

# MAXAIR INSTALLATION GUIDELINES

**PROCEDURE: 1. INSTALL CLIPS & PIPE SUPPORT SYSTEM. 2. FOR SOCKET FUSION PRE-MANUFACTURE MAIN LINES ON GROUND.**

## Compression Fittings AIR20 to AIR63



1. Cut pipe to length with appropriate cutter (PC...) for a swarf-free finish.



2. Chamfer with appropriate chamfering tool. (CHAM...) This may not be necessary for AIR20, 25, 32.



3. Remove nut and conical grip ring from fitting and mount on pipe in the same order with the large end of the grip ring facing fitting. Lubricate, see notes\*, \*\*.



4. Insert the pipe into fitting with a twisting motion until it passes through the "O" ring and meets the internal shoulder. Ensure that grip ring is touching the fitting.



5. Screw and tighten the nut onto the fitting firmly by hand. The larger pipe sizes 40mm & upward will need tightening with the appropriate wrench (NW1) however, do not use excessive torque.

\*\* Lubricate with silicone spray, soapy water or vaseline except on specialist applications. ie: powder coating, spray painting, breathing & quality air, etc. DO NOT use penetrating fluids such as WD40, 5-56, Penetrene etc.

## Compression Fittings AIR90 to AIR110



1. Cut pipe to length and chamfer.  
2. Remove nut, conical grip ring, bushing and "O" ring and mount on pipe in the same order leaving out grip ring.  
3. Lubricate pipe end and inside of fitting. (See note below\*\*)



4. Insert pipe into the fitting until it meets the internal shoulder.



5. Bring up the "O" ring and bushing and tighten nut until they are fully in place.



6. Unscrew nut, open grip ring and put on pipe with the large end touching the bushing.



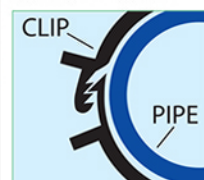
7. Tighten nut with the appropriate wrench (NW2) taking care not to use excessive force.

\*Fitting may be supplied with a tapered seal instead of O-Ring, -in this case nut need not be removed, - simply chamfer pipe, lubricate, fully insert, and tighten.

## CL Pipe Clips Installation



1. Mount pipe clip using appropriate fastener. In vertical mounting situations (horizontal pipe-work) ensure female ratchet is uppermost as shown below.



2. Pull clip apart and put the pipe in.



3. Press the pipe into clip towards the clip base and set to appropriate setting.



To remove pipe from clip push the 2 bands sideways in opposite directions to disengage.

## Pipe Support spacings

PIPE SIZE	HORIZONTAL SUPPORT SPACING	
	UP TO 25° C	UP TO 50° C
AIR20	700	600
AIR25	900	750
AIR32	1200	900
AIR40	1400	1100
AIR50	1600	1200
AIR63	1800	1400
AIR90	2000	1600
AIR110	2400	1800
AIR160	2700	2100

Spacings may need to be altered for various ambient temperatures encountered. Refer to Technical Department. For vertical fixing, the spacings may be increased approximately 20%. Spacings may also be increased using Continuous support Channel, see P17. Spacings will need to be decreased if pipework is conveying fluids.