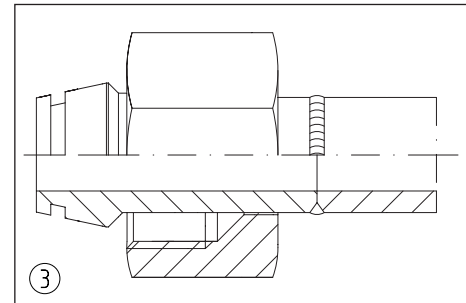
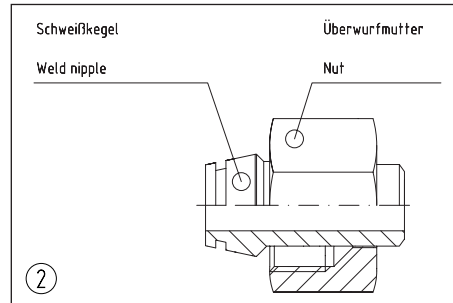
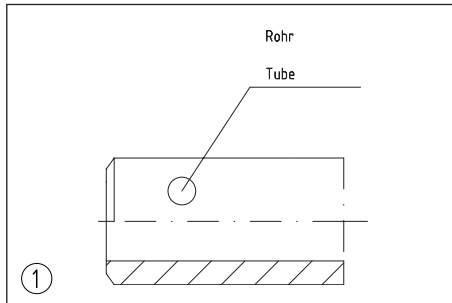


SCHWEISSKEGEL-VERSCHRAUBUNGEN MIT O-RING WELD NIPPLE-COUPLINGS WITH O-RING

MONTAGEANLEITUNG - SCHWEISSKEGEL-VERSCHRAUBUNGEN	ASSEMBLY INSTRUCTIONS - WELD NIPPLE COUPLINGS	10.3
ESV - SCHOTT-VERSCHRAUBUNGEN	ESV - BULKHEAD COUPLINGS	10.4
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MONTAGEANLEITUNG SCHWEISSKEGEL-VERSCHRAUBUNGEN

ASSEMBLY INSTRUCTIONS WELD NIPPLE COUPLINGS



1. Rohr rechtwinklig ablängen, entgraten und anfasen für V-Naht nach DIN 2559.

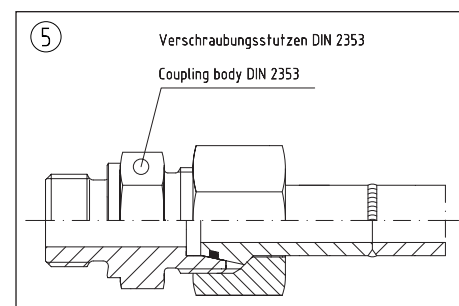
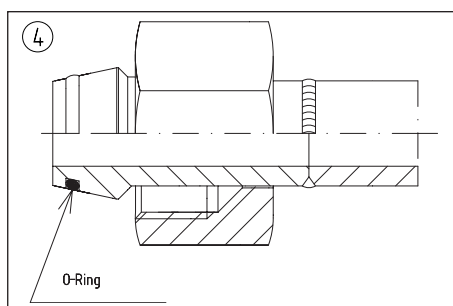
2. Überwurfmutter, wie abgebildet, über den Schweißkegel schieben.

3. Schweißkegel und Rohr nach den Schweißrichtlinien verschweißen. Darauf achten, dass keine Schweißperlen ins Rohrrinnere gelangen. Kegel, Nut und Stutzenkonus müssen sauber sein.

1. Cut tube at right angles and chamfer it for V-welding seam to DIN 2559.

2. Slide nut over weld nipple arrangement as shown above.

3. Weld nipple and tube are welded according to the general welding instructions. Please ensure that no globules of weld enter the inside of the tube. Nipple, groove and taper must be clean.



4. O-ring erst nach dem Schweißen in die Nut einlegen. Er darf sich nicht verdrehen. Schweißkegel, Konus und Innen- und Außengewinde einölen, nicht einfetten.

