



APPLICATION

- It is specified in individual figures 1 to 18
- In assembly with another armature
 - o As a pressure device of category III pursuant to the Decree of the Government 26/2003 Coll. (module of compliance assessment B+D)
 - o As a special design in the purity level for oxygen (O₂), this armature is delivered perfectly degreased and provided with a suspended blue tag (code P2S)
- Couplings
 - o As a special design with purity of internal surfaces of grade I pursuant to TPE 10-40/1926/85 (code PC1)
 - o For conditions requiring seismic resistance 1 Hz to 33 Hz, acceleration 3g, certification STKC Dubnica

The accessories are rated products pursuant to the Act No. 22/1997 Coll. and Compliance Certificate **EC-981000** is issued for them.

DESIGNATION

Data on identification label

- Product ordering number
- Drawing number
- Designation CE

DELIVERY

Unless agreed otherwise with the customer, each delivery includes

- Delivery note
- Products pursuant to the purchase order
- Accompanying technical documentation in Czech:
 - o EC Compliance Certificate
 - o Product manual
 - o Protocol about inspection cleanness of internal surfaces (only in case of armature with code PC1)

If it is established in the purchase contract or agreed otherwise, the following documentation can be also delivered with the product:

- A copy of inspection certificate 3.1 pursuant to ČSN EN 10204 for material with casting number
- Compliance Certificate with purchase order 2.1 pursuant to ČSN EN 10204
- A copy of certification about test results for certification of seismic capability pursuant to ČSN IEC 980

PACKING

Accessories are delivered welded in a PE bag together with the identification label provided with the drawing number, ordering number and CE designation and in the package ensuring resistance to the impact of temperature effects and mechanical effects pursuant to controlled packing regulations.

TRANSPORT

Accessories may be transported on conditions corresponding to the set of conditions of classes IE 23 pursuant to ČSN EN 60721-3-2 (i.e. by airplanes, trucks, all types of trailers and semi-trailers in the areas with well-developed road network, railway wagons with specially designed shock absorbers and ships, in areas that are not ventilated and not protected against atmospheric effects).

STORAGE

Accessories may be stored on conditions corresponding to the set of combinations of classes IE 12 pursuant to ČSN EN 60721-3-1 (i.e. at ambient temperature -30 to 45° C with relative humidity of ambient air 95% and max. content 29g H₂O/m³ of dry air, in places with a threat of occurrence of condensation, dripping water, formation of ice, but without a special threat of an attack with biological agents, with vibrations of small significance and not situated close to sources of dust and sand.)

ORDERING

Accessories can be ordered in two ways: either directly (as type 981) or by means of an ordering number of another product.

Ordering directly as type 981:

The purchase order shall specify:

- Name
- Type number 981 + relevant code or ordering number
- Other (special) requirements
- Number of pieces

In this way, only one type of accessories can be ordered, so that there may only be one code or one ordering number behind the number 981.

PURCHASE ORDER EXAMPLE

Standard design:

Weld-on cone
981 KU3
20 pcs

Special requirement:

Manometric shock absorber
981TL1
with inlet and outlet threads G1/2
20 pcs

Ordering by means of the ordering number of another product:

The purchase order shall specify:

- Product name including the name of accessories
- Ordering number including code(s) of accessories
- Number of pieces

In this way, more types of accessories, which are applicable to that particular product, can be ordered. The number of pieces of individual parts of accessories is based on the need of such parts for the product, the type number of which is specified in the purchase order.

PURCHASE ORDER EXAMPLE

Standard design:

1. Valve set + weld-on cone with cap nut
9644521 W1 S1 KU3
10 pcs
2. Valve set + weld-on sleeve with cap nut + holder
9642531 W2 S1 NA5 B3
10 pcs

Table 1

THE TABLE SPECIFIES ACCESSORIES, WHICH ARE DELIVERED WITH THE ARMATURE AS A DEFAULT, AND ALSO ACCESSORIES, WHICH CAN BE DELIVERED WITH THE ARMATURE AFTER ORDERING WITH THE USE OF THE CODE BEHIND THE ORDERING NUMBER.

