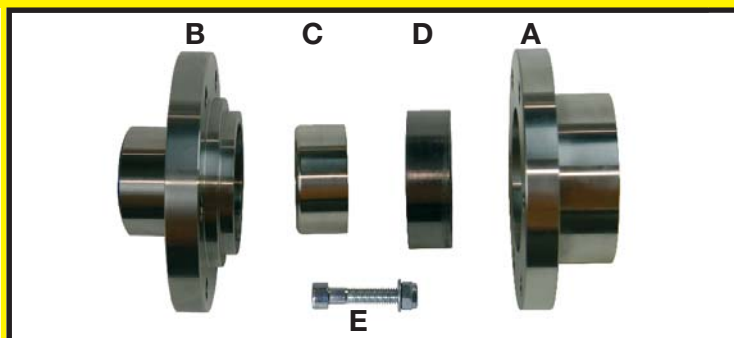


Assembly instructions isowell

Instructions for how to work with isowell-pipes



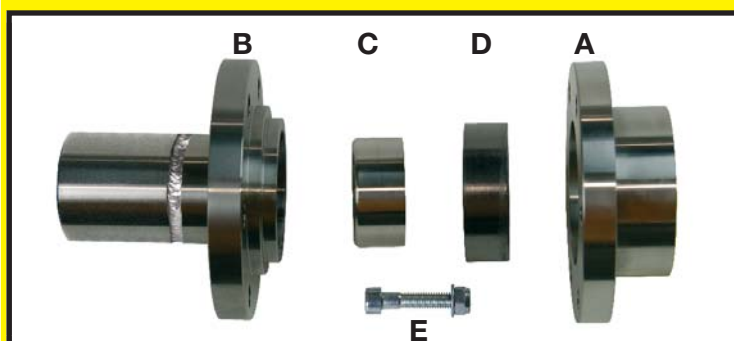
Flange connection with inside thread (Connection to a line with a threaded end)



Package Contents:

- A - 1 pc. Flange 25bar (Screwable Flange)
- B - 1 pc. Flange Connection with Inside Thread 25bar (Counterflange)
- C - 1 pc. Support Ring 25bar
- D - 1 pc. Sealing Ring 25bar (Graphite Ring)
- E - 6 pc. Screw including Nut and Washer

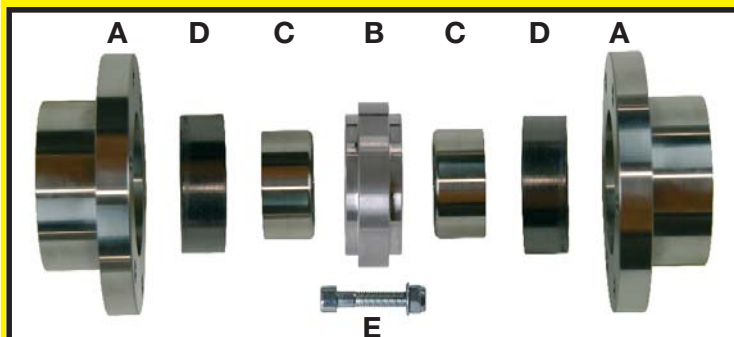
Flange connection with welding ends (Connection to a line with a welded end)



Package Contents:

- A - 1 pc. Flange 25bar (Screwable Flange)
- B - 1 pc. Flange with Welded End 25bar (Counterflange)
- C - 1 pc. Support Ring 25bar
- D - 1 pc. Sealing Ring 25bar (Graphite Ring)
- E - 6 pc. Screw including Nut and Washer

Flange connection pipe-to-pipe (Connection isowell-isowell)



Package Contents:

- A - 2 pc. Flange 25bar (Screwable Flange)
- B - 1 pc. Intermediate Connection Ring 25bar
- C - 2 pc. Support Ring 25bar
- D - 2 pc. Sealing Ring 25bar (Graphite Ring)
- E - 6 pc. Screw including Nut and Washer

Required Tools:

- Protective gloves
- Tape measure / ruler
- Marking pen
- Handsaw
- Utility knife / cutter
- Screwdriver
- Stainless steel wire brush
- Hacksaw with stainless steel blade
- Half-round file
- Rag
- Expander including gauge shell and PEX spacer ring
- Plastic or rubber mallet
- Allen and hex key sets

