

Installation & Maintenance Instruction for Malleable Iron Fittings

• Precautions before Installation

Before installation, visually inspect the thread quality of the fittings or the pipe, the teeth are full, no iron filings, etc., no rust, no bumps on the first three threads, no broken teeth and other defects affecting the installation and complete connection of the outlet threads.

(pay special attention to the unions' ball cone seal, cone seal or ball seal joint, please check the seal surface for bumps, scratches or other defects that affect the seal before installation).

• Installation



1) Choose the Correct Size Fittings and The right tools, Prepare fittings with the same specifications and threading standards.



3) Wrap sealing tap

Thread fitting body should be wrapped with PTFE tape or other raw material. The raw material tape needs to be wound in the direction of the thread, if the direction reversed, the sealing performance is greatly reduced. It is recommended to start winding from the second wire at the beginning of the thread. Check the inner and outer screw sleeves before winding the raw material belt. If it is loose, then the raw material belt should be entangled more. Otherwise, it will be less entangled.



2) Clean the Pipe thread

Check the thread quality of the fittings to be installed, and wipe the dirt in the thread with a clean rag.



4) Attach the Pipe Fitting

Screw the inner and outer threads by hand, Tighten the fittings 2-4 turns with pipe wrench.

• Maintenance

1. Before normal use, the test pressure should be tested according to the corresponding test pressure. If the thread leakage phenomenon is found, the tube clamp can be used to continue tightening the 1-2 buckle(circle).

2. The end face of the steel pipe connected to the pipe fitting must be flush, the thread should not be slanted, and there should be no ellipse or bending phenomenon, otherwise the pipe will not be straight after connection.

3. When tightening with wrench, pay attention to the card to prevent the product from being broken due to screwing of the square side. The best installation method is to fix the pipe fitting and twist the steel pipe to ensure the product is not damaged.

Torque Data

● According to the size of the pipe fittings, the recommended installation tightening torque data is as follows:

Size	1/8	1/4	3/8	1/2	3/4	1	1¼	1½	2	2½	3	4
Installation torque N·m	-	-	-	60~ 90	60~ 90	80~ 110	90~ 130	140~ 180	180~ 220	200~ 240	220~ 260	300~ 400