TYPE OF ARMATURE	ACCESSORIES DELIVERED WITH ARMATURE AS A DEFAULT	CODES OF ACCESSORIES, WHICH CAN BE SPECIFIED BEHIND THE ORDERING NUMBER
964 2... (for sensor flange - pitch 54 mm)	Sealing ring PTFE 24x18x3, Sealing blind to control handle	- SR2, SR3, SR4, SR5 - B3 - ODP2, ODP1 - KL1 - KU1, KU2, KU3, KU4, KU5, KU6 - NA1, NA2, NA3, NA4, NA5, NA6 - NAG1, NAG2, NAG3, NAG4, NAG5, NAG6 - EMA3, TZ1
964 3... *) (for sensor flange - pitch 57 mm)		
964 4... (between the piping)	Holder B3, Sealing blind to control handle	- ODP2, ODP1 - KL1 - KU1, KU2, KU3, KU4, KU5, KU6 - NA1, NA2, NA3, NA4, NA5, NA6 - NAG1, NAG2, NAG3, NAG4, NAG5, NAG6 - EMA3, TZ1
967 ...	Sealing blind to control handle	- KU1, KU2, KU3, KU4, KU5, KU6 - NA1, NA2, NA3, NA4, NA5, NA6 - NAG1, NAG2, NAG3, NAG4, NAG5, NAG6 - TZ1, TZ2 - KL1
984 2..... (for sensor flange - pitch 54 mm)	Sealing ring 24x18x3	- SR2, SR3, SR4, SR5 - B3 - ODP2 - KU1, KU2, KU4, KU5, - NA1, NA2, NA4, NA5,
984 4..... (between the piping)	Holder B3	- ODP2 - KU1, KU2, KU4, KU5, - NA1, NA2, NA4, NA5,

*) only after an agreement with the manufacturer as a special requirement

FIGURE 1 - WELD-ON CONE WITH CAP NUT

CODE	MATERIAL	DIMENSIONAL DRAWING
KU1	Carbon steel 11 523	
KU2	Stainless steel 1.4541	
KU3	Creep-resisting steel 15 128	
KU4	Carbon steel 11 523	
KU5	Stainless steel 1.4541	
KU6	Creep-resisting steel 15 128	

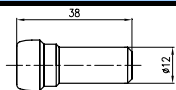
The cone is delivered by 1 piece together with the relevant cap nut.

After putting the cap nut on the cone and welding the cone on the piping, the armature provided with the corresponding screw joint for the cone according to the dimensional drawing of the screw joint can be attached to the cone.

CAP NUT FOR WELD-ON CONE

MATERIAL OF NUT	DIMENSIONAL DRAWING OF NUT	DIMENSIONAL DRAWING OF SCREW JOINT
Stainless steel 1.4541		
Carbon steel 11 109.0 (only for KU1 and KU4)		

FIGURE 2 - BLIND CONE WITH CAP NUT IN POSITION OF PLUG

CODE	MATERIAL	DIMENSIONAL DRAWING
ZKU1	Carbon steel 11 523	

The cone is delivered by 1 piece together with the relevant cap nut.
After putting the cap nut on the cone, the armature provided with the corresponding screw joint for the cone according to the dimensional drawing of the screw joint can be attached to the cone.

CAP NUT FOR BLIND CONE

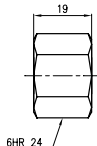
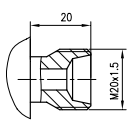
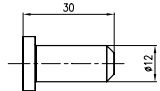
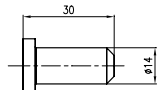
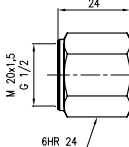
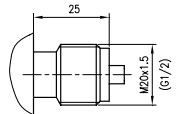
MATERIAL OF NUT	DIMENSIONAL DRAWING OF NUT	DIMENSIONAL DRAWING OF SCREW JOINT
Carbon steel 11 109.0		

FIGURE 3 - WELD-ON SLEEVE WITH CAP NUT AND SEALING

CODE	THREAD OF CAP NUT	MATERIAL	DIMENSIONAL DRAWING
NA1	M20x1.5	Carbon steel	
NAG1	G1/2	11 523	
NA2	M20x1.5	Stainless steel	
NAG2	G1/2	1.4541	
NA3	M20x1.5	Creep-resisting steel	
NAG3	G1/2	15 128	
NA4	M20x1.5	Carbon steel	
NAG4	G1/2	11 523	
NA5	M20x1.5	Stainless steel	
NAG5	G1/2	1.4541	
NA6	M20x1.5	Creep-resisting steel	
NAG6	G1/2	15 128	

The sleeve is delivered by 1 piece together with the relevant cap nut and with aluminium sealing.
After putting the cap nut on the sleeve and welding the sleeve on the piping, the armature provided with the corresponding screw joint for the sleeve according to the dimensional drawing of the screw joint can be attached to the piping.

