

### 1. Intended use

The 835-01 drilled hole sleeve can be used for the installation of Hawle Hawlinger (1 „1/2“ and ZAK 46) service valves in conjunction with cast iron and steel pipes for drinking water supply up to 16 bar.

### 2. Product description

The plastic drilled hole sleeve (Fig. 1) is installed in the drilled hole after drilling. The drilled hole sleeve prevents the drill hole from „growing over“ (incrustation).

The four „wings“ on the upper part of the drilled hole sleeve are folded inwards during installation and engage in the end position in the lower part of the Hawlinger.



Figure 1

### 3. Assembly

The assembly can be carried out either in a depressurised state or in an operating state (see description below) of the pipeline to be drilled.

1. Mount the Hawlinger with saddle seal on the main pipe.

Tighten the Hawle strap evenly and firmly. The maximum tightening torque specified on the strap (50 - 100 Nm) must be observed. Caution: When used with BLUTOP pipes, maximum 70 Nm.

2. Perform the drilling procedure in the usual manner with the Hawle drilling machine (Order No. 830-00) and spiral drill  $\varnothing$  36 (Order No. 831 105 3600).

For BLUTOP pipes it is recommended to carry out the drilling process with a 7 mm dia. centre drill and a 35 mm dia. holesaw (Order No. 831 103 3500) and a suitable actuator (speed 100-150 rpm) (e.g. cordless drill).

The following adapters must be used in conjunction with the Hawle drilling machine (order no. 830-00):

- (Adapter battery-powered drilling machine to drilling machine Order No. 831 003 9991)
- (Adapter drilling machine ZAK 46 Order No. 831 003 9046)
- (Adapter drilling machine male thread 1 1/2" Order No. 831 000 6350)

After drilling, pull back the drill shaft under counterpressure (blue handwheel, Order No. 849 000 0024), close the washer disc on the Hawlinger by turning 1/2 and remove the drilling machine.

3. Unscrew the spiral drill or holesaw from the drill shaft and replace it with a set adapter (Order No. 835 200 0000) (Fig. 2).



Figure 2

4. Push the drilled hole sleeve onto the set adapter and push it back with the drill shaft to the stop (Fig. 3).



Figure 3

5. Mount the drilling machine on Hawlinger. The flushing tap on the drilling machine can be opened.
6. Place the blue handwheel (order no. 849 000 0024) on the square of the drill shaft and open the washer disc on the Hawlinger. After another short rinse, close the flushing tap (Caution: The drill shaft can extend abruptly due to the internal pressure).
7. For assembly of the drilled hole sleeve, push the drill shaft with the flushing connection closed with manual force up to the lower stop (distinct stop perceptible).
8. Pull the drill shaft back up to the upper stop, close the washer disc, open the flushing tap and remove the drilling machine.
9. Perform pressure testing.

**Should you have questions or need further information, please contact:**

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