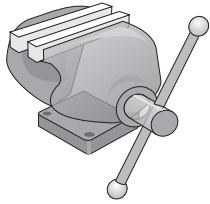


EO-2 assembly instructions



Assembly in vice

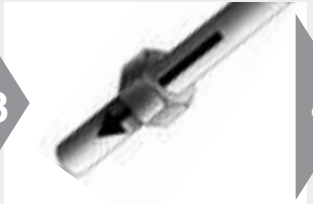
- Reliable method
- Only economic for assembly of small quantities



- 1
- ⚠ Threads on stainless steel fittings must be lubricated
 - ⚠ Use EO-NIROMONT special high-performance lubricant for stainless steel fittings



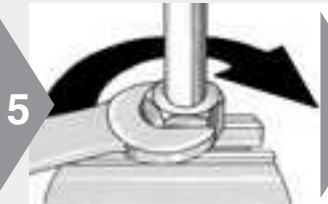
- 2
- Check according to VOMO checking instructions
 - Use pre-assembly tool VOMO
 - Fitting body may be used one time only and components must stay together



- 3
- Push functional nut onto tube-end
 - Advantage: Easy tube insertion, particularly large dimensions



- 4
- ⚠ Press tube-end firmly into the assembly cone
 - Screw on nut until finger-tight



- 5
- Tighten until sharp increase of resistance (approx. 1 to 1½ turns)
 - ⚠ Recommended to use spanner extension for sizes over 20 mm O.D. (see chart)



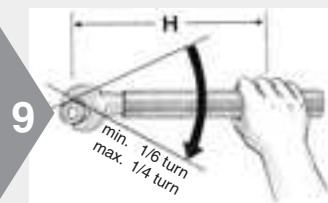
- 6
- Assembly check:**
- Gap between sealing ring and retaining ring must be closed
 - A little relaxation (approx. 0.2 mm) is allowed



- 7
- ⚠ **Gap not closed:** Check all components including tube

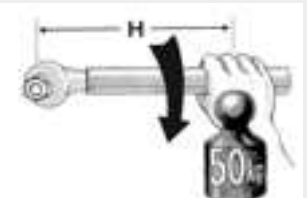


- 8
- Assemble fitting until wrench-tight (without spanner extension)



- 9
- ⚠ Then tighten fitting firmly by min 1/6 (max. 1/4) turn (1 to 1½ flats)
 - ⚠ Recommended to use spanner extension for sizes over 20 mm O.D. (see chart)

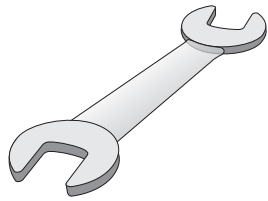
Spanner length



Size	Spanner length H [mm]
22-L	400
28-L 20-S	500
35-L 25-S	800
42-L 30-S	1000
38-S	1200

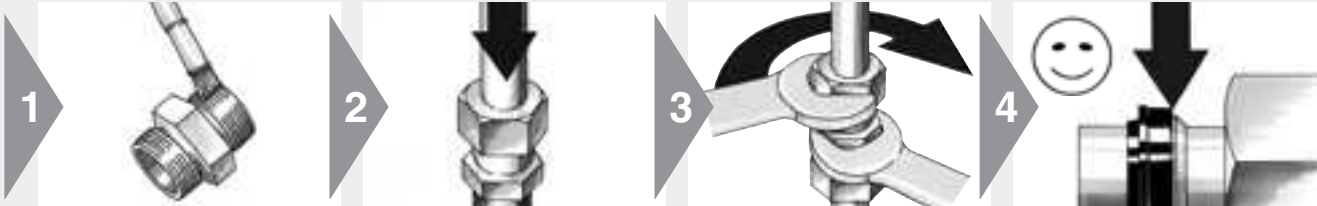
E

EO-2 assembly instructions



Direct assembly

- Simple procedure for single assemblies of small dimensions
- Not economic for series assemblies
- ⚠ Tubes \varnothing 30, 35, 38 and 42 mm must be pre-assembled in vice



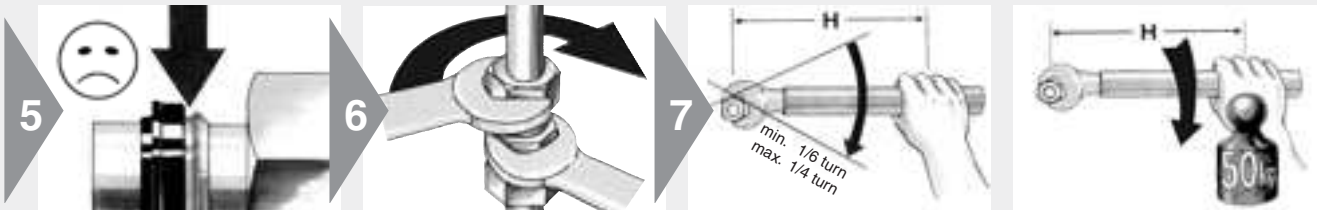
- ⚠ Threads on stainless steel fittings must be lubricated
- ⚠ EO-NIROMONT is a special high-performance lubricant for stainless steel fittings

- ⚠ Press tube-end firmly into the assembly cone
- Turn back nut for easy tube insertion



- Tighten until sharp increase of resistance (approx. 1 to 1½ turns)
- ⚠ Recommended to use spanner extension for sizes over 20 mm O.D. (see chart)

- Assembly check:**
- Gap between sealing ring and retaining ring must be closed
 - A little relaxation (approx. 0.2 mm) is allowed



- ⚠ **Gap not closed:** Check all components including tube

- Assemble fitting until wrench-tight (without spanner extension)

- ⚠ Then tighten fitting firmly by min 1/6 (max 1/4) turn (1 to 1½ flats)
- ⚠ Recommended to use spanner extension for sizes over 20 mm O.D. (see chart)

Spanner length

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