

1. Intended use / product description



Medium: Potable water / Municipal Sewage
Max. operating temperature: Potable water / Municipal Sewage: 0° to 40°
Max. operating pressure: Potable water / Municipal Sewage: 16 bar
Material: Upper/lower shell: GJS-400, Hawle epoxy powder coating
 Gaskets: EPDM

Pipe repair clamp consisting of two half-shells for closing tapped holes or sealing damaged areas in PE pipes (DIN EN 12201, DIN 8074) or PVC pipes (DIN EN ISO 1452-2).
 Reliable sealing due to three O-rings (profile seal).

Due to the stability of the pipe, the tapping hole or damaged area must not be larger than the maximum tapping diameter (based on the pipe size, max. 1/2 pipe diameter or max. Ø50mm).

Ord.No.	d	max. tapping diameter/ damaged area
510 000 0630	63 mm	30 mm
510 000 0750	75 mm	36 mm
510 000 0900	90 mm	45 mm
510 000 1100 - 510 000 2800	110 mm - 280 mm	50 mm

CAUTION: Pipe repair clamps cannot be used to make feed or assured connections!

During installation and maintenance operations, the applicable standards and guidelines, accident prevention regulations and the regulations of professional associations are to be observed and complied with.
 Installation and maintenance operations may be performed by qualified personnel only.

2. Assembly

	Open-ended wrench SW17, SW19, SW24
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1. The surface of the pipe must be free from dirt, soil, or grease, and the pipe has to be cleaned accordingly. Prevent water leakage at the leakage point.
2. Place the pipe repair clamp at the desired position.
The damaged area must be within the three o-rings!
3. Fix the two half-shells with the four screws supplied.

The following torques are valid:

M10: max. torques 50 Nm
 M12: max. torques 70 Nm
 M16: max. torques 90 Nm

Standard installation:

Tighten the hexagon head screws evenly and crosswise until the two parts get in contact and the maximum torque is reached.

IMPORTANT: Do not use any extensions!

Installation on old pipes:

When the pipe saddle is to be installed on existing PE lines (old pipes), the outside diameter may be beyond the standard tolerance. Pretighten the HAKU with two longer screws, if necessary.

After final assembly of the saddle, check the maximum torque **twice after 15 minutes**, each!

3. Commissioning and pressure-testing

After the successful installation, the device has to be subjected to pressure testing in the open trench considering the maximum operating pressures as specified in the DVGW regulations.

4. Servicing and maintenance

Hawle pipe repair clamps do not require any maintenance.

If you have any other questions or if you need more information, please contact:

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