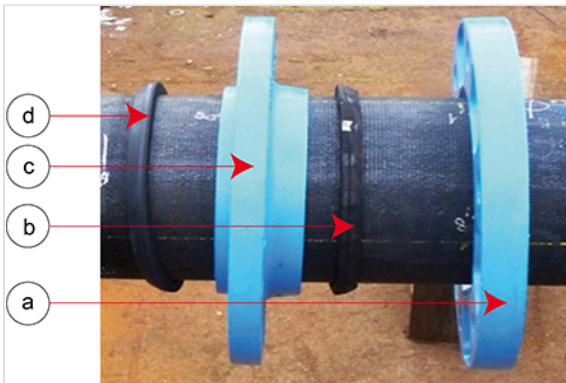


Assembly instructions for NATURAL-ALPINAL collar



Placing the component parts

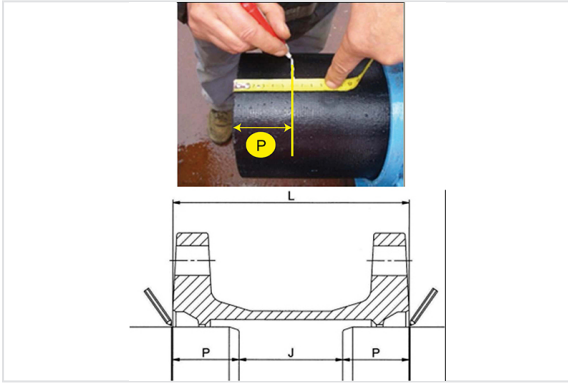


First place the gland "a" → anchored gasket "b" → spacer "c" → leaktightness gasket "d" on the pipe.

Be attentive to the order of the component parts when placing them.

Item	Description
d	Leaktightness gasket
c	Spacer
b	Anchored gasket
a	Gland

Draw the depth for assembly

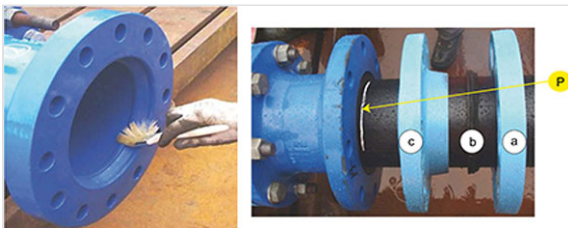


Draw the dimension "distance P" on the spigot of the pipes to be assembled.

(P = minimal distance between the side to be assembled and the spigot end)

DN	P ± 10	L	J Max
80	60	280	160
100	60	300	180
125	60	310	190
150	60	300	180
200	60	331	211
250	60	330	210
300	60	340	220
350	70	350	210
400	70	440	300
500	70	470	330

Placing the collar



Lubricate the gasket chamber with the PAM lubricant. Slide the collar on the pipe, place the gasket in the chamber. Verify that the assembly depth is good, marking "P" must be visible.

Placing the spacer



Verify that there is a regular gap between the spacer and the collar side to be assembled

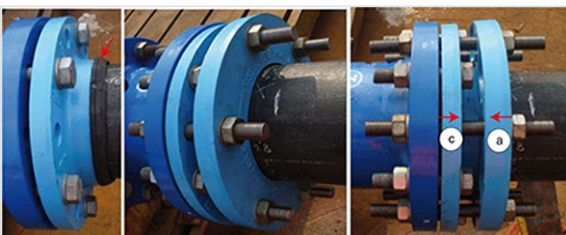
Lubricate the threads of the bolts with a mechanical paste (eg CASTROL or MOBIL), place them (one out of two in the spacer) and tight them following the torque according to DN, see the torque chart.

Angular deflection : first tight aligned at 8 m.daN torque, then apply the deviation (max 2°), then tight again at recommended torque according to DN.

Torque (m.daN)

DN	80	100	125	150	200	250	300	350	400	450
Torque	12	12	18	20	20	20	20	20	30	30

Placing the gland



Verify that there is a regular gap between the spacer and the gland

Bring the anchored gasket closer in order to touch the spacer, then bring the gland closer.

Place the spindles and tight them at 8 m.daN torque.

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