

## Assembly of flange fittings in stainless steel 1.4404

### After welding and before starting the installation of flange fittings:

- The installation site must be free and accessible
- The media pipe must be dry and cleaned of polyurethane foam residues

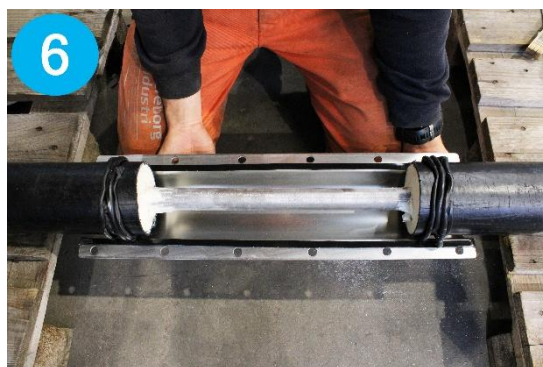
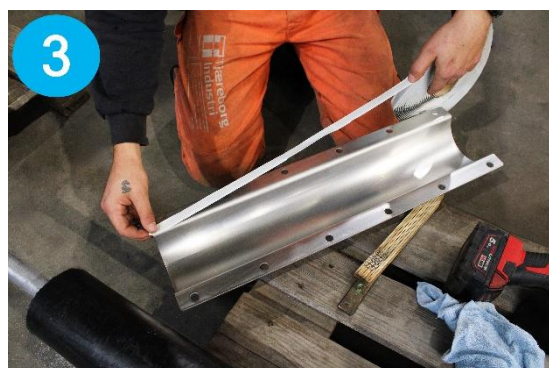
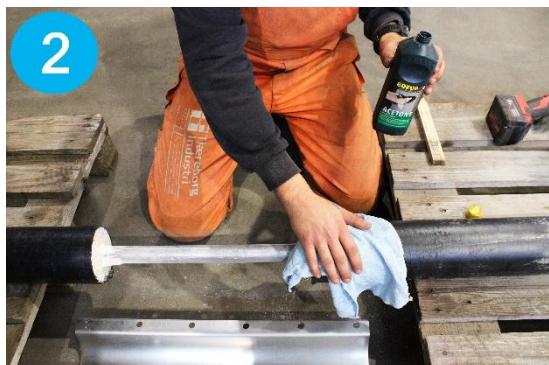
### Assembly of flange fittings:

1. The pre-insulated rigid- or flexible pipes must be cleaned of moisture and dirt at a distance of approx. 20 cm. from the pre-insulated rigid pipe ends
2. The media pipe must be dry and cleaned of polyurethane foam residues
3. Sealing tape\* is placed on the lower part of the flange. Let the sealing tape protrude 5-7 cm. beyond the flange ends and close it back over the lower part as an overlap.
4. The flanges with sealing tape are now ready for installation around the pre-insulated rigid pipe.
5. 3.5 cm inside the pre-insulated rigid pipes ends, sealing tape is placed around the pre-insulated rigid pipes with approx. 5-7 cm. overlap
6. Press the lower part in place against the pre-insulated rigid pipes ends and press the sealing tape overlap against the pre-insulated rigid pipe.
7. Install the upper part, which is compressed and tightened with the lower part
8. To facilitate the installation, use, if necessary, a fastening strap, so that you have both hands free to install the supplied bolts, which are inserted from the bottom up with washers on both sides
9. The bolts are cross-tightened with 100 newton meters.
10. Before filling with foam, insert one of the two supplied plugs (with a hammer if necessary) into one of the foaming holes.
11. Make a vent hole in this plug. The plug will be held in place during the foaming process, so that air and foam can escape from the vent holes in the plugs.
12. Use a prescribed foam.
13. Immediately after the foam has stopped escaping from the vent holes, insert plug 2 so that it is also level with the upper edge of the hole like plug 1. Check that no foam has escaped along the flange joints. Carefully remove any foam residue from the plugs and cut off the retaining strips on the plugs.
14. Prepare the supplied discs by removing the white protective foil. Remember to have a separate fireproof surface, as the glue must be heated with a burner if necessary.
15. Briefly heat the steel around the plugs, one at a time.
16. Preheat one disc at a time and...
17. Place (using gloves) the preheated disc over one of the plug. Make sure it is pressed firmly and completely tight around the plug.
18. Repeat with disc 2.

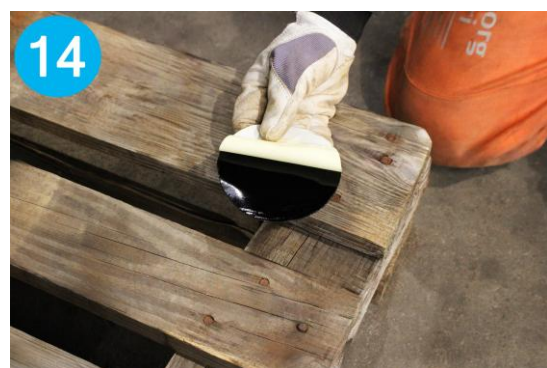
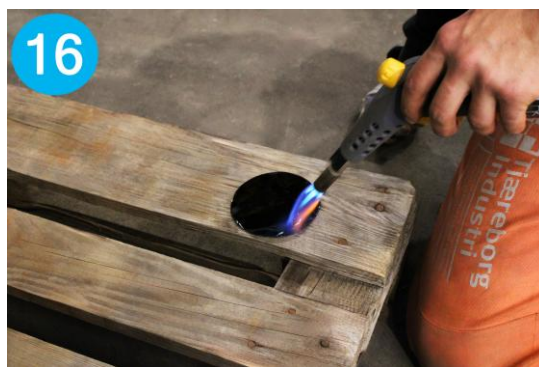
\* Sealing tape can be supplied as round and flat tape. Order separately – not included.

*Epoxy training is required when working with foaming.*

*It is important that there is a focus on the correct protective equipment and safety measures.*







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