

## **FITTING INSTRUCTIONS FOR SIRIT PUSH IN FITTINGS**

The seal of the stud coupling is specified by what is laid down in ISO standard 6149-80 and DIN standard 3482. To obtain the correct assembly on all terminal fittings it is essential to adhere to the tightening torques shown in the following table:

<b><u>Thread Tightening Torque</u></b>	<b><u>(Nm) ± 10</u></b>
M10 x 1	22
M12 x 1.5	24
M14 x 1.5	30
M16 x 1.5	35
M18 x 1.5	36
M22 x 1.5	40
M26 x 1.5	45

The tubing must be cut at the right angles with a maximum tolerance of 12°. Correct assembly is performed only when the tubing is inserted touches the end of the tube seat. To be absolutely certain that this is the case it is advisable to mark the depth of the tubing coupling or use the "X" provided on some Din Tubing.



**CORRECT**

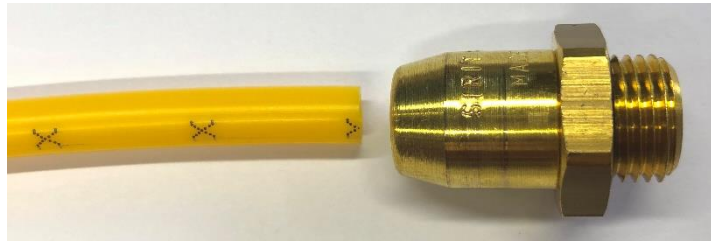


**INCORRECT**

<b><u>Pipe</u></b>	<b><u>Depth Of Pipe MM</u></b>
6 x 4	19.8
8 x 6	20.5
10 x 7	24
10 x 7.5	24
10 x 8	24
12 x 9	25
15 x 12	27
16 x 12	27
18 x 14	27



The tubing/fitting coupling does not require tools. To make the operation easier it is sufficient to slightly turn the tubing when inserting, once the tubing has been fully inserted, twist the tubing to ensure a full score on the tubing and pull back to ensure the tubing has been fitted correctly, pulling back ensures it has been fully fitted to the seat of the fitting and not just part clamped on the retaining clip.



**IMPORTANT: Check the component is coupled correctly and securely. Pull the component to ensure.**

As a guide for final leak testing the fittings, we advise a spray test to take place once the fittings have been pressurised to 10 Bar.

Please follow the above instructions when fitting.



**Air Brake Connections Limited**  
**Unit 5, May Avenue Industrial Estate – Northfleet – Kent - DA11 8RU**  
**www.airbrakeconnections.co.uk - Tel: 01474 – 535456**  
**Email: sales@airbrakeconnections.co.uk**