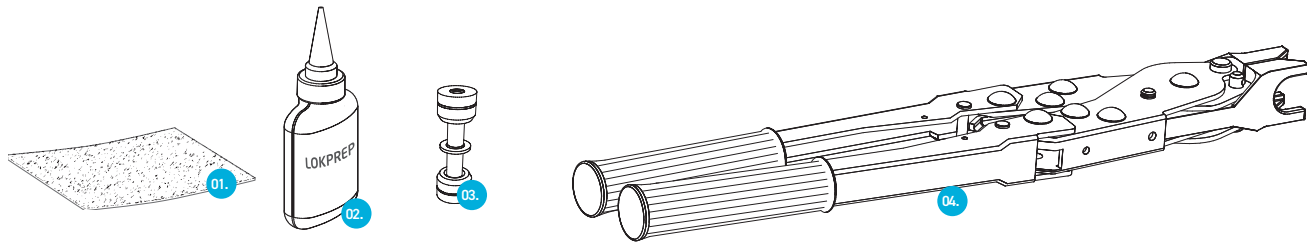


# ASSEMBLY INSTRUCTIONS

## LOKRING® tube connection assembly version 00

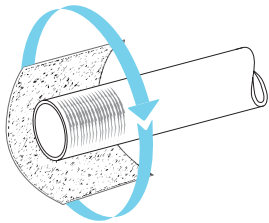
(The assembly version is determined on the basis of the last two figures in the article name. **Example:** LOKRING 6 NK Ms 00)

# VULKAN

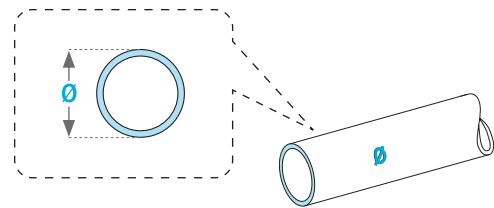


01. Emery cloth 02. LOKPREP 65G 03. LOKRING connector 04. Hand assembly tool

**!** Clean the tube ends in a rotational motion to ensure that they are clean and free from paint or other surface impurities.

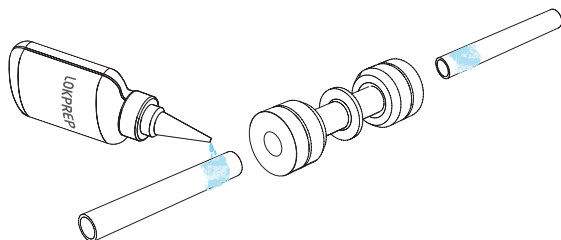


**!** Determine the outer tube diameter  $\varnothing$  using a digital caliper.

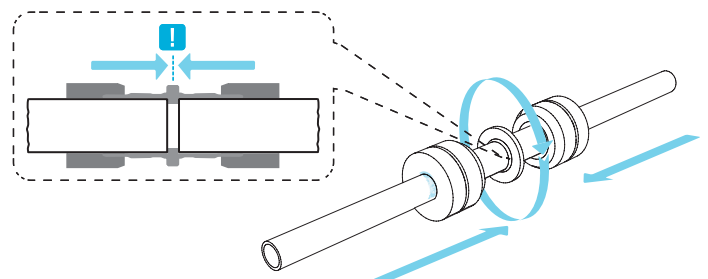


$\varnothing$  = outer tube diameter

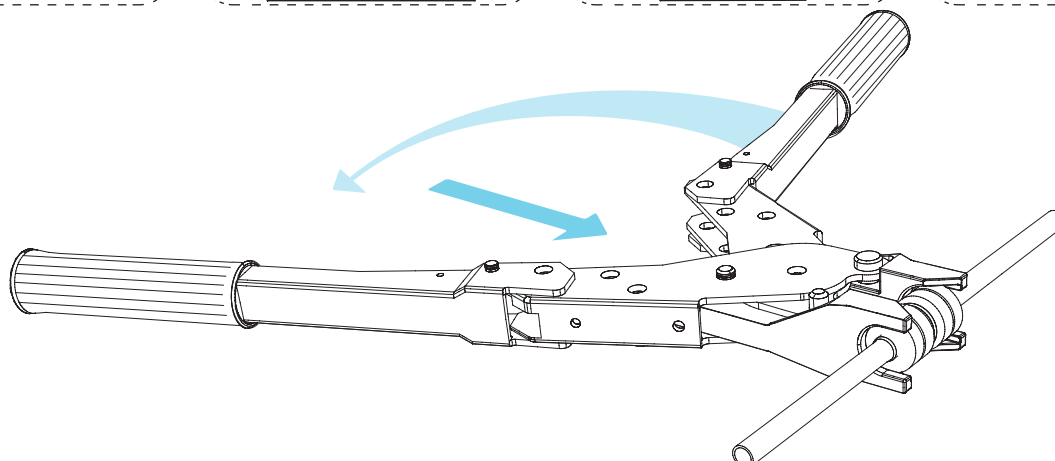
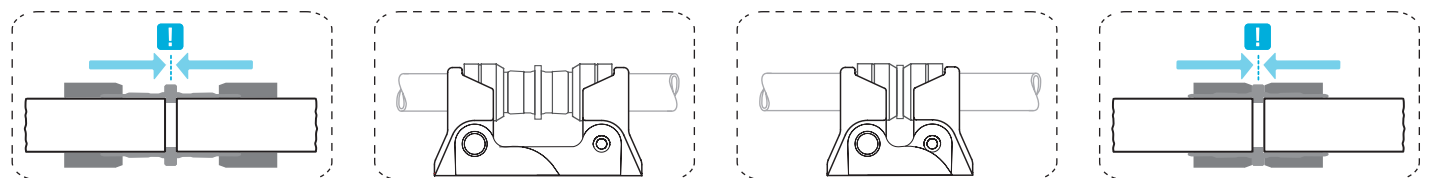
**1** Apply LOKPREP 65G (02) onto the tube ends.



**2** Insert both tube ends into the LOKRING connector (03) until the tubes reach the inner stop **1**. Rotate the LOKRING connector (03) through 360° to distribute the LOKPREP 65G (02) evenly. Respect the correct curing time of the LOKPREP 65G (02).



**3** Position the jaws of the hand assembly tool (04) squarely onto the rings of the LOKRING connector (03). **!** In a controlled manner use the hand assembly tool (04) to press the rings onto the connector ensuring that the tubes remain seated against the centre stop of the LOKRING connector (03) throughout this process. Once both rings are flush to the centre stop of the connector the joint is complete. Carefully remove the hand assembly tool (04) from the LOKRING connector (03).



# EXAMPLES AS ASSEMBLY AID

LOKRING® tube connection assembly version 00

**!** **Wrong:** Rings have not been pressed through to the assembly stop.

**Right:** Rings have been pressed flush to the assembly stop.

**!** **Wrong:** The bending point is too close to the joint end.

**Right:** The tube has to be led straightly out of the joint.

**!** **Wrong:** Assembly jaws are not set in place correctly.

**Right:** Assembly jaws are set flush correctly.

**!** **Wrong:** The tube is not pushed in as far as the inner stop.

**Right:** Push the tube in until you can feel the inner stop.

# CURING TIME OF LOKPREP 65G

LOKRING® tube connection assembly version 00

