Visual Index

EO Progressive Ring Fittings — Introduction

The flareless bite type fitting was pioneered by Ermeto in Germany in the early 1930's. When Parker Hannifin acquired Ermeto, it introduced the EO fittings to the US. Today, the EO fittings are the most widely used bite type fittings in the world.

The EO progressive ring fitting is a flareless metric fitting (for metric tube)that consists of a body, a progressive ring (ferrule) and a nut. On assembly, two cutting edges of the progressive ring "bite" into the outer surface of the tube ensuring the necessary holding power and seal for high operating pressures.

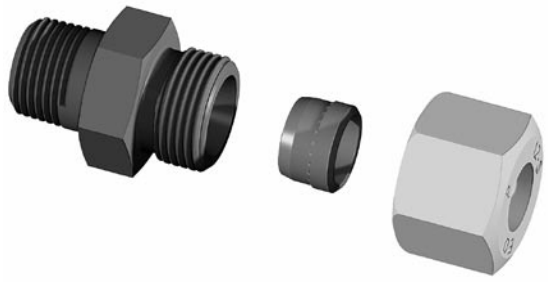

Fig. H1 — EO fitting components: Body, progressive ring and nut

The fittings and components listed in this catalog are intended solely for the assembly of connections for fluid applications.

Three series of EO tube fittings (LL, L and S) and accessories are manufactured in accordance with DIN 2353 (summary) which today is represented by international standard 8434-1 on the basis of decades of experience.*

To ensure functional safety of EO tube fittings, only EO parts should be used in their assembly. Routing of tubes should be carried out in accordance with Parker/EO recommended practices. Assembly instructions are available.

Design and Construction

The three components of EO fittings are designed and manufactured to produce a strong, reliable, leak-free joint upon proper assembly.

The EO Body. EO fitting bodies are available in over thirty configurations. The shaped products (i.e., elbows, tees, crosses) are hot forged, then machined to the stringent EO fitting specifications. The forging process used by Parker further improves the strength and metallurgical properties of the fitting material.

Straight products are made from cold drawn bar stock. The cold drawing operation ensures consistently tight dimensional tolerances, as well as significantly improved strength.

The EO Progressive Ring (Cutting Ring). EO progressive rings are precision machined with all dimensions and surfaces, particularly the critical bite edges, monitored on an ongoing basis. The rings are then heat treated in a manner that provides the hardness, strength, and toughness necessary to satisfy the demanding service conditions that exist in industry today. The original progressive ring, known as DPR, is now being replaced with the new generation, called PSR. PSR is stronger and features a "positive stop" to eliminate over-tightening.

The EO Nut. EO fitting nuts are either cold formed, hot formed or machined from cold drawn material. The cold forming and cold drawing operations provide a more tightly packed grain structure, thus improving the material's strength. In addition, cold forming significantly improves the fatigue properties or endurance limits of the nuts.

Standard Material Specifications

Steel fittings:
EO tube fittings – Materials according to DIN 3859-1

Stainless steel fittings:
EO tube fittings – X6CrNIMoTi 17122 in accordance with DIN 17440 / EN 10088, material no. 1.4571.

Brass fittings:
EO tube fittings – CUZN35Ni2 in accordance with DIN 17660, material no. 2.0540.

Elastomer seals: NBR (BUNA-N), FKM (Fluorocarbon)

Surface Finish - Steel fittings:

Standard LL Series	Body, Nuts, and Rings	– Zinc clear chromate, Chromium 6 Free
L+S Series	Body and Nuts	– Zinc clear chromate, Chromium 6 Free
	Progressive Rings (PSR)	– Zinc clear chromate, Chromium 6 Free

Short codes for surface protection procedure in accordance with DIN 267 part 9 or DIN 50942.

How EO Fittings Work: Function of Progressive Ring Fittings

The EO progressive ring fitting produces a low to high pressure, leak free connection of tubes and components in fluid systems. The basic function of the EO progressive ring is the controlled progressive bite of the ring into the tube due to a unique internal geometry.

The front cutting edge has already started cutting into the tube before the second cutting edge starts. As soon as both cutting edges have cut the tube to the designed depth further advance is limited by the stop edge.

Owing to the design of both cutting edges and stop edge all forces arising are equally distributed. This distribution along with the specially designed interior collar of the ring guarantees increased safety, particularly with regard to vibration and flexure stresses. The design and function of the progressive cutting ring ensure that service vibration loading is not present in the areas of the tubing where the bite is made.

*The selection of LL, L or S design should be made by the user on the basis of intended system pressure. The pertinent maximum recommended working pressures are shown throughout this catalog in individual data charts of the various fitting configurations.