

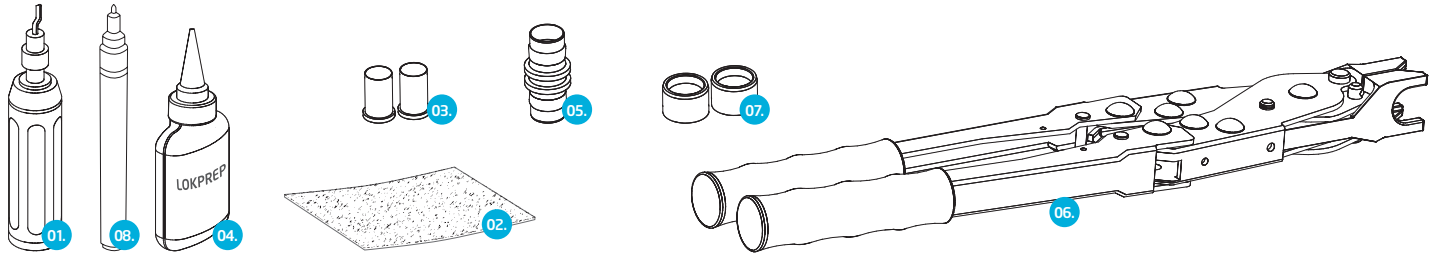


# ASSEMBLY INSTRUCTIONS

## LOKRING® tube connection assembly version 50

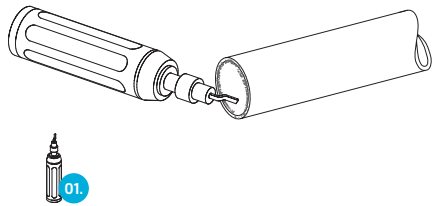
(The assembly version is determined on the basis of the last two figures in the article name. **Example:** LOKRING 6 NK Ms 50)

# VULKAN LOKRING

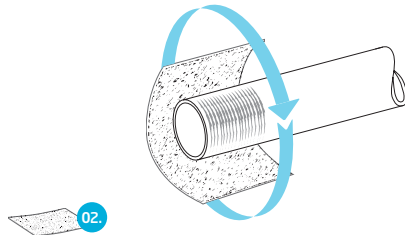


01. Tube deburrer 02. Abrasive mat 03. Stabilisation inserts 04. LOKPREP 05. joint 06. Hand assembly tool 07. LOKRINGS 08. Permanent marker

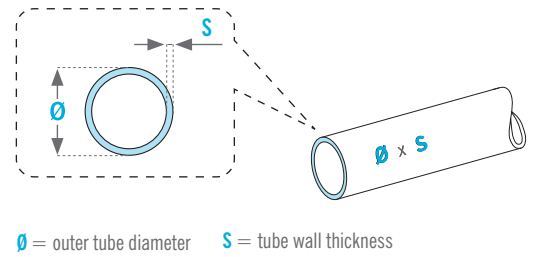
**!** Deburr the tube end all the way round using a tube deburrer (01). Use different deburring tools for different materials.



**!** Clean the tube end by rubbing it in rotary movements using the abrasive mat (02).

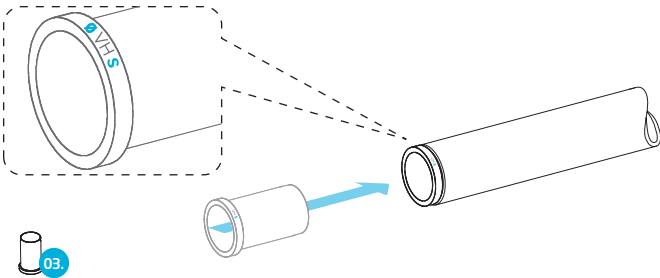


**!** Determine the tube wall thickness  $S$  and the outer tube diameter  $\emptyset$  on the basis of tube coding or using a slide gauge.

