

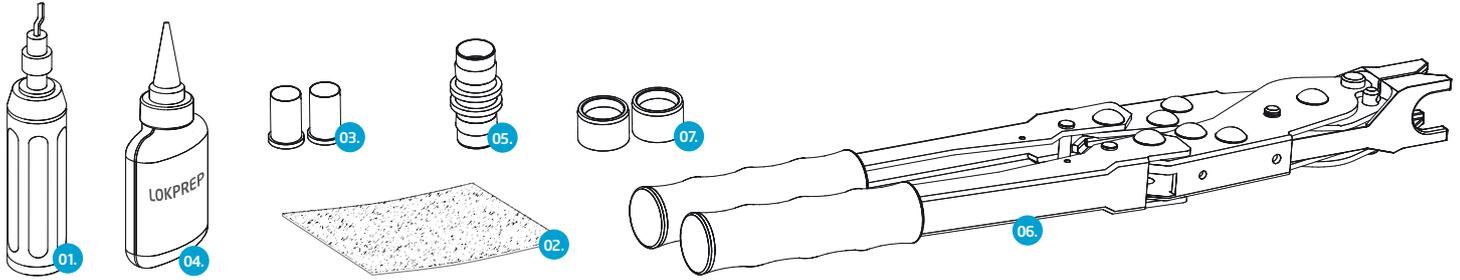


ASSEMBLY INSTRUCTIONS

Lokring tube connection assembly version Ms 50

(The assembly version is determined on the basis of the last two figures in the article name. **Example:** LOKRING 6 NK Ms 50)

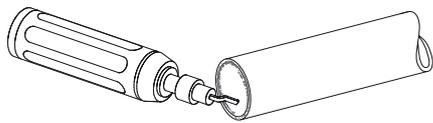
VULKAN LOKRING



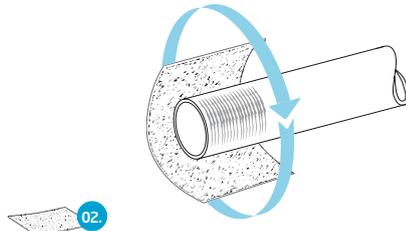
01. Tube deburrer **02.** Abrasive mat **03.** Stabilisation inserts **04.** LOKPREP **05.** Joint **06.** Hand assembly tool **07.** LOKRINGS



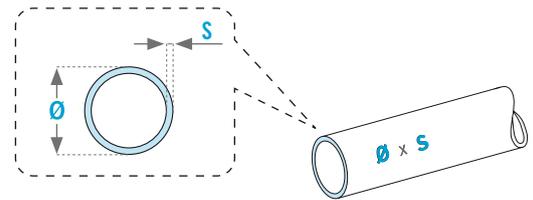
Deburr the tube end all the way round using a tube deburrer (01).



Clean the tube end by rubbing it in rotary movements using the abrasive mat (02).

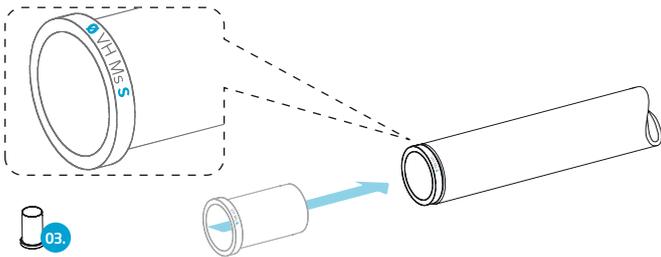


Determine the tube wall thickness S and the outer tube diameter \emptyset on the basis of tube coding or using a slide gauge.

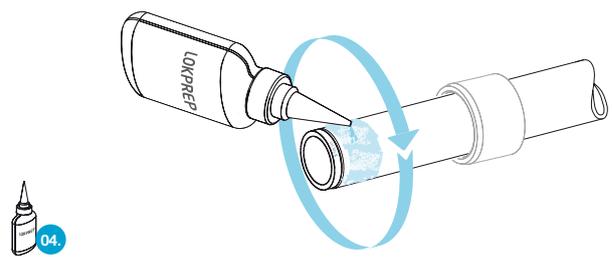


\emptyset = outer tube diameter S = tube wall thickness

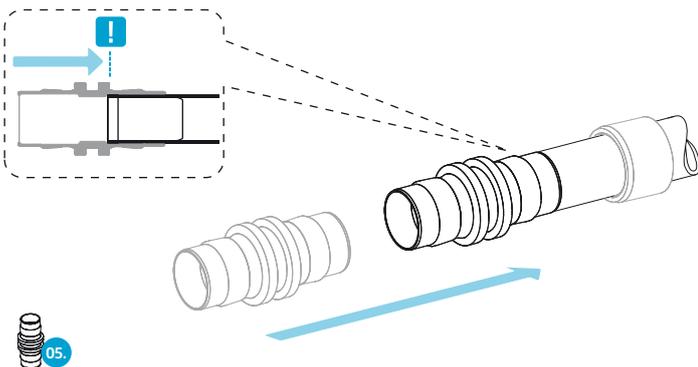
1 Insert a stabilisation insert (03) suitable for the outer tube diameter \emptyset and tube wall thickness S .