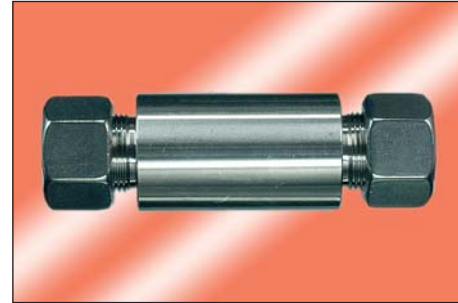
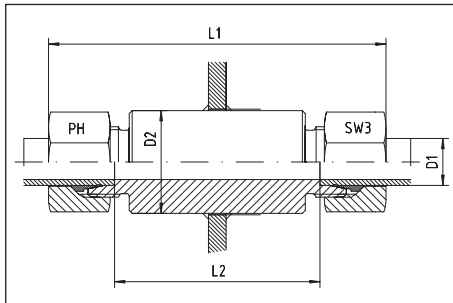
5. Überwurfmutter von Hand auf den Stutzen schrauben, dann mit dem Schlüssel ca. 1/4 - 1/3 Umdrehung anziehen. Das Rohr mit angeschweißtem Kegel muss spannungsfrei verschraubt und verlegt werden.

4. O-ring is only to be inserted into groove after welding. O-ring must not be twisted. Do not grease, but oil nipple, taper inside and outside of thread.

5. Screw the nut by hand onto the body, tighten nut with a spanner approx. 1/4 – 1/3 of a turn. Tube with welded nipple has to be installed free of tension.

Einschweiß-Schottverschraubungen

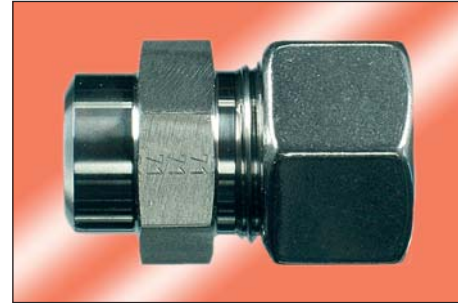
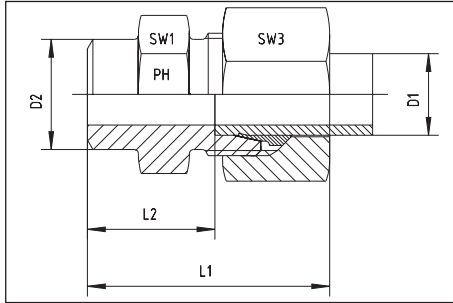
Welding bulkhead connections



Reihe Series	Druck Pressure PN	Rohr A.D. Tube O.D.		ca. Maße approx. dimensions			Bestellzeichen Order-Code
		D1	D2	L1	L2	SW3	
L	315	6	18	85	56	14	ESV-L-06
L	315	8	20	85	56	17	ESV-L-08
L	315	10	22	87	58	19	ESV-L-10
L	315	12	25	87	58	22	ESV-L-12
L	315	15	28	100	70	27	ESV-L-15
L	315	18	32	101	69	32	ESV-L-18
L	160	22	36	105	73	36	ESV-L-22
L	160	28	40	106	73	41	ESV-L-28
L	160	35	50	114	71	50	ESV-L-35
L	160	42	60	115	70	60	ESV-L-42
S	630	6	20	89	60	17	ESV-S-06
S	630	8	22	89	60	19	ESV-S-08
S	630	10	25	91	59	22	ESV-S-10
S	630	12	28	91	59	24	ESV-S-12
S	630	14	30	107	72	27	ESV-S-14
S	400	16	35	107	71	30	ESV-S-16
S	400	20	38	114	71	36	ESV-S-20
S	400	25	45	120	72	46	ESV-S-25
S	400	30	50	126	73	50	ESV-S-30
S	315	38	60	133	72	60	ESV-S-38

Gerade Anschweißverschraubungen

