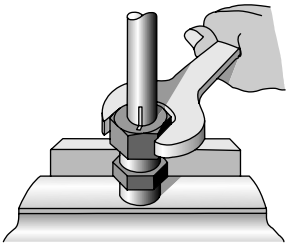
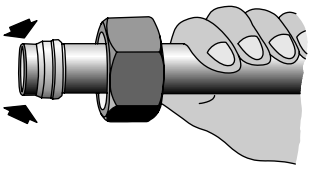
5. Tighten nut 1 ½ turns if using the fitting body (1 ¼ turns if using the hardened pre-assembly tool). The tube must not turn with the nut. The stop edge in the progressive ring limits over tightening by sharply increasing the tightening torque.



Pre-set Inspection

To inspect the pre-set, remove the nut and tube from the fitting and check if a visible collar fills the space completely in front of first cutting edge. If not, tighten slightly more. It does not matter if ring can be rotated on tube end.



Pre-set Using EO-Karrymat, EOMAT III, Hydra-Tool or Hyferset

When pre-setting EO fittings larger than sizes 18 mm, it is recommended that a hydraulic tool be used. The EO-Karrymat, Hydra-Tool or the Hyferset (shown in Fig. T41) are recommended for low to medium volume production.

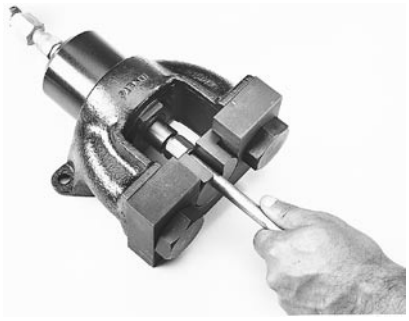


Fig. T41 – Hyferset tool

For high volume production, it is recommended that the EOMAT III, shown in Fig. T42, be used for pre-setting. The required operating pressure depends on the tube type, material and tube dimensions, and is automatically selected by a microprocessor.

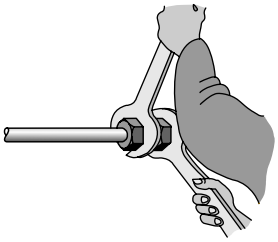
Fig. T42 – EOMAT III

For full instruction on the use of these hydraulic tools, please refer to the Bulletins indicated below:

- EO-Karrymat – Bulletin 4044-T1/UK/DE/FR/T
- EOMAT III – Bulletin 4043-1/GB
- Hyferset - Bulletin 4393-B1
- Hydra-Tool – Bulletin 4392-B10

Installation

To install the pre-set tube assembly to the fitting body, wrench-tighten nut to wrench resistance (light wrenching). From this position, tighten nut another 1/4 turn or 1 1/2 flats of the nut. Another wrench must be used to prevent movement of the fitting body.



Assembly with Support Sleeve (VH)

If the tube wall thickness is small relative to the tube O.D., this may lead to tube collapse. As a rule, the tube collapse (reduction in diameter) should not exceed 0.3 mm for tubes up to 16 mm O.D. and 0.4 mm for tubes from 18 mm O.D. and above.

When assembling thin walled tube, there is insufficient cross sectional rigidity where the progressive ring cuts. This will have a detrimental effect on the sealing efficiency. For this, internal support sleeves (VH) are available which are inserted in the tube to prevent tube collapse and also increase the cross-sectional rigidity.