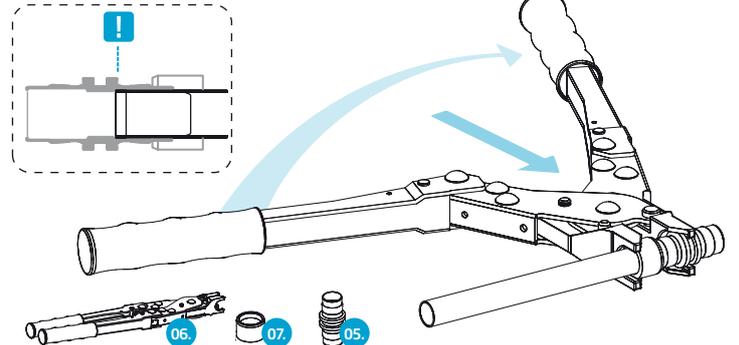
2 Apply LOKPREP (04) all the way round the sealing area of the tube end.



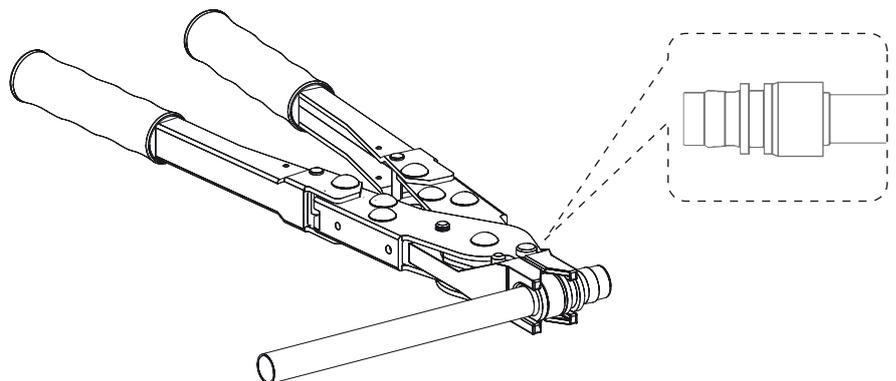
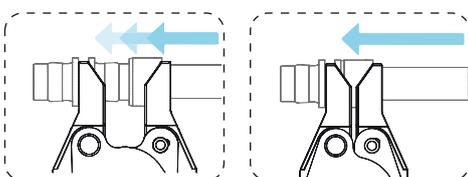
3 Push the connection joint (05) onto the tube until it reaches the inner stop **1**.



4 Put the assembly jaws (06) in place behind LOKRING (07) and the assembly stop of the joint (05). Press the tube connection together. **1** Do not change the insertion depth of the tube and connecting joint.

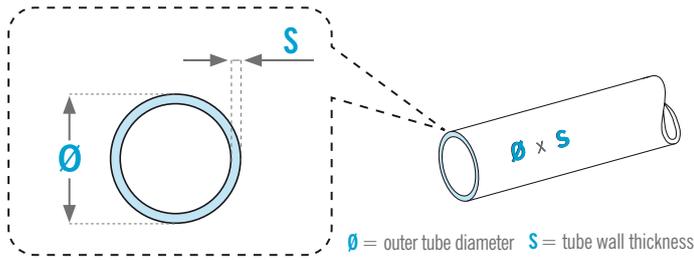


5 Press the tube connection until LOKRING (07) is flush to the assembly stop of the joint (05).



CHOOSING THE STABILISATION INSERT

Lokring tube connection assembly version Ms 50



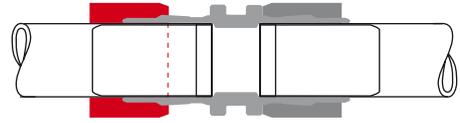
EXAMPLES AS ASSEMBLY AID

Lokring tube connection assembly version Ms 50



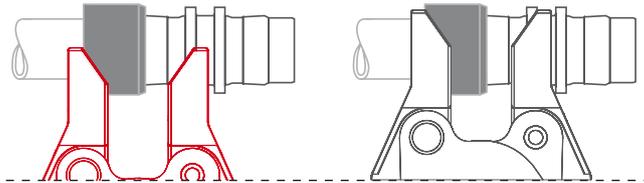
Wrong: LOKRING has not been pressed through to the assembly stop.

Right: LOKRING has been pressed flush to the assembly stop.



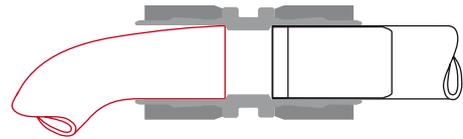
Wrong: Assembly jaws not set in place correctly.

Right: Assembly jaws set flush correctly.



