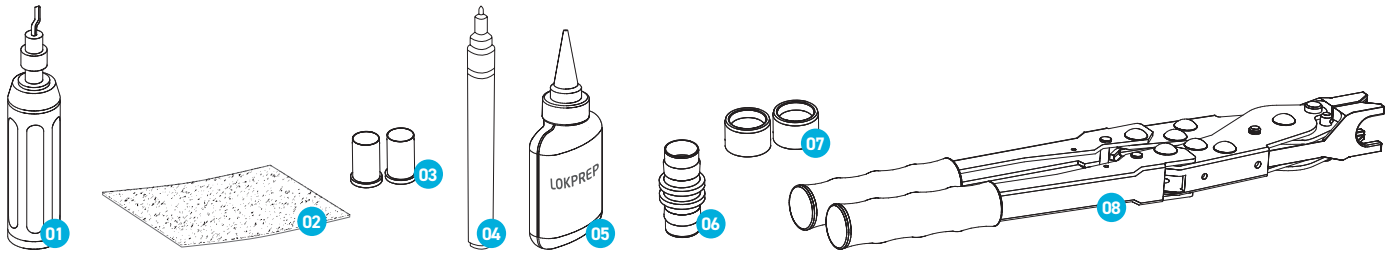
ASSEMBLY INSTRUCTIONS

LOKRING® tube connection assembly version 50

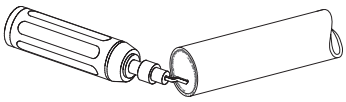
(The assembly version is determined on the basis of the last two figures in the article name. **Example**: LOKRING 6 NK Ms **50**)

VULKAN

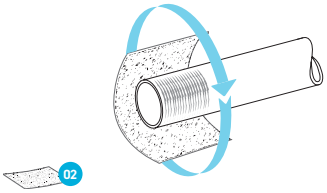


01. Tube deburrer **02.** Abrasive mat **03.** Stabilisation inserts **04.** Permanent marker **05.** LOKPREP
06. Joint **07.** LOKRINGs **08.** Hand assembly tool with assembly jaws MB EVP

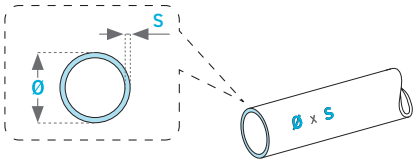
Deburr the tube end all the way round using a tube deburrer **(01)**. **Use different deburring tools for different materials.**



Clean the tube end by rubbing it in rotary movements using the abrasive mat **(02)**.

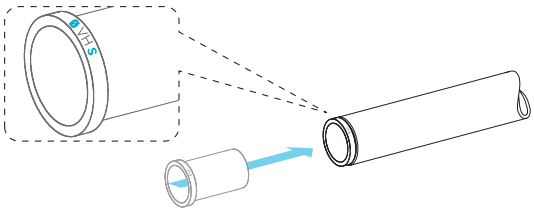


Determine the tube wall thickness **S** and the outer tube diameter **Ø** on the basis of tube coding or using a slide gauge.

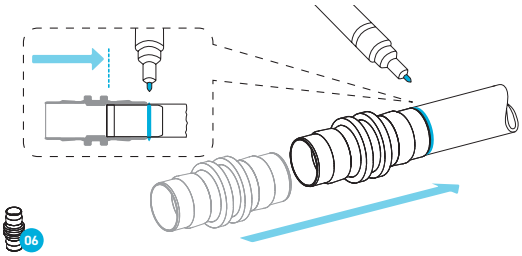


Ø = outer tube diameter **S** = tube wall thickness

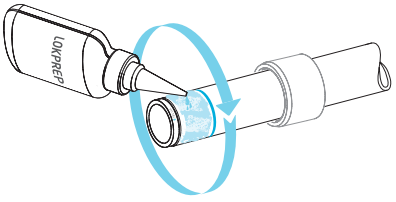
1 Insert a stabilisation insert **(03)** suitable for the material, the outer tube diameter **Ø** and tube wall thickness **S**. Stabilisation inserts **(03)** may not be necessary in case of use with refrigerants with an operating pressure lower than 25 bar (e.g. R134a car A/C systems or refrigerator cabinets).



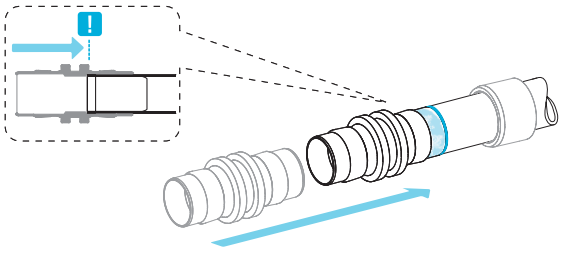
2 Before applying the LOKPREP **(05)**, push the joint **(06)** onto the tube until you can feel the inner stop. Mark **(04)** the correct insertion depth on the tube.



