

Single ferrule compression fitting **Range 54**



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Safety Information:

- Do not bleed the system by loosening the compression fitting's nut or cap.
- Do not assemble or tighten single ferrule compression fittings when your system is pressurised.
- Check that the pipe is correctly positioned against the bottom of the hole in the compression fitting's body before you tighten the nut.
- Do not mix materials or single ferrule compression fitting parts (ferrules, nuts or compression fitting bodies) made by different manufacturers.
- You should only use them with seamless pipes with D4/T3 dimensional tolerance.
- Do not disassemble single ferrule compression fittings unless you are going to assemble them onto piping.
- Follow the installation instructions, in particular for the number of nut tightening turns.
Do not over tighten the compression fitting's nut, as this will not improve the compression fitting's sealing and could instead reduce its nominal pressure. It could also cause fatigue in the ferrule material and make it difficult to disassemble the single ferrule compression fitting.
- Use a manual preswaging tool to make sure that the assembly of the single ferrule compression fitting is sealed and secure on the piping.

Installation instructions:

You can install single ferrule compression fittings for pipes quickly, easily and completely reliably using hand tools.

Pipe preparation

1. Cut the pipe square, the acceptable tolerance is 90 ± 0.5 . You should not use a pipe cutter.
Deburr the ends of the pipe on its internal AND external surfaces.
2. Check the pipe: it must be clean, without any burrs and it must not be deformed or have any oval distortion defects.



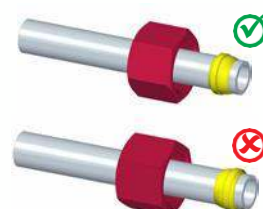
Ferrule preswaging

1. You should apply a small amount of lubricant onto all of the threads on the compression fitting's nut, the preswaging tool and the compression fitting itself. You should also lightly grease the 24 tapered parts of the preswaging tool and the compression fitting as well as the crimping ferrule to make it easier to tighten it and to avoid seizing.

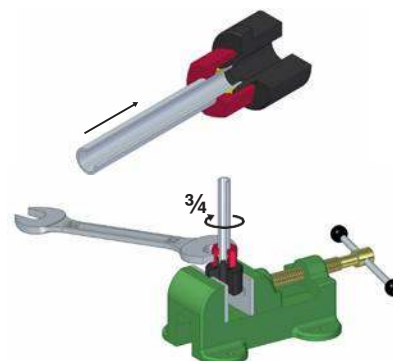


2. Place the preswaging tool in a clamp. Make sure you have chosen the diameter adapted to your piping.

3. Slide the nut and the ferrule onto the pipe, as shown in the diagram to the right.
The cutting edge of the ferrule must be facing towards the open end of the pipe.



4. Assemble the pipe on the ferrule side with the preswaging tool. Keep the pipe up against the 24 cone.
Tighten the nut by hand on to the tool until the ferrule is in contact with the pipe. You will then feel a strong increase in tightening torque.

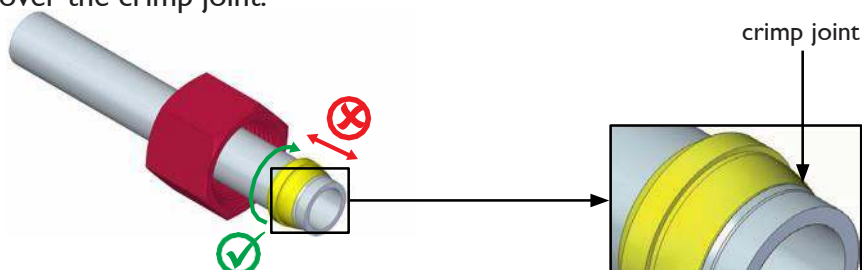


5. Once the ferrule is in contact with the pipe, tighten the nut 1/2 of a turn.

Visual inspection

1. Loosen the nut from the assembly.

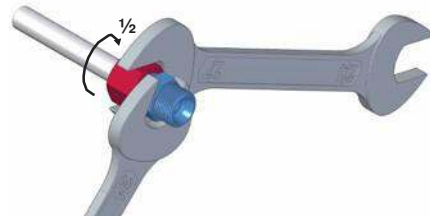
2. Check that there is a crimp joint around the whole of the pipe's circumference, this will show that the ferrule's cutting edge has penetrated the pipe correctly.
You will be able to rotate the ferrule around the pipe but you should not be able to move it forwards or backwards over the crimp joint.



Final assembly

Tighten the nut until you cannot tighten it any further, you will feel a strong increase in tightening torque.

Then, tighten the nut an additional $\frac{1}{2}$ turn, making sure that the single ferrule compression fitting assembly does not move.



Do not over tighten (or under tighten) the compression fitting's nut as this will not improve the compression fitting's sealing and could instead reduce its nominal pressure.

Disassembly and reassembly



Do not disassemble a single ferrule compression fitting when your system is pressurised. You cannot disassemble and reassemble this assembly more than 10 times.

1. You should grease the single ferrule compression fitting's threads every time you disassemble it.
2. When you reassemble the compression fitting, tighten it until it cannot be tightened any further. Use a wrench extender if necessary.

Minimum length of the straight part of a pipe with a bend

You must make sure that the straight part of the pipe, measured from its end to the start of its curve radius, is at least two times the length of the nut.