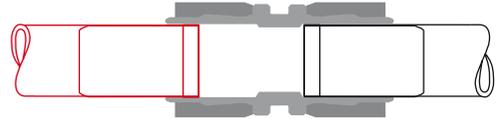
Wrong: Stabilisation insert is missing.

Right: Correct stabilisation insert is inserted.



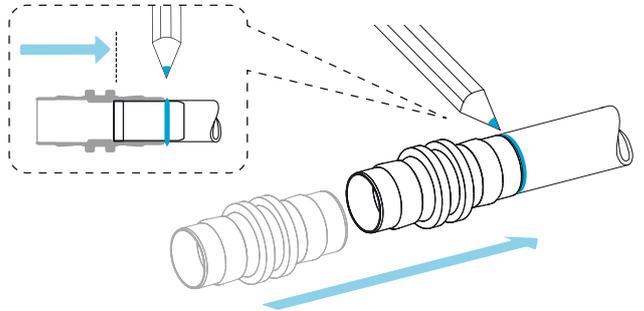
Wrong: The tube is not pushed in as far as the inner stop.

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



Important help when LOKRINGS are not pre-assembled:

Before applying the LOKPREP 2, push the connecting joint onto the tube until you can feel the inner stop. Mark the correct insertion depth on the tube.



After assembly 5, check the correct assembly/insertion depth on the basis of the position marking.

Ø		S	Article name	
[mm]	inch]	[mm]		
6	-	0,8	LOKin 6	VH MS 08
6	-	1,0	LOKin 6	VH MS 10
6,35	1/4	0,7	LOKin 6,35	VH Ms 07
6,35	1/4	0,8	LOKin 6,35	VH MS 08
6,35	1/4	0,9	LOKin 6,35	VH MS 09
6,35	1/4	1,0	LOKin 6,35	VH MS 10
8	-	0,8	LOKin 8	VH MS 08
8	-	1,0	LOKin 8	VH MS 10
9,53	3/8	0,7	LOKin 9,53	VH Ms 07
9,53	3/8	0,8	LOKin 9,53	VH MS 08
9,53	3/8	0,9	LOKin 9,53	VH MS 09
9,53	3/8	1,0	LOKin 9,53	VH MS 10
10	-	0,8	LOKin 10	VH MS 08
10	-	1,0	LOKin 10	VH MS 10
12	-	0,9	LOKin 12	VH MS 09
12	-	1,0	LOKin 12	VH MS 10
12,7	1/2	0,7	LOKin 12,7	VH Ms 07
12,7	1/2	0,8	LOKin 12,7	VH MS 08
12,7	1/2	0,9	LOKin 12,7	VH MS 09
12,7	1/2	1,0	LOKin 12,7	VH MS 10
12,7	1/2	1,2	LOKin 12,7	VH MS 12
12,7	1/2	1,6	LOKin 12,7	VH MS 16
15	-	1,0	LOKin 15	VH MS 10
16	5/8	0,8	LOKin 16	VH MS 08
16	5/8	0,9	LOKin 16	VH MS 09
16	5/8	1,0	LOKin 16	VH MS 10
16	5/8	1,1	LOKin 16	VH MS 11
16	5/8	1,2	LOKin 16	VH MS 12
16	5/8	1,6	LOKin 16	VH MS 16
18	-	1,0	LOKin 18	VH MS 10
18	-	1,2	LOKin 18	VH MS 12
19	3/4	0,9	LOKin 19	VH MS 09
19	3/4	1,0	LOKin 19	VH MS 10
19	3/4	1,1	LOKin 19	VH MS 11
19	3/4	1,2	LOKin 19	VH MS 12
19	3/4	1,6	LOKin 19	VH MS 16
20	-	1,0	LOKin 20	VH MS 10
22	7/8	0,9	LOKin 22	VH MS 09
22	7/8	1,0	LOKin 22	VH MS 10
22	7/8	1,1	LOKin 22	VH MS 11
22	7/8	1,2	LOKin 22	VH MS 12
22	7/8	1,4	LOKin 22	VH MS 14
22	7/8	1,6	LOKin 22	VH MS 16
25,4	1	0,9	LOKin 25,4	VH MS 09
25,4	1	1,0	LOKin 25,4	VH MS 10
25,4	1	1,2	LOKin 25,4	VH MS 12
28	-	1,0	LOKin 28	VH MS 10
28	-	1,2	LOKin 28	VH MS 12
28	-	1,5	LOKin 28	VH MS 15
28,6	11/8	0,9	LOKin 28,6	VH MS 09
28,6	11/8	1,0	LOKin 28,6	VH MS 10
28,6	11/8	1,2	LOKin 28,6	VH MS 12
28,6	11/8	1,6	LOKin 28,6	VH MS 16
35	13/8	0,9	LOKin 35	VH MS 09
35	13/8	1,2	LOKin 35	VH MS 12
35	13/8	1,4	LOKin 35	VH MS 14
35	13/8	1,5	LOKin 35	VH MS 15