CAP NUT FOR WELD-ON SLEEVE

MATERIAL OF NUT	DIMENSIONAL DRAWING OF NUT	DIMENSIONAL DRAWING OF SCREW JOINT
Stainless steel 1.4541		
Carbon steel 11 109.0 (only for NA1, NAG1, NA4 and NAG4)		

SEALING RINGS FOR WELD-ON SLEEVE

They can also be ordered independently from other materials pursuant to the ordering numbers specified below:

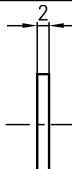
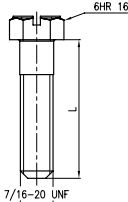
ORDERING NUMBER SEALING	MATERIAL	DIMENSIONAL DRAWING
382 041	Al EN AW-1050A	
382 063	Steel 1.4541	
382 096	Steel 1.4404	
276 067	Cu 42 3005	

FIGURE 4 - SCREW WITH HEXAGON HEAD 7/16-20 UNF

for the connection of the valve unit to the flange of the pressure difference sensor

CODE	MATERIAL	LENGTH "L"	FLANGE	DIMENSIONAL DRAWING
SR2	Alloy steel 15 230	47 mm	Conventional	
SR3		75 mm	Coplanar	
SR4	Stainless steel A2 (AISI 304)	47 mm	Conventional	
SR5		75 mm	Coplanar	

Delivery: 4 pcs

FIGURE 5 - DRAIN PIPING FOR VALVE SET

CODE	APPLICATION AND INSTALLATION					DIMENSIONAL DRAWING	
ODP2	Drain piping is designed for the installation to the five-way set 964. Installation procedure: 1. Grease the thread M12 × 1.5 with grease for high temperatures. 2. Insert sealing rings according to the medium temperature into the sealing grooves of the drain piping and slide the piping on the drain screw. 3. Screw the drain screw into the valve set and tighten with torque of 9 Nm.						
	Position	Part	Material	Dimension of ring	No. of pcs in packing		Ordering number of spare rings
	1	Drain piping	Steel 1.4541		1		
	2	Drain screw	Steel 1.4541		1		
	3	Sealing ring for temperatures to 200°C	PTFE	18x14x2	1		479820
	4			18x12x2	1		479842
5	Sealing ring for temperatures to 450°C	Board HD-U	18x14x2	1	495297		
6			18x12x2	1	495308		
ODP1 ¹⁾	Drain piping is designed for the installation to the five-way set 964. Installation procedure: 1. Screw the drain reduction into the drain hole of the set (wind up sealing tape PTFE on the thread 1/4-18 NPT before screwing or, in case of temperatures exceeding 200°C, apply grease for high temperatures). Torque is 28 Nm. 2. Insert sealing rings according to the medium temperature into the sealing grooves of the drain piping and slide the piping on the reduction. 3. Screw the drain screw into the reduction and tighten with torque of 9 Nm.						
	Position	Part	Material	No. of pcs in packing	Ordering number of spare rings		
	1	Drain piping	Steel 1.4541		2		
	2	Drain screw	Steel 1.4541		2		
	3	Sealing ring 18x14x2 for temperatures to 200°C	PTFE		4		479820
	4	Sealing ring 18x14x2 for temperatures to 450°C	Board HD-U		4		495297
5	Drain reduction	Steel 1.4541		2			

¹⁾ Do not use for new structures (only upon special request).

The complete drain piping is delivered with the parts specified in the Table. Sealing rings can also be delivered as spare parts under the specified ordering numbers. In such a case you need to specify the required number of pieces of rings.

