Fittings for PE-X pipe



Gold-Therm

Data sheet LINE 3400 GOLD-THERM

Axial press nickel-plated fittings for Pe-X pipes

GENERAL FITTINGS
YOUNIQUE · ITALIAN

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LINE 3400

Axial press fittings for Pe-X pipes

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DESCRIPTION

3400 GOLD-THERM fittings are suitable for heating and cooling systems with radiant panels.
GOLD-THERM fittings and sleeves are not interchangeable with GOLD-FIX fittings and sleeves.

ADVANTAGES

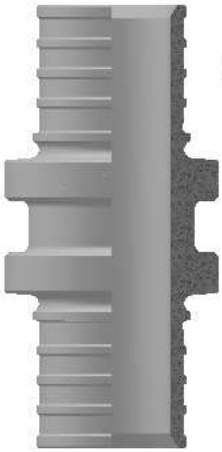
- Safe installation: watertight connection, without stagnation points and without requiring O-rings or additional gaskets
- Greater water flow and consequently lower pressure drops
- Heat treatment of the bush which guarantees greater plasticity, greater deformation capacity and less chance of breakage
- Great reliability over time
- Raw materials complying with UBA LIST

FIELDS OF APPLICATION

APPLICATIONS		T. min.	T. max	T. of the system	Max. pressure
	cooling	-20°C	+120°C	-20°C/+95°C	10 bar
	floor heating	-20°C	+120°C	-20°C/+95°C	10 bar
	-20°C: with the use of glycol in a maximum percentage of 30%				

COMPONENTS AND MATERIALS





LEGEND	COMPONENTS	MATERIALS
1	Sleeve	Brass CW612N - UNI EN 12164
2	Body	Brass CW617N - UNI EN 12165

SUITABLE PIPES

Fittings of line 3400 GOLD-THERM are suitable for installation with PE-Xa/EVOH pipes.
For the complete list of available pipes refer to the catalogue or visit the website www.generalfittings.it

REGULATIONS

• UNI EN ISO 15875-3
Plastic piping systems for hot and cold water installations

• UNI EN 1254-3
Fittings comply with UNI EN 1254-3 law: “Sanitary fittings for plastic pipes with compression ends”.

• UNI EN 10226-1
Threads comply with UNI EN 10226-1 law: “Piping thread for coupling on the thread”.

PIPE DIAMETERS - REAMERS AND JAWS

Pe-X		
Ø pipe	Reamer	Jaw
17 x 2.0	RH-HAS	RH 17
20 x 2.0	RH-HAS	RH 20

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CERTIFICATIONS

COUNTRY	CERTIFICATION	COUNTRY	CERTIFICATION
			

INSTRUCTIONS

The following instructions have to be applied to systems defined for GOLD-THERM fittings and PE-Xa pipe with oxygen barrier (dimensions 17-20).

Always use machines and equipments defined in General Fittings catalogue.

The direction of the sleeve is NOT reversible. The marking of the sleeve must always be opposite to the direction of pipe insertion.

General Fittings PE-Xa pipe is equipped with an oxygen barrier. The oxygen barrier is not flexible like the polyethylene pipe and could tear in the expansion phase of the pipe, especially at low temperatures. However, this does not affect safety and guarantee of the tightness.
If the expansion phase is made too quickly and at temperatures below 0°C, even the layer of PE-Xa pipe can be damaged, beside the oxygen barrier. In this case the damaged part of the pipe must be removed and reapeted the operation.

General Fittings Multilayer PE-Xa pipe is equipped with an oxygen barrier. If the expansion phase is carried out too quickly and at temperatures below zero, the layer of the PE-Xa pipe be damaged and lacerated. In this case the damaged part of the pipe must be removed and the operation must be repeated.
Manual machine and electrically operated machine: the manual machine is suitable for systems with PE-Xa pipe in sizes 17-20. The electrically operated machine it is suitable for PE-Xa pipes in sizes 17-20.

Fittings and sleeves must be protected before putting in contact with masonry from fluids and other aggressive substances by a suitable coating.

For any technical product information please contact directly the Technical Department of General Fittings Spa.

ASSEMBLY INSTRUCTIONS

Before cutting the pipe, check that the pipe has no surface defects and that the marking is readable and complete in all its parts



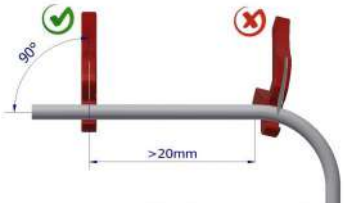
Always check that the shear blade is perfectly sharp, without dents or damaged parts



Cut the pipe perpendicularly to its axis using an appropriate pipe-cutting tool [code TT500.00].



The cut must always be made on the straight part of the pipe at a minimum distance of 150mm from the closest fitting or at a minimum distance of 20mm from the pipe's bend ending.
The cut must be clean, without pipe internal or external burs.



Check that the expander is not damaged and it is screwed up to the end. Once screwed the expander shouldn't unscrew during the rotation of the pipe on the expander. Verify that the tool we are going to use is correct and studied for the pipe we are going to assemble. Insert the expander without forcing and parallel to the axis of the pipe.



Insert the sleeve into the pipe, making sure that themarked strip is opposite to the cut of the pipe and thatthere is double distance compared to the sleeve betweenthe end of the pipe and the sleeve itself.



Gradually and homogeneously widen the pipe withoutheating the deforming parts.
Temperaturesrecommended during this flaring phase go from -10° C to+50 °C.
NB: according to the different pipes, use the appropriatereamer.



The expansion operation must be repeated at least a second time by turning the equipment by 30 °. If the internal part of the pipe is not perfectly cylindrical, repeat the described operations again.



Cut pipes which are not circular adjust after expansion and waste the piece of non-conformed pipe. Replace expanders which are damaged or do not allow perfect circularity of the enlarged pipe. The defective expander can cause sealing problems over time.
Grease the expander cone if the actuation of the tool is difficult.
If, after the expansion, there are cracks or slots on the pipe, remove the damaged tube and repeat the expansion operation.



If all raccomended procedures for the expansion of the pipe have been adopted, the pipe will slide onto the fitting without forcing. If the insertion of the pipe is difficut, repeat the above mentioned expansion operations.



The pipe has a natural return effect (memory effect). Pipe and fitting assembly operations must therefore be carried out quickly. All sealing ribs of the fitting must covered by the pipe inserted manually.



MANUAL: Push the sleeve towards the fitting. Put theelements in the jaws of the pressing machine, makingsure that the sleeve and the fitting collar are insertedproperly.



AUTOMATIC: Push the sleeve towards the fitting. Put theelements in the jaws of the pressing machine, makingsure that sleeve and fitting collar are inserted properly.



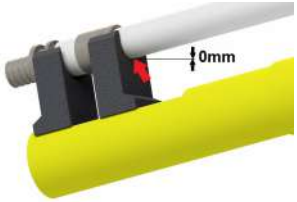
Start the pressing machine.



Make sure that the assembled sleeve is up the stroke of the fitting's body.



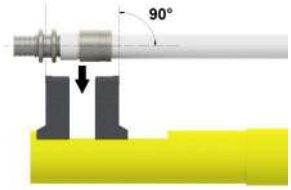
Put pipe and sleeve in abutment.



Check that sleeve and fitting are always inserted in the correct position.



The perpendicular positioning allows a coaxial assembly of the sleeve.



GENERAL FITTINGS SPA
Via Golgi 73/75, 25064 Gussago (BS) - ITALY
te. +39 030 3739017
www.generalfittings.it