During assembly, the following expanders are used:

DN25	H40x3,7
DN32	H50x4,6
DN40	S63x8,7
DN50	H75x6,8

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Assembly instructions isowell

Instructions for how to work with isowell-pipes



01 Instructions for Storage and Safety

To ensure optimal and long-lasting functional quality, unused **isoplus** products should be stored in a dry and well-ventilated space. Avoid storing in direct sunlight or in spaces exposed to rain, snow, dust or other adverse environmental conditions.
The installation and use of **isoplus** products must be carried out in compliance with the relevant health and safety regulations for the location.

02 Instructions for Installation

The individual steps in the following assembly instructions are applicable to all three possible types of connection accordingly.

ATTENTION! Be sure to wear gloves!
The corrugated, stainless steel pipe is very sharp due to its thin walls.

03 Marking



To free the carrier pipe, mark the outside of the pipe with a pen approx. 12-15 cm from the end.

04 Cutting the Casing



Cut into the encased pipe using a handsaw. **ATTENTION!** When using network monitoring, only cut the casing. Otherwise, there is the chance of severing the signaling wires.

05 Cutting Lengthwise



Using the cutting knife, make a cut lengthwise in the PE-LD encasement.

06 Removing the Casing



Peel off the outer jacket casing by using the screwdriver as a lever and remove it.

07 Cutting into the Foam



Cut into the foam using a utility knife / cutter. **ATTENTION!** When using network monitoring, do not cut the signaling wires!

08 Exposing



Expose the carrier pipe. When using network monitoring, fold the signaling wires to the back.

09 Removing Foam Residue



Remove any foam residue with a stainless steel wire brush.

10

Sawing



Use the screwable flange as a guide for sawing. To avoid getting the chamber of the flange dirty, screw it on in the opposite direction. Using the stainless-steel hacksaw, saw off the section of the carrier pipe that extends beyond what is needed along the flange. Remove the flange.

11

Filing



File the inside and the outside of the pipe with the half-round file.

12

Cleaning the Pipe



Use the rag to remove any shavings from the carrier pipe.

13

Cleaning the Flange



Use the rag to remove any shavings from the flange.

14

Graphite Sealing Ring



Set the graphite sealing ring into the chamber of the screwable flange.

15

Screwing On



Screw on the flange including the sealing ring.

16

Gauge Shell



Attach the gauge shell flush with the end of the carrier pipe and screw it tightly.

17

Expanding



Slide the PEX spacer ring onto the expander. Using the expander, widen 2 to 3 times with a 30° displacement. Remove the expander and unscrew the gauge shell.

18

Support Ring



Using a plastic or rubber mallet, strike the support ring until it is set. Tap the support ring with the rubber mallet to remove any burrs that may have appeared on the carrier pipe; this ensures the installation for additional parts.

19 Screwing Flange Forward



Screw the flange in a forward direction to the end of the pipe.

20 Counterflange



Attach counterflange and fasten the screws evenly in a crosswise manner.

ATTENTION! With an isowell-isowell connection, take note of the intermediate connection ring (Pic. 21).

21 Intermediate Connection Ring



For an isowell-isowell connection, the intermediate connection ring must be installed before the flanges are screwed together!

22 Screwing Together

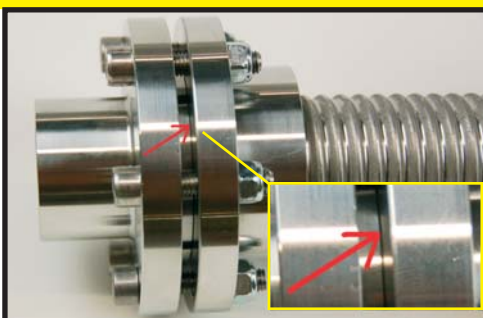


Screw together the screwable flange and the counterflange.
ATTENTION! Before tightening the screws, make sure the connection is not twisted on the carrier pipe.

Take note of the tightening torques for the screws used:

M6	8.8	10 Nm
M6	10.9	15 Nm
M8	8.8	25 Nm
M10	8.8	50 Nm

23 Control



After the screws have been tightened, make sure no gaps exist between the flanges!