FIGURE 6 - ANGULAR SCREW JOINT SA4

CODE	APPLICATION	DIMENSIONAL DRAWING
SA4	The adjustable angular screw joint enables discretionary rotation of the body with weld-on terminal for a threaded ring on a tube with Ø 10 mm. After an agreement with the manufacturer, it can be delivered with threaded rings of different dimensions or with a different terminal.	

FIGURE 7 - COUPLING SA5

CODE	APPLICATION	DIMENSIONAL DRAWING
SA5	The coupling enables to connect the armature with internal thread G1/4 and a tube with \varnothing 10 mm by means of a threaded ring.	

FIGURE 8 - SCREW JOINT SA6, SA7, SA8

CODE	APPLICATION	DIMENSIONAL DRAWING
SA6	The screw joint enables to connect an armature with internal thread G1/4 and a tube with \varnothing 10 mm, which is welded.	<p>TĚSNĚNÍ = Sealing Šroubení (OK22)=Screw joint</p>
SA7		<p>TĚSNĚNÍ = Sealing Šroubení (OK22)=Screw joint</p>
SA8		<p>TĚSNĚNÍ = Sealing Šroubení (OK22)=Screw joint</p>

FIGURE 9 - PUT-ON CONTROL HANDLE

CODE	APPLICATION	DRAWING
KL1	The handle is used to control valve units of armatures (964, 967) in case of application for high temperatures of the medium (over 200 °C). It is inserted on the standard handle of the valve unit. It is delivered in a PE bag and is packed by 1 pc.	

FIGURE 10 - HOLDER FOR INSTALLATION OF VALVE SETS

The holder is made of galvanized carbon steel 11 320 and is delivered together with two screws, which are used to attach the holder to the body of the unit.

CODE	APPLICATION	DIMENSIONAL DRAWING
B3	The holder is delivered as default together with the valve set 964 and 984 in the design for the assembly between impulse piping.	

B4	<p>The holder is delivered if it has been required in the purchase order. It is used e.g. when replacing the old Bulgarian sets.</p>	
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FIGURE 11 - INTERCONNECTING PIECE FOR CASCADE CONNECTION OF PRESSURE DIFFERENCE SENSORS
The interconnecting piece is used to interconnect two pressure difference sensors (type 114 51) with a traditional flange. It is delivered in a box, packed by 2 pieces (to interconnect two pressure difference sensors) together with 4 sealing O-rings, the material of which can be selected, and eight screws, which are used to screw both elements to the sensor flanges.

CODE	MATERIAL OF O-RINGS	DRAWING
H1	FPM (-20 to +250°C)	
H2	NBR (-30 to +125°C)	
H3	EPDM (-45 to +110°C)	

FIGURE 12 - QUICK COUPLING EMA3

CODE	APPLICATION	DRAWING
EMA3	<p>The quick-coupling is used to connect and disconnect measurement and extraction places with the internal thread 1/4 - 18NPT in a fast and simple way. The sensor thread is M16x2. The quick-coupling is made of stainless material 1.4571.</p>	

FIGURE 13 - MANOMETRIC SHOCK ABSORBER

CODE	APPLICATION AND INSTALLATION	DRAWING
TL1	<p>The shock absorber is used to decrease pressure surges in the impulse piping. It is made of stainless steel 1.4541. Its internal thread is used to connect a pressure sensor or a manometric valve. The impulse piping is connected to the external thread by means of sealing and a sleeve with a cap nut. It is only designed for clean media. During the installation and uninstallation of the shock absorber to the sensor (to the piping), the shock absorber shall be kept with a wrench in the area of the hexagon that is closer to the sensor (to the piping). During the installation and the operation, it shall be ensured that no mechanical impurities could enter the shock absorber.</p>	

FIGURE 14 - MANOMETRIC PLUG

The plugs are made of stainless steel 1.4541.

CODE	APPLICATION	DIMENSIONAL DRAWING
TZ1	<p>The plug can be used to blind the holes in the flanges of the pressure and pressure difference sensors, valve sets or valves with a corresponding thread.</p>	
TZ2	<p>The plug with venting can be used in flanges of the pressure and pressure difference sensors, valve sets or valves with a corresponding thread.</p>	

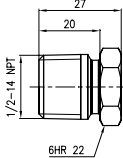
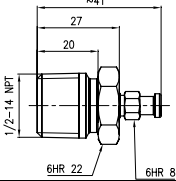
TZ3	The plug can be used to blind the holes in the adapters of the pressure and pressure difference sensors, valve sets or valves with a corresponding thread.	
TZ4	The plug with venting can be used in adapters of the pressure and pressure difference sensors, valve sets or valves with a corresponding thread.	

