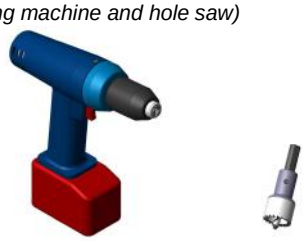
EQOfluids®

BRANCHES ASSEMBLING INSTRUCTIONS

EQOair – EQOh2o - EQOnitro - EQOgas – EQOvac - EQOairHP - EQOoilHP - EQOnitroHP

1. Needed tools and materials

1.1. Tools to hole pipes
(Drilling machine and hole saw)



1.2 Tool for the internal deburring of the pipe
(Blade deburring tool)

1.1. Tool for tightening the "4" closing bolt and the "6" plug
(6 mm. ex. wrench or ratchet spanner with ex. wrench)

2. Assembly with correct components positioning

1. Offtake part
2. Bottom part
3. Washer
4. Cylinder head screw with internal hexagon
5. Plug O-ring gasket
6. Plug
7. Gasket
8. Washer (not present in all sizes
9. Clamping ring
10. Tightening nut

3. Examples and assembly solutions for branches

a

b

a. Example of a direct offtake : it is the simplest and more economic one, but it is not always feasible due to alignment problems between the masonry and the main pipe. When a gaseous fluid is transported, the condensate in the main pipe, if present, is conveyed directly into the offtake. Of course the main pipe has to be installed with such a weathering as to have its final section in a lower position (to collect and drain the condensate through suitable equipment and flow speeds cannot exceed 6 m/sec.

b. Example of an offtake obtained through a 90°elb ow. All problems of alignment are solved, but what said under point a is still to be considered.

4. ASSEMBLING

4.1 Verify the integrity of the pipe section where the gasket is to be positioned .
Any scratches on the paint, if not deep, can be eliminated using fine 300÷600 emery paper. Deep dents or scratches can be eliminated only by changing the branch position or by replacing the interested pipe section.

4.2. Verify the correct positioning of the components.
Branches are supplied assembled and have to be disassembled only for the installation.
In case of accidental disassembly, check the presence and the position of all components which has to be the one of the assembly figure at point 2 only.

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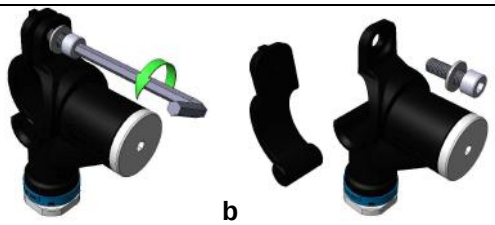
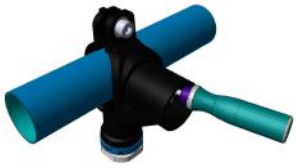
4.3. Completely unscrew the screw 4 (a) and separate the bottom part 2 from the offtake part 1 by getting it sliding axially up to complete loosening (b).	 a b
4.4. Position the off-take part 1 on the pipe, close to its final position and insert the bottom part 2 by pushing it axially along the hinge, up to align the screw holes 4 (c).	 c
4.5. Screw the screw 4 without tightening it and place the branch in its final position (d). **4.6. Tighten the screw 4 finally (e).**	 d  e
4.7 Totally unscrew the plug 6 (f)	 f
4.8. Hole the pipe with a milling cutter of a size adequate to the branch pipe diameter (g) **40= Ø19 (3/4")**  *This operation will not damage the thread on condition that the guide helix point is set in such a way that it does not protrude by more than 1÷1,5 mm (3/64"÷1/16") over the saw teeth.*	 g
4.9. Remove the burr after holing and carefully clean out all residues due to this operation (h).	 h
4.10. Screw the plug 6 again and tighten it with a 6 mm. Allen wrench (i) **Now the branch is ready for the assembling of the offtake pipe.**	 i

In case of doubt, please contact our technical service : giacomo@eqofluids.com.

More technical information can be found on our website: www.eqofluids.com.

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