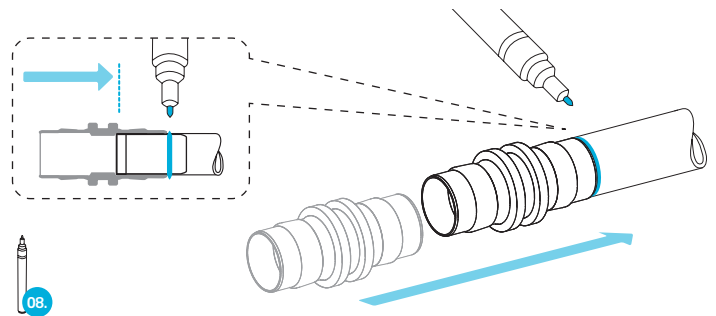


$\emptyset$  = outer tube diameter  $S$  = tube wall thickness

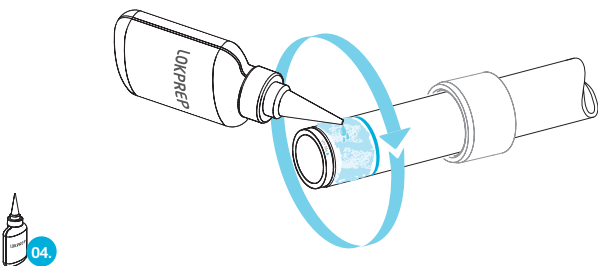
**1** Insert a stabilisation insert (03) suitable for the material, the outer tube diameter  $\emptyset$  and tube wall thickness  $S$ . Stabilisation inserts may not be necessary in case of use with refrigerants with an operating pressure lower than 25 bar (e.g. R134a car A/C systems or refrigerator cabinets).



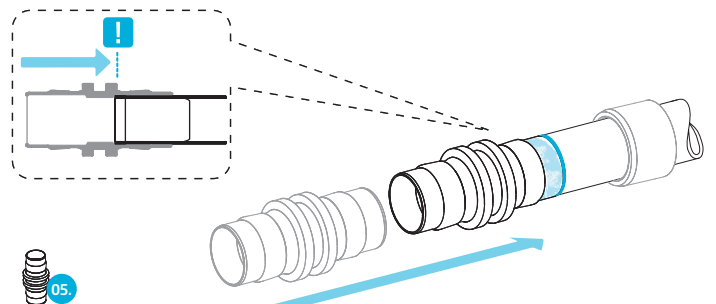
**2** Before applying the LOKPREP (04), push the connecting joint onto the tube until you can feel the inner stop. Mark (08) the correct insertion depth on the tube.



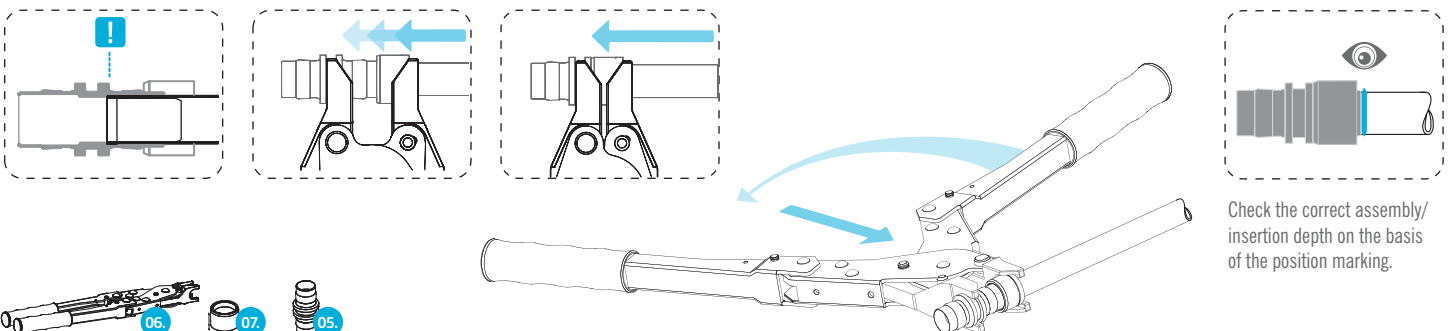
**3** Choose the correct LOKPREP for the tube material and the ambient temperature. Apply LOKPREP (04) all the way round the sealing area of the tube end. Respect the correct curing time of the LOKPREP.



