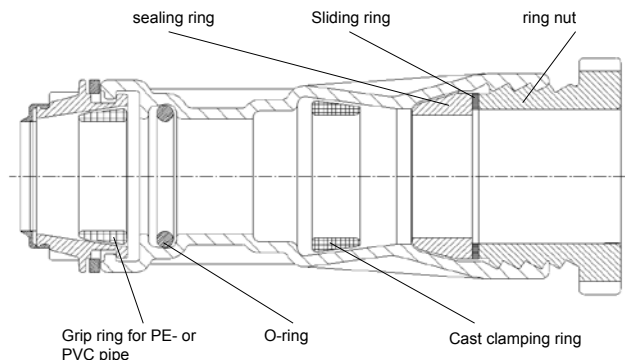


1. Intended use / product description



Medium: Potable water / Sewage water
Max. operating pressure: Sewage water: 16 bar
 Potable water: 16 bar
Material: Body/Screw ring: GJS-400, Hawle epoxy powder coated

Transition fitting from DCI to PE pipe.

On the one hand with threaded union incl. SMU sealing ring to DIN 28601, on the other hand with socket and removable cone ring for the restraint connection of PE pipes of quality PE 80 and PE 100 to DIN 8074 and PE-X pipes to DIN 16893 (version for PVC pipes on request).

Simplest assembly / Simplified dismantling without extractors (fitting side).

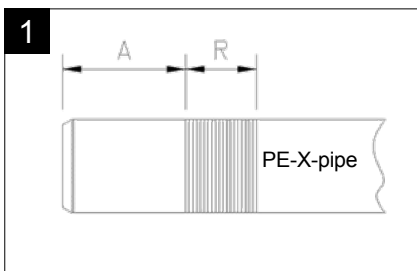
Caution: With multiple use of the fitting or the threaded union, the grip ring and, if applicable, the O-ring or the sealing ring must be replaced.

Caution: When connecting PE pipes a support liner must always be used.

When laying, installing the pipes and during maintenance, it is necessary to refer to and comply with applicable standards and regulations, accident prevention regulations and regulations from trade associations. Installation, assembly and maintenance should only be carried out by qualified personnel.

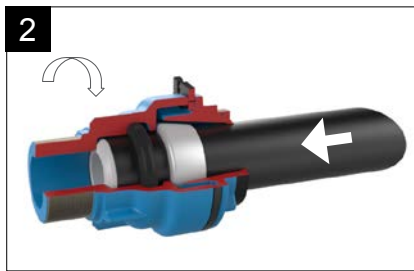
2. Assembly

2.1 Assembly fitting side

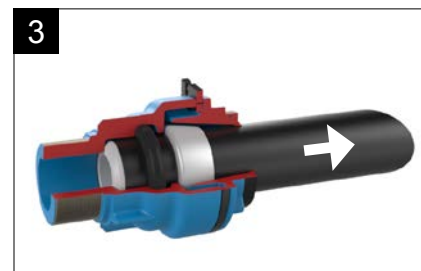


Use pipe end without notches and grooves on the surface. Cut the pipe straight with sharp PE shears. For pipes with a very smooth surface (e.g. PE-X pipes) we recommend roughening the pipe end only in the clamp area perpendicular to the pipe axis!

	Roughening area R for PE-X pipe in mm	
	A	R
d 40	42,0	24,0
d 50	52,0	26,5
d 63	62,0	30,0

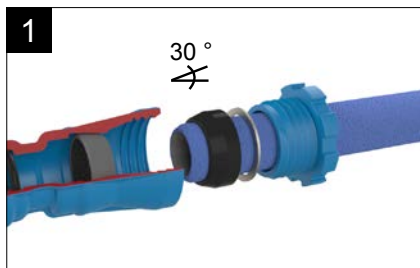


Pipe and fitting must be clean and free of lubricants. Mark the insertion length on the pipe. Caution: Before assembly, the plug fitting must be checked for completeness and for correct seating of O-ring and clamp! Insert the support liner into the PE pipe as far as it will go. When using the included Hawle POM support liner, only deburr the cut surface (Chamfering tool Ord.No. 600-00 or Chamfering tool Ord.No. 598-00). When using MS support liners, the tube should be chamfered at 30°. Push on the push-fit fitting completely, turning and rocking it while doing so. Use only clear water or Hawle installation spray (no grease or soap) as mounting aid!

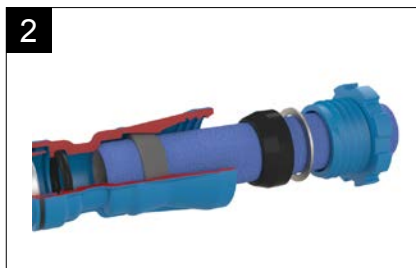


Check tensile strength and tightness by pressure test.

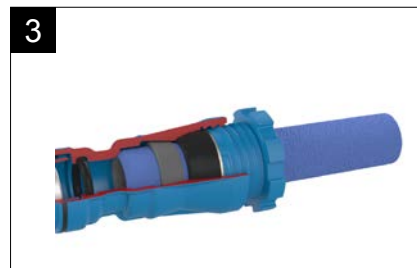
2.2 Assembly screw ring



Use the pipe end without damaging the surface. Wrappings must be removed. Cut pipe straight and chamfer burr-free at an angle of 30°.

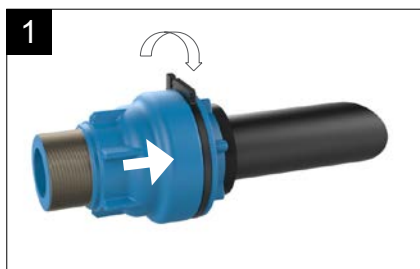


Check the correct fit of the grip ring (the narrow side in the direction of the threaded union). Mark the insertion length and push the transition on completely.

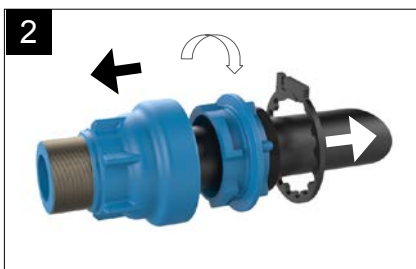


Establish threaded union connection. Check tensile strength and tightness by pressure test.

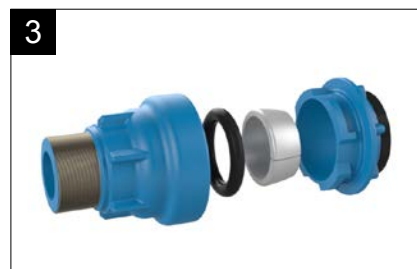
2.3 Demontage Fittingseite



Release the load on the fitting or pipe in the mounting direction: (short jerk) !



Remove fixing ring. Unscrew the cone area (blue cast iron ring) with a suitable tool (either pipe wrench or turning spanner)



When reusing the fitting, replace the grip ring. Inspect O-ring seal and replace if necessary.

2.4 Dismantling - screw ring

For dismantling, use the long version of the extracting tool art. no. 601 050 0001.

3. Service and maintenance

The Transition fitting from DCI pipe / PE pipe type „N“ is maintenance-free.

4. Commissioning and pressure testing

After successful installation, a pressure test must be carried out in an open pipe trench, observing the maximum operating pressures in accordance with DVGW regulations.

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

Hawle Armaturen GmbH
- Application Engineering -
Liegnitzer Str. 6
83395 Freilassing
Phone: +49 (0)8654 6303-0
Telefax: +49 (0)8654 6303-222
E-Mail: info@hawle.de
Web: www.hawle.de