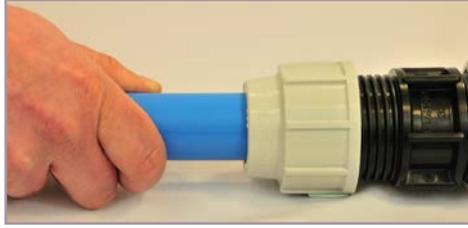


mechanical fitting instructions

Metric Fittings 20mm - 110mm and Imperial Fittings 1/2" - 2"



Insert liner into pipe (metric 20mm-63mm only) and slacken nut until half the thread is visible.



Push pipe into body, through the nut, split ring, and O-ring.



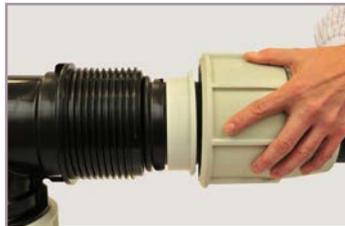
Tighten nut firmly: Hand tight on pipe 20mm (1/2") - 32mm (1"), on pipe 40mm (1 1/4") and above use a Plasson wrench.

Note: For diameters 40mm and above, chamfering and lubrication of the pipe will ease insertion (use silicon lubricant). Metric fitting shown for illustrative purposes. Imperial fittings have black nuts.

Metric Fittings - 125mm



Draw the nut, collars, and O-ring over the end of the pipe to a distance of approx. 250mm (put the white split ring to one side for later use).



Insert the pipe into the body of the fitting until it meets the interior stop. Then draw the O-ring and collars close to the body of the fitting.



Tighten the nut with a Plasson wrench until the O-ring and collars enter the fitting and reach their end position. Unscrew nut from fitting.



Open the white split ring and mount onto pipe with larger side against the collar ensuring that both parts meet tightly onto the fitting using a Plasson wrench.

Metric Fittings - 160mm

- Undo and take out nuts & bolts.
- Take the two shell halves apart, remove the exposed sleeve & O-ring and place over the pipe end.
- Push the body of the fitting completely home over the pipe end.
- Place the two shell halves with grip rings over the pipe & fitting body.
- Insert bolts, washers, and nuts and tighten until the shells are in contact with each other.



Plas4 Universal Fittings



Prepare the pipe by removing any unsound material adhering to the pipe then cut and de-burr pipe as necessary.



Slide the universal end of the fitting onto the pipe end until it reaches the internal fins and a resistant point is felt. **NOTE:** Do NOT force pipe end past the internal fins as this may impair joint.



Tighten the black nut using a Plasson wrench or similar. Assemble the Metric PE joint as per the standard fitting instructions.

Note: If reusing the fitting, ensure the metal teeth are located in the grip ring, and the pipe end does not pass the location of the internal fins.