**4** Push the connection joint (05) onto the tube until it reaches the inner stop **!**



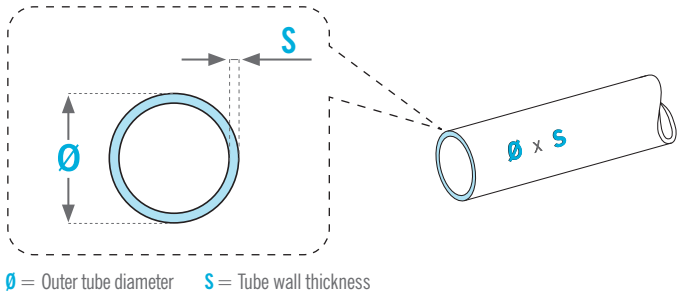
**5** Put the assembly jaws (06) in place behind the LOKRING (07) and the assembly stop of the joint (05). Press the tube connection together. **!** Do not change the insertion depth of the tube and connecting joint. Press the tube connection until the LOKRING (07) is flush to the assembly stop of the joint (05).



Check the correct assembly/insertion depth on the basis of the position marking.

# CHOOSING THE STABILISATION INSERT

LOKRING® tube connection assembly version 50



Article name                      Stabilisation insert                      Tube wall thickness in mm (S)

**LOKIN 6,35 VH Ms 08**

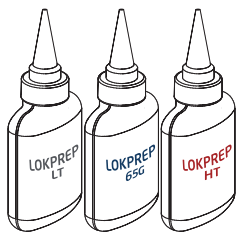
Outer tube diameter (Ø)                      Tube material  
 Ms for brass\* or Al for aluminium\*

\* Use Ms stabilisation inserts for copper tube and Al stabilisation inserts for aluminium tube.

**Note:** Stabilisation inserts must not be used inside an NRA adaptor or inside the stainless steel tube of a EURO flare-fitting.

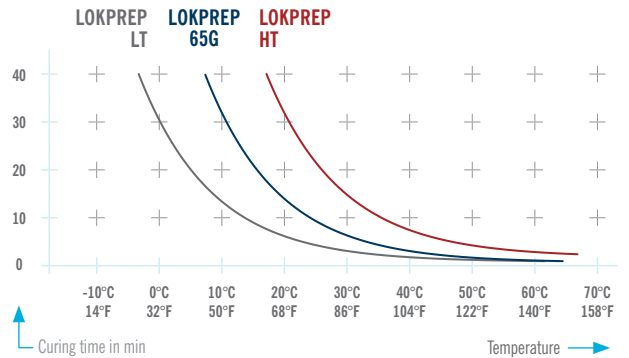
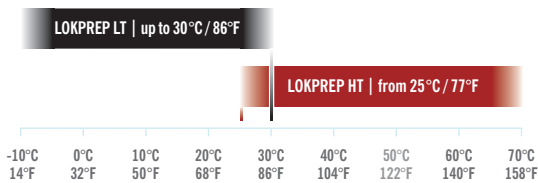
# CHOOSING THE LOKPREP

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- Use an aluminium LOKRING® connector and LOKPREP 65G for all connections from aluminium to aluminium or aluminium to copper. Always use a heat shrink sleeve for connections from aluminium to copper in order to protect the connection against corrosion.
- Use a brass LOKRING® connector and LOKPREP LT or LOKPREP HT for all connections from copper to copper.

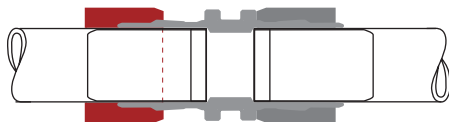
**!** The following diagram shows the suitable temperature ranges for LOKPREP LT and LOKPREP HT.



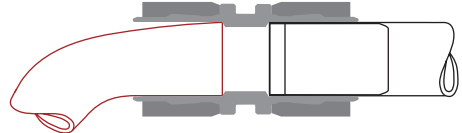
# EXAMPLES AS ASSEMBLY AID

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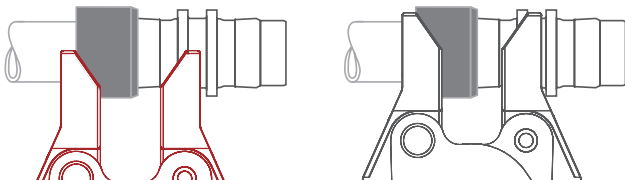
**!** **Wrong:** LOKRING has not been pressed through to the assembly stop.      **Right:** LOKRING has been pressed flush to the assembly stop.



**!** **Wrong:** Stabilisation insert is missing.      **Right:** Correct stabilisation insert is inserted.



**!** **Wrong:** Assembly jaws are not set in place correctly.      **Right:** Assembly jaws are set flush correctly.



**!** **Wrong:** The tube is not pushed in as far as the inner stop.      **Right:** Push the tube in until you can feel the inner stop.