FIGURE 15 - MANOMETRIC SLEEVE CONNECTION

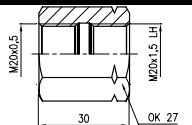
CODE	MATERIAL	DIMENSIONAL DRAWING
NP1	Stainless steel 1.4541	
NP2	Galvanized carbon steel 11 109	

FIGURE 16 - MANOMETRIC REDUCTION

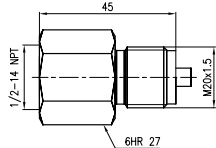
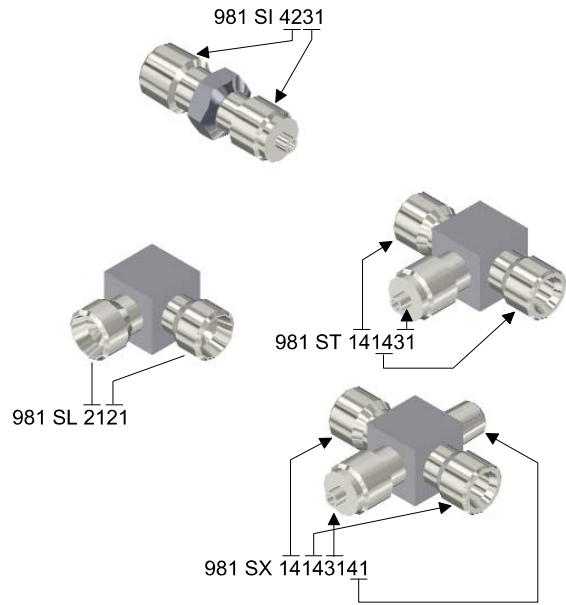
CODE	APPLICATION	DIMENSIONAL DRAWING
TR3	It is mostly used to connect the manometer with the thread NPT to the sleeve with a nut M20x1.5 Material : stainless steel 1.4541	

FIGURE 17 - COUPLINGS

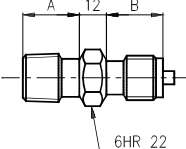
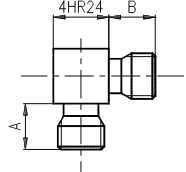
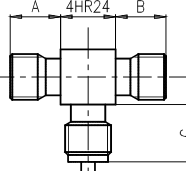
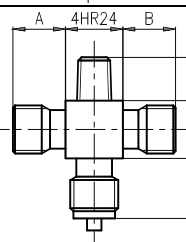
The couplings are designed for the interconnection of the impulse piping or for the connection of the impulse piping to other armatures and devices (valve, pressure sensor, etc.) and for other applications.

The coupling consists of the coupling body and terminals pursuant to Figure 18. Material : stainless steel 1.4541.

In case of a requirement for the special design with purity of internal surfaces of grade I pursuant to TPE 10-40/1926/85, specify the code PC1 behind the ordering number.



Examples of coupling designs and their specification:

CODE	DIMENSIONAL DRAWING	PURCHASE ORDER EXAMPLE
SI aabb		1 pc coupling 981 SI 4231
SL aabb		1 pc coupling 981 SL 2121
ST aabbcc		1 pc coupling 981 ST 141431
SX aabbccdd		1 pc coupling 981 SX 14143141

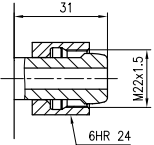
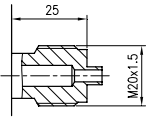
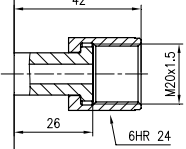
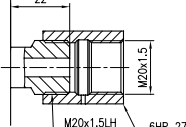
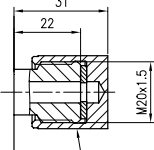
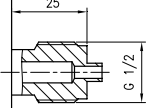
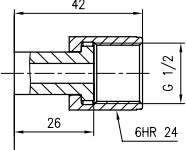
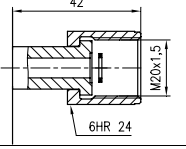
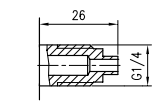
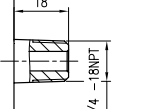
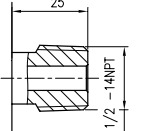
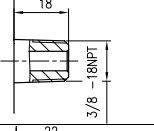
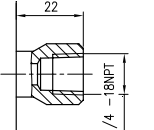
Note:

