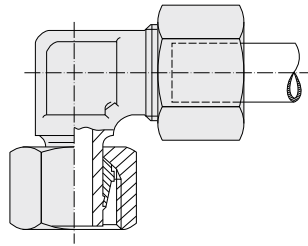




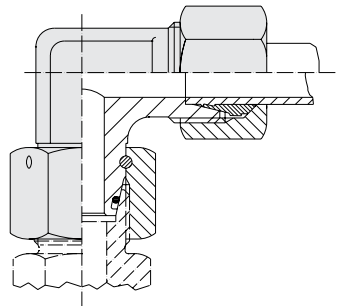
ASSEMBLY INSTRUCTION STUD END AND TAPER CONNECTION (DKO)

Fully assembled cutting ring connectors with shaft type VA, VB, VC, VD, RL, RS



Oil the thread. Then insert the shaft into the screw connection and tighten by hand. Then tighten with spanner until there is a noticeable increase in force. For the final assembly of the shaft side, the union nut is tightened 30°-60° past the point of a noticeable increase in force.

Taper couplings type VADKO, VBDKO, VCDKO, VDDKO, RLDKO, RSDKO



Oil the thread of the screw connection and O-shaped ring of the taper connection (DKO) side. Insert the taper couplings into a 24° Cone of tube fitting and tighten by hand. For the final assembly of the taper connection side, the union nut is tightened with 1/4 to 1/2 turns. The screw connection must be held using a suitable spanner.

TUBE QUALITY

We recommend the use of seamless precision steel tubing with dimensions in accordance with DIN EN ISO 10305 Part 4, Material: E235, NBK.

Tubes from rust and acid-proof material must be seamlessly cold-drawn, scale-free and heat-treated in accordance with DIN EN 10216-5 - X6 CrNiMoTi17-12-2-CFD and exhibit tolerances in accordance with DIN EN ISO 10305-1.