Transair® Main Assembly Rules

1 transair

Ring Main Assembly

Ø16.5 / Ø25 / Ø40

Tooling required for ring main assembly in Ø16.5, Ø25 or Ø40:



Assembly steps for ring main assembly in Ø16.5, Ø25 or Ø40:



1. Verify alignment of the arrows of the nuts and arrows of the fittings. They guarantee the threading torque of the nuts.

3. If you cut the pipe, don't

forget to deburr it and to

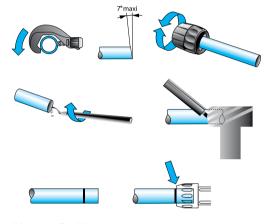
reproduce the connection length mark with marking

2. Push the pipe in the fitting to the "connection" marking at the end of the pipe. Mechanical connection and tightness will then be guaranteed.

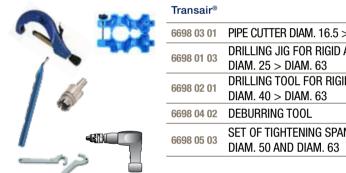
Connection length for all pipe-to-pipe fitting are equal to:

For 6602/6604/6606/4002 connectors: 25 mm for Ø16.5 27 mm for Ø25 45 mm for Ø40

For 6625 end cap: • 39 mm for Ø16.5 mm 42 mm for Ø25 mm 64 mm for Ø40 mm



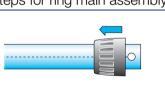
Ø50 / Ø63 Tooling required for ring main assembly in Ø50 or Ø63:



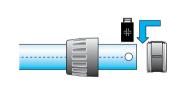
6698 03 01 PIPE CUTTER DIAM. 16.5 > DIAM. 76 DRILLING JIG FOR RIGID ALUMINIUM PIPE DIAM. 25 > DIAM. 63

DRILLING TOOL FOR RIGID ALUMINIUM PIPE DIAM. 40 > DIAM. 63 6698 04 02 DEBURRING TOOL SET OF TIGHTENING SPANNERS

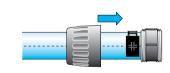
Assembly steps for ring main assembly in Ø50 or Ø63:



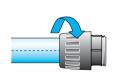
1. Unscrew one of the connector nuts and fit over the pipe.



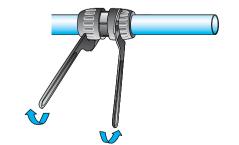
2. Position the SnapRing in the appropriate housings (2 holes at the end of the pipe).



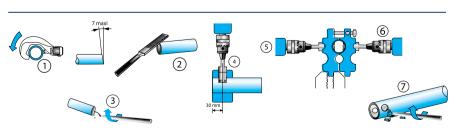
3. Bring the nut towards the body, that has been previously positioned at the end of the pipe, until it stops against the



4. Tighten the nut by hand.

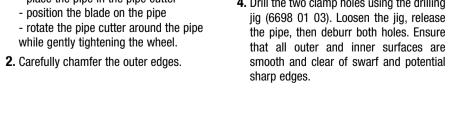


5. Complete the assembly with Transair® tightening spanners ref. 6698 05 03.



1. Cutting the pipe: - place the pipe in the pipe cutter position the blade on the pipe - rotate the pipe cutter around the pipe while gently tightening the wheel.

3. Also deburr the inner end of the pipe 4. Drill the two clamp holes using the drilling

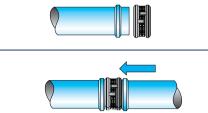


Ø76 / Ø100 / Ø168

Tooling required for ring main assembly in Ø76, Ø100 and Ø168:



Assembly steps for ring main assembly in Ø76, Ø100 and Ø168:



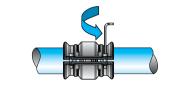
the shoulder. **2.** Bring the second pipe to the cartridge and slide fully up to the

1. Slip the cartridge over the

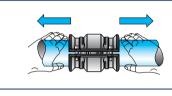
end of the first pipe fully up to



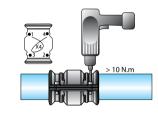
3. Position the clamp over the cartridge / pipe assembly.



4. Hand tighten the pre-fitted screws with an Allen key.



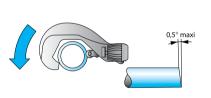
5. Pull the pipes fully back towards the outside of the clamp.



6. Fully tighten the clamp screws. For effective clamp sealing, screw tightening should be performed on alternate sides of the clamp as shown on the

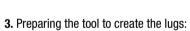
Lock in position by closing

the retaining pin.

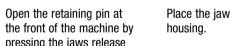


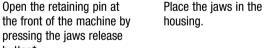
2. Carefully deburr and chamfer the outer and inner edges of the pipe with a file.

1. Cutting the pipe: - place the pipe in the pipe cutter - position the blade on the pipe - rotate the pipe cutter around the pipe while gently tightening the wheel.

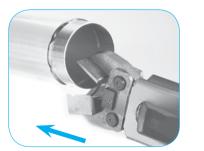








4. Creating the lugs for Ø76, Ø100 or Ø168 cut pipe:

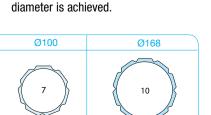


Manually open the jaws of the clamp and insert the aluminium pipe into the clamp as far as it will go.