Characters aa, bb, cc, dd represent codes of weld-on terminals, the dimensions of which (A, B, C, D) are specified in Figure 18 - Connecting terminals. From this table, terminals with the following codes can be chosen for the couplings: 11, 12, 13, 14, 15, 16, 17, 18, 19, 21, 22, 31, 32, 33, 34, 35, 36, 37, 38, 41, 42, 43, 51, 61 and 63 (code 52 only after an agreement with the manufacturer).

FIGURE 18 - CONNECTING TERMINALS

The tables specify various types of connecting terminals, which can be chosen for valves, valve sets, couplings and other armatures. A two-digit code is specified for each type of the terminal in addition to its dimensional drawing, description and installation procedure. This code shall be specified in the relevant place of the ordering number of the armature. Along with the weld-on terminal, the relevant number of cap nuts, sealing, plugs, threaded rings, which are illustrated in the dimensional drawing, will be delivered according to its type for the armature.

CODE	DRAWING	INSTALLATION PROCEDURE OF CONNECTING TERMINALS WITH THREADED RINGS																																								
11		<p>By means of a cap nut and two rings, stainless or carbon steel tube (pursuant to ČSN 42 6711 and ČSN 42 6750) with the diameter 6, 8, 10, 12, 14, 16, 18, 20 and 22 mm with tolerance of the outer diameter of ± 0.3 mm can be connected in a way that enables further dismantling..</p> <p>FIRST INSTALLATION:</p> <ol style="list-style-type: none"> Put a cap nut, rear (cylindrical) ring and front (conical) ring – ensure correct orientation! – on the straight-cut end of the tube that is free of burrs. To ensure correct function, it is necessary to maintain the layer of grease applied by the manufacturer on the conical sealing surface, rear ring and threads! Insert the end of the tube with rings up to the bottom of the connecting sleeve and tighten the cap nut by hand. By means of the torque wrench tighten the cap nut with the torque according to the following table: <table border="1"> <thead> <tr> <th>Tube diameter [mm]</th> <th>6</th> <th>8</th> <th>10</th> <th>12</th> <th>14</th> <th>16</th> <th>18</th> <th>20</th> <th>22</th> </tr> </thead> <tbody> <tr> <th>Torque [Nm]</th> <td>30</td> <td>40</td> <td>50</td> <td>55</td> <td>65</td> <td>75</td> <td>85</td> <td>90</td> <td>100</td> </tr> </tbody> </table> <ol style="list-style-type: none"> If the medium pressure exceeds 20 MPa, the nut shall be tightened again after the first trial pressurisation <u>after pressure has been discharged from the system.</u> <p>UNINSTALLATION + REPEATED INSTALLATION:</p> <ol style="list-style-type: none"> The uninstallation shall be realized by complete unscrewing of the cap nut <u>after pressure has been completely discharged from the system.</u> Before repeated installation, check cleanness of the tube, threads and all sealing surfaces and pay attention to any possible damage. Rotation of the front threaded ring on the tube is not a defect! To ensure correct function, it is necessary to maintain the layer of grease applied by the manufacturer on the conical sealing surface, rear ring and threads; otherwise, they shall be greased again. If required, this original grease can be ordered at the manufacturer of the armatures. Realize the installation by inserting the end of the tube with rings and cap nut up to the bottom of the connecting sleeve. Tighten the cap nut by hand. By means of a torque wrench, tighten the cap nut by torque pursuant to the following table: <table border="1"> <thead> <tr> <th>Tube diameter [mm]</th> <th>6</th> <th>8</th> <th>10</th> <th>12</th> <th>14</th> <th>16</th> <th>18</th> <th>20</th> <th>22</th> </tr> </thead> <tbody> <tr> <th>Torque [Nm]</th> <td>25</td> <td>35</td> <td>40</td> <td>50</td> <td>55</td> <td>65</td> <td>70</td> <td>80</td> <td>85</td> </tr> </tbody> </table> <p>WARNING: THE CAP NUT MAY NEVER BE TIGHTENED (RELEASED) UNDER PRESSURE – it could cause lethal injury!!! Failure to comply with the aforesaid torque (i.e. insufficient or excessive tightening of the cap nut) during the installation and with the minimum straight part of the tube from its end results in decreasing resistance of the connection to pressures and vibrations, which could finally result in leakage of the connection. If vibrations of the piping system could occur, the armature to be connected shall be fixed by means of a suitable holder and the connecting piping shall be attached in certain distances by tube fittings.</p> <div style="display: flex; justify-content: space-around; align-items: center;"> <div style="text-align: center;"> <p>CAP NUT CONNECTING SLEEVE FRONT RING REAR RING</p> </div> <div style="text-align: center;"> <p>THE TUBE TO BE CONNECTED SHALL BE FULLY SLID UP TO THE BOTTOM OF THE SLEEVE</p> <p>min.40 MINIMUM LENGTH OF DIRECT PART OF TUBE</p> </div> </div>	Tube diameter [mm]	6	8	10	12	14	16	18	20	22	Torque [Nm]	30	40	50	55	65	75	85	90	100	Tube diameter [mm]	6	8	10	12	14	16	18	20	22	Torque [Nm]	25	35	40	50	55	65	70	80	85
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21		<p style="text-align: center;">SCREW JOINT FOR CONE</p> <ol style="list-style-type: none"> Put a cap nut on the cone Weld the cone on the end of tube Screw the tube to the sleeve with a nut and tighten with torque of 120 Nm. 																																								
22		<p style="text-align: center;">WELD-ON CONE WITH CAP NUT M20x1.5</p> <p>By means of a nut, screw the armature to the screw joint for a cone, which forms a part of e.g. a condensation tank, another valve, etc., and tighten with torque of 120 Nm.</p>																																								

