fitting are unattached from the fitting or manifold, remove the pipe from the seal fitting, by counter rotating the nut, until it comes away.
- 5.4 The 3 pieces should remain on the pipe at this time: – the rear section, with two grey o-rings seals attached, the guide plate and the split grooved ring.
- 5.5 Slide these off the pipe by hand, or gently use padded pliers if appropriate.
- 5.6 Visually inspect the components before further action, ensuring no damage can be seen.

6 Remaking a Joint

- 6.1 Re-assemble the loose components into the nut as follows: -
- 6.1.1 First place the split grooved ring into the nut.
- 6.1.2 Then the flat guide plate, smallest diameter facing into the nut.
- 6.1.3 Then the rear section, threaded end first. Ensure the two grey o-ring seals are already in place. If they have come unattached, re attach them first. The smaller o-ring is at the front of this section (used for gripping the outside diameter of the pipe), and the larger o-ring (used for creating a sealing face against the fitting or manifold) at the rear of the component.
- 6.1.4 Re-engage this rear section by threading into rear of nut clockwise.
- 6.2 Repeat assembly technique onto prepared pipe as described in section titled MAKING A JOINT.
- 6.3 Make sure the pipe end is damage free. If necessary re-cut, to provide a damage free pipe end, and clean contact surfaces. This sequence described above should always be followed when and dismantling

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