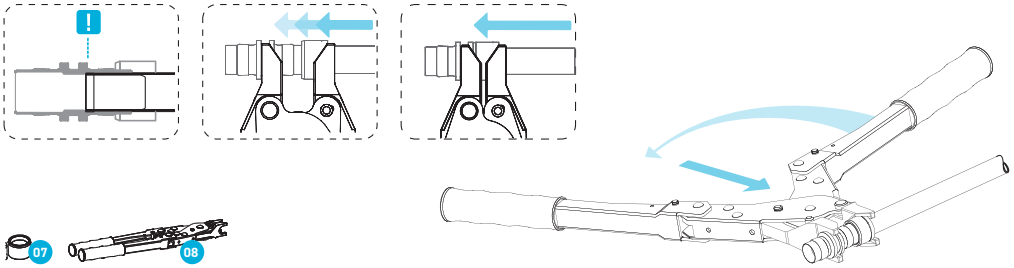
3 Choose the correct LOKPREP **(05)** for the tube material and the ambient temperature. Apply LOKPREP **(05)** all the way round the sealing area of the tube end. Respect the correct curing time of the LOKPREP **(05)**.

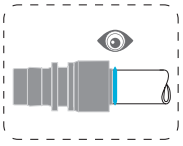


4 Push the joint **(06)** onto the tube until it reaches the inner stop !.



5 Put the assembly jaws **(08)** in place behind the LOKRING **(07)** and the assembly stop of the joint **(06)**. Press the tube connection together. ! Do not change the insertion depth of the tube and joint **(06)**. Press the tube connection until the LOKRING **(07)** is flush to the assembly stop of the joint **(06)**. Respect the curing time of the LOKPREP **(05)** before applying forces to the connection.



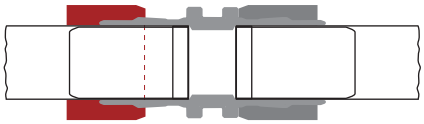


Check the correct assembly/insertion depth on the basis of the position marking.

EXAMPLES AS ASSEMBLY AID

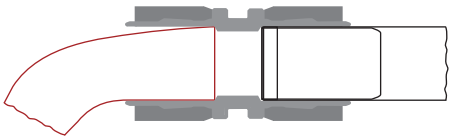
Wrong: LOKRING has not been pressed through to the assembly stop.

Right: LOKRING has been pressed flush to the assembly stop.



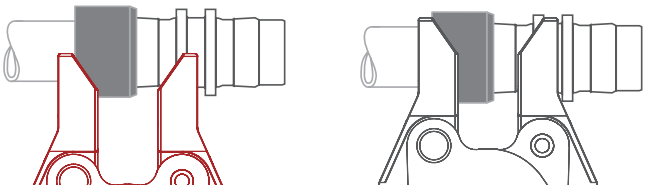
Wrong: Stabilisation insert is missing.

Right: Correct stabilisation insert is inserted.



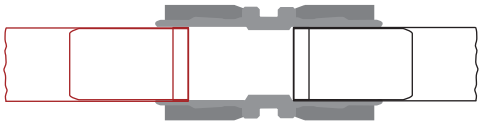
Wrong: Assembly jaws are not set in place correctly.

Right: Assembly jaws are set flush correctly.



Wrong: The tube is not pushed in as far as the inner stop.

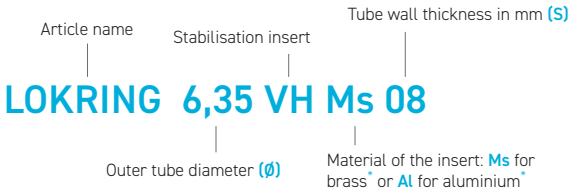
Right: Push the tube in until you can feel the inner stop.



CHOOSING THE STABILISATION INSERT

*Use Ms stabilisation inserts for copper tube and Al stabilisation inserts for aluminium tube.

Note: Stabilisation inserts must not be used inside an NRA adaptor or inside the stainless steel tube of a EURO flare-fitting.

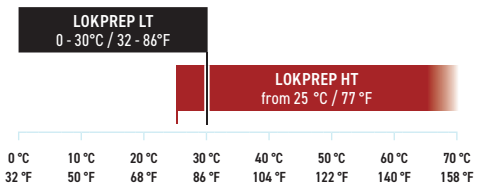


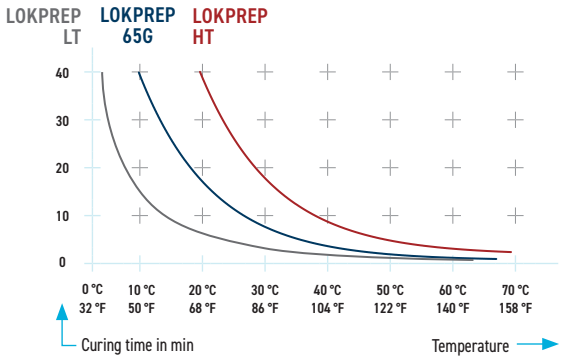
CHOOSING THE LOKPREP

→ Use an **aluminium LOKRING connector** and **LOKPREP 65G** for all connections from aluminium to aluminium or aluminium to copper. Always use a heat shrink sleeve for connections from aluminium to copper in order to protect the connection against corrosion.

→ Use a **brass LOKRING connector** and **LOKPREP LT** or **LOKPREP HT** for all connections from copper to copper.

The following diagram shows the suitable temperature ranges for **LOKPREP LT** and **LOKPREP HT**.





LOKRING assemblies at an ambient temperature below 0°C (32°F) should be avoided, as the proper curing of LOKPREP cannot be guaranteed. If installation at temperatures below 0°C (32°F) cannot be avoided, it must be ensured that the joint is heated to above 0°C (32°F) after installation. However, the temperature due to heating must not exceed 100°C (212°F).

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