23		<p>WELD-ON CONE WITH CAP NUT M22x1.5</p> <p>By means of a nut, screw the armature to the screw joint for a cone with the relevant thread, which forms a part of e.g. a piping, and tighten with torque of 150 Nm.</p>
CODE	DRAWING	DESCRIPTION AND INSTALLATION PROCEDURE
31		<p>MANOMETRIC SCREW JOINT M20x1.5</p> <ol style="list-style-type: none"> 1. Put a cap nut on the sleeve 2. Weld the sleeve on the end of tube 3. Put a metal sealing on the screw joint 4. Screw the piping to the screw joint by means of a nut and tighten with torque of 120 Nm.
32		<p>WELD-ON SLEEVE WITH CAP NUT M20x1.5</p> <p>By means of a nut, screw the armature to the manometric screw joint with the relevant thread and tighten with torque of 120 Nm.</p>
33		<p>MANOMETRIC SCREW JOINT M20x1.5 LH</p> <p>The screw joint is used to connect the manometer or valve with manometric screw joint M20x1.5</p> <ol style="list-style-type: none"> 1. Put a metal sealing on the screw joint of the manometer 2. Screw the manometer and the armature together with the use of a sleeve coupling (delivered with the armature), which is tightened by torque of approx. 120 Nm.
34		<p>TEST SCREW JOINT M20x1.5</p> <p>The screw joint is used to connect control manometer. It is delivered including the plug with sealing. Recommended torque is 120 Nm.</p>
35		<p>MANOMETRIC SCREW JOINT G1/2</p> <ol style="list-style-type: none"> 1. Put a cap nut on the sleeve 2. Weld the sleeve on the end of tube 3. Put a metal sealing on the screw joint 4. Screw the piping to the screw joint by means of a nut and tighten with torque of 120 Nm.
36		<p>WELD-ON SLEEVE WITH CAP NUT G1/2</p> <p>By means of a nut, screw the armature to the manometric screw joint with the relevant thread and tighten with torque of 120 Nm.</p>
37		<p>WELD-ON SLEEVE WITH CAP NUT M20x1.5 WITH SEALING PURSUANT TO STANDARD SHELL</p> <p>By means of a nut, screw the armature to the manometric screw joint and tighten with torque of 120 Nm. The sealing is ensured by stainless sealing ring made of soft steel.</p>
38		<p>MANOMETRIC SCREW JOINT G1/4</p> <ol style="list-style-type: none"> 1. Put a cap nut on the sleeve 2. Weld the sleeve on the end of tube 3. Put a metal sealing on the screw joint 4. Screw the piping to the screw joint by means of a nut and tighten with torque of 120 Nm.
41		<p>EXTERNAL THREAD 1/4 - 18 NPT</p> <ol style="list-style-type: none"> 1. Wind up sealing tape of PTFE on the thread. 2. Screw the armature into the hole with corresponding internal thread and tighten with torque of 28 Nm.
42		<p>EXTERNAL THREAD 1/2 - 14 NPT</p> <ol style="list-style-type: none"> 1. Wind up sealing tape of PTFE on the thread. 2. Screw the armature into the hole with corresponding internal thread and tighten with torque of 60 Nm.
43		<p>EXTERNAL THREAD 3/8 - 18 NPT</p> <ol style="list-style-type: none"> 1. Wind up sealing tape of PTFE on the thread. 2. Screw the armature into the hole with corresponding internal thread and tighten with torque of 45 Nm.
51		<p>INTERNAL THREAD 1/4 - 18 NPT</p> <p>The thread is cut in the weld-on terminal; only the valve 967 with internal threads has a thread cut directly into the basic body.</p> <ol style="list-style-type: none"> 1. Wind up sealing tape of PTFE on the corresponding external thread. 2. Tighten the screw joint with torque of 28 Nm.