Re-open the two jaws to remove the pipe and rotate the pipe slightly.

Min. Number of Lugs



Contact:

Renew the operation until the required

minimum number of lugs for each

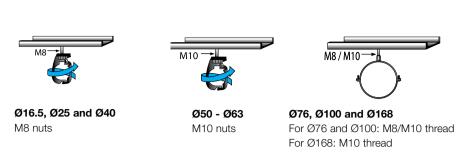
Release the jaws. Press the trigger and

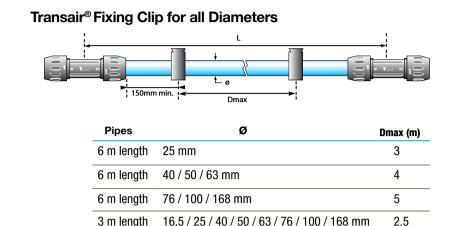
crimp the tube until a 'snap' sound is heard.

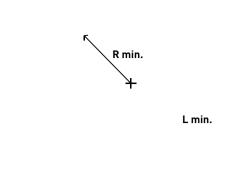
Important: do not overlap the lugs!

Fixture & Bending

To ensure good system stability, we recommend the use of at least 2 clips per pipe. Transair® aluminium pipe should only be mounted using these clips. They should not be substituted by any other type of clip or fixing.



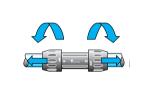




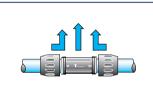
Transair®	R min. (mm)	L min. (mm)
Ø16.5	102	185
Ø25	154	185
Ø40	250	185
Ø50	300	185
Ø63	394	185
Ø76	317	185
Ø100	423	185
Ø169	700	195

Network Modifications

Ø16.5 / Ø25 / Ø40 Replacing a straight union by a tee or a valve:



1. Loosen the 2 nuts. **2.** Slide them along the pipe on either side of the connector.



3. Remove the body of the connector, together with the

4. Slide the nuts of the tee and

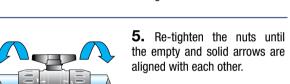
between the 2 pipes such that

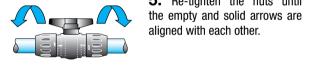
the solid and empty arrows are

position the body of the tee

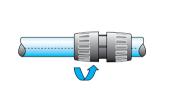


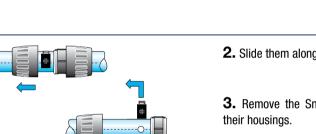


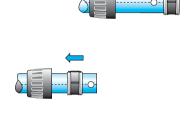


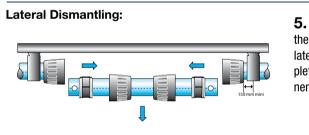






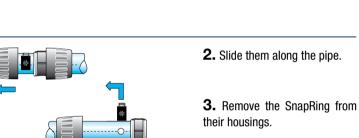


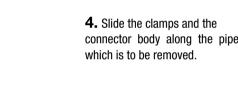




Ø50 / Ø63



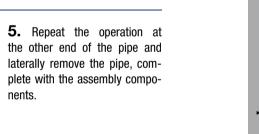


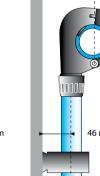


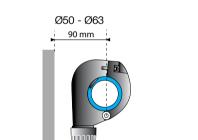
removed.

1. Loosen the connector nuts

on the ends of the pipe to be







Drops Assembly

Tooling required to assemble a drop:



DRILLING JIG FOR RIGID ALUMINIUM PIPE DRILLING TOOL FOR RIGID ALUMINIUM PIPE 6698 02 02

DIAM. 40 > DIAM. 63

DRILLING TOOL FOR RIGID ALUMINIUM PIPE

Tooling required to install a drop on a Ø50 or Ø63 ring main:

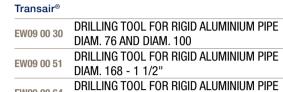


DRILLING JIG FOR RIGID ALUMINIUM PIPE DIAM. 25 > DIAM. 63 DRILLING TOOL FOR RIGID ALUMINIUM PIPE

DIAM. 40 > DIAM. 63 6698 04 02 DEBURRING TOOL

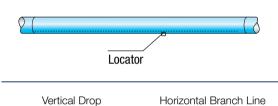
Tooling required to install a drop on a Ø76, Ø100 or Ø168 ring main:

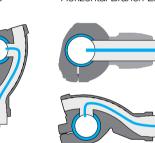
6698 04 02 DEBURRING TOOL



DIAM. 168 - 2" 6698 04 02 DEBURRING TOOL

Introduction to Drop Assembly





Transair® quick assembly brackets can be installed vertically or horizontally.

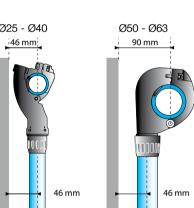
On every pipe two lines are

printed at 90° distance. They

both allow installation of aligned

or perpendicular brackets/ drops

on the same pipe.



