

Installation instructions for threaded fittings

How to prepare fittings following the instructions in the Connection standards section.

Preparing fittings for the connections.

1 Apply sealant on threading.

Recommended number of turns according to fitting diameter, with LOCTITE 55.

Ø	1/2"	3/4"	1"	1" 1/4	1" 1/2	2"
TWISTS FOR METAL	6-8	7-9	8-12	9-14	10-15	15-25

2 Manually make fittings fit (how to create a collector by aligning side fittings).

3 Screw tight with a wrench, do not force or tighten in excess. Align while tightening.



Sealant

USE OF SEALING PRODUCTS

Where necessary it is recommended that the fittings be aligned (e.g. collectors).

For perfect tightness Bucchi recommends the following sealants:

0800922

MULTIFIBER NYLON SEALANT LOCTITE 55

to be smeared over plastic or metal threads.

0800923

POLYMERIZING SEALANT GEL LOCTITE 5331

to be smeared over plastic or plastic/metal threads.

0800927

THREADLOCKER liquid two-component epoxy adhesive Loctite EA9480

applicable to plastic and metal threading.



Sealants offer the following advantages:

- They replace the usual PTFE tape, hemp and pastes
- They ensure full contact between threads and guarantee 100% tightness
- They do not shrink, do not run and do not clog other parts - including filters, because they do not fray
- They can be easily disassembled with normal tools (for product, characteristics and

instructions for use see relevant folder)

- Classified WRC, approved BS 60920 for drinking water. DVGW-approved

The threadlocker features the following advantages:

- It prevents the loosening of vibrating parts such as fittings with female and male thread
- It resists loosening caused by vibration: Tensile Lap Shear ISO 4587: glassreinforced

techno-polymer 2.5-5.0 N/mm²; Nylon 2.0-2.5 N/mm²

- It enables disassembly using manual tools
- It provides good chemical resistance. Certified for food use, it is indicated for gluing metals and plastics in environments where food is processed. KTW certificate for drinking water, food certificate for food contact of the Fraunhofer Institut.

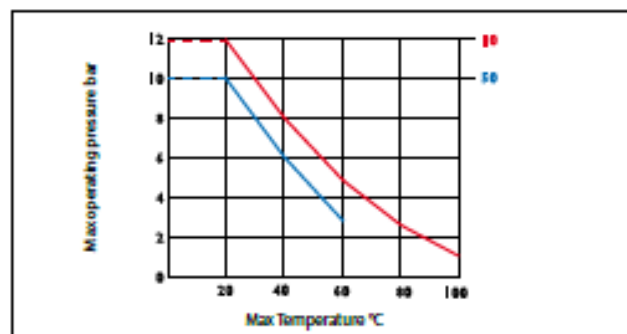


MAXIMUM OPERATING CONDITIONS

Diagram illustrating the operating pressure change in response to water or fluid temperature for which PP has been classified chemically resistant.

PP-PN 10

Max Temperature	Working life	Operating pressure maximum
20 °C	10	12 bar
	50	10 bar
40 °C	10	8 bar
	50	6 bar
60 °C	10	5 bar
	50	3 bar
80 °C 100 °C	10	2,5 bar
	50	1 bar



Threaded fittings, in compliance with the following standards:

- with internal thread: GAS parallel threading, UNI ISO 228/1
- with external thread: GAS parallel threading, UNI ISO 228/1

Tightening torques for BSP plastic threading

Do not tighten fittings with plastic threading too much because it may cause inappropriate stress and potential defective operation.

The recommended maximum tightening torques are shown in the table below.

Threads	1/4"	3/8"	1/2"	3/4"	1"	1"1/4	1"1/2	2"
Max Tightening PP material	2 Nm	3 Nm	6 Nm	8 Nm	10 Nm	15 Nm	20 Nm	25 Nm
Max Tightening PA material	3 Nm	5 Nm	8 Nm	10 Nm	12 Nm	17 Nm	30 Nm	35 Nm