52		<p style="text-align: center;">INTERNAL THREAD 1/2 - 14 NPT</p> <p>The thread is cut directly in the basic body.</p> <ol style="list-style-type: none"> 1. Wind up sealing tape of PTFE on the corresponding external thread. 2. Screw the screw joint or tube into the hole in the armature and tighten with torque of 60 Nm.
53		<p style="text-align: center;">INTERNAL THREAD 1/2 - 14 NPT</p> <p>The thread is cut in the weld-on terminal. This terminal is only used for 9642553AS2 or 9642553AS21.</p> <ol style="list-style-type: none"> 1. Wind up sealing tape of PTFE on the corresponding external thread. 2. Screw the screw joint or tube into the hole in the armature and tighten with torque of 60 Nm.
CODE	DRAWING	INSTALLATION PROCEDURE OF CONNECTION OF TERMINALS WITH THREADED RINGS
54		<p style="text-align: center;">INTERNAL THREAD 1/2 - 14 NPT</p> <p>The thread is cut in the weld-on terminal. This terminal is only used for 96443xx, 96444xx or 96445xx.</p> <ol style="list-style-type: none"> 1. Wind up sealing tape of PTFE on the corresponding external thread. 2. Screw the screw joint or tube into the hole in the armature and tighten with torque of 60 Nm.
61		<p style="text-align: center;">EXTERNAL THREAD G1/4</p> <p>Wind up sealing tape of PTFE on the thread. Tighten the screw joint with torque OF 35 Nm.</p>
63		<p style="text-align: center;">EXTERNAL THREAD G3/8</p> <p>Wind up sealing tape of PTFE on the thread. Tighten the screw joint with torque of 80 Nm.</p>

INSTALLATION AND CONNECTION

Installation and uninstallation of the screw joint, type of line 981, for selected equipment pursuant to the Decree No. 214/1997 Coll., their operation and maintenance may only be realized by a bearer of the AUTHORIZATION, which is issued by the manufacturer of the armatures on the basis of a completed training.

Installation and connection of the accessories are provided at the relevant Figures 1 to 18.

SPARE PARTS

Accessories may be delivered as spare parts.

WARRANTY

The warranty shall apply to the accessories in a set with the armature pursuant to the manual for the armature.

REPAIRS

Accessories are not repaired.

DISABLING AND LIQUIDATION

They shall be realized in compliance with the Waste Act No. 106/2005 Coll.

The product and its package do not include any parts that could impact the environment.

The products withdrawn from the operation (including their packing) may be disposed of to sorted or unsorted waste pursuant to the type of waste.

The package of the product can be recycled completely. Metal parts of the product shall be recycled, non-recyclable plastic materials shall be disposed of in compliance with the aforesaid Act.



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