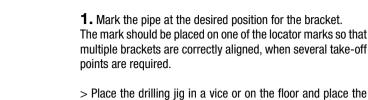
For Ø25 and Ø40 Transair® quick assembly brackets, the pipe centre to wall distance is equal to the bracket centre to wall distance, i.e. 46mm.

For Ø50 and Ø63 Transair® quick assembly brackets the pipe centre to wall distance is 90mm and the Ø25 and Ø40 bracket centre distance is 46mm.

Additional Products

Please view our Assembly Guides for more information - www.parkertransair.com

Ø25 / Ø40 / Ø50 / Ø63 -> Ø16.5 / Ø25



Ensure that the line marked on the pipe is centred within the drilling guide: 2 marks on either side of the jig's upper side provide a rapid indication of the pipe's positioning.

the appropriate drilling tool. - Ø25 mm: Ø16 mm hole > drilling tool **6698 02 02** - Ø40 - Ø50 - Ø63 mm: Ø22 mm hole > drilling tool 6698 02 01

> Tighten the locking clamp to secure the pipe and drill using

NB: Recommended rotation speed: 650 rpm.



2. Loosen the locking clamp and release the pipe, deburr and remove any swarf and the cut circular aluminum piece of pipe. Repeat the operation for the number of brackets that

3. Position the quick assembly bracket using its





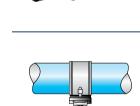
4. Tighten the screw with Allen key Hex 5 mm or Hex

Ø76 / Ø100 / Ø168 —> 1", 1 1/2", 2"



1. Drill the aluminum pipe at the desired position using drilling tool ref. EW09 00 30, EW09 00 51, EW09 00 64.

NB: Recommended rotation speed: 650 rpm.

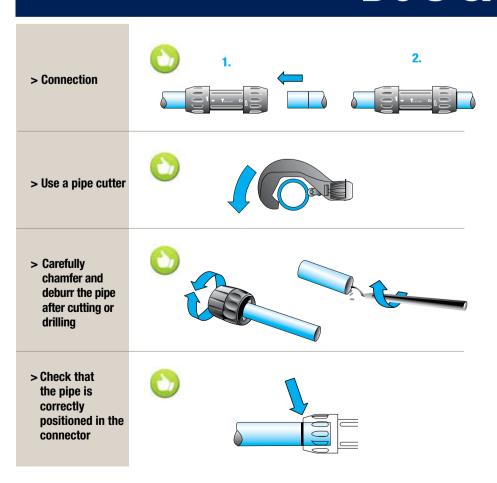


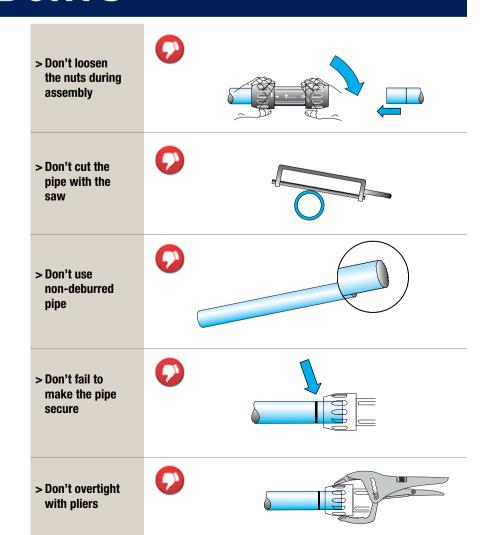
3. Position bracket ref. RR61 / RR63 and fully tighten the 2 screws.

100-130 Lbs.-ft

Diameter	Transair®	Bolt Torque (Nm)	Bolt Torque (Lbsft)	
076	RR61 L1 08	70-75 Nm	50-55 Lbsft	
Ø100	RR61 L3 08	70-75 Nm	50-55 Lbsft	
Ø168	RR63 L8 12	135-175 Nm	100-130 Lbsft	

Do's & Dont's





To complete the installation you will find hereafter a list of accessories you may need. Please contact us for further information and product part numbers.

Composite Automatic Safety Couplers: For quick and repetitive connection and disconnection 100% safety



in a reduced space 2m, 4m or 6m with internal diameters: 4 mm, 5 mm, 7 mm, 8 mm

Dusting, cooling and drying components

Removing swarf

Cleaning machinery

ISO B 8 mm

EURO 7,2 mm

ARO 5,5 mm

Very high flow, extremely low pressure loss

Profiles available: ISO B 5,5 mm

Hose Reels:

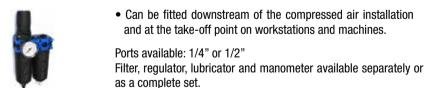
Blowgun:

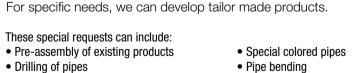
 Optimise productivity and the safety of your work area Prevent hose damage occuring on the workshop floor

10m, 16m or 21m 8 mm, 10 mm, 12,5 mm with internal diameter:

Compliance with OSHA 1910.242 (b) and OSHA 1910.95 (b)

RR63 L8 16 135-175 Nm









10/2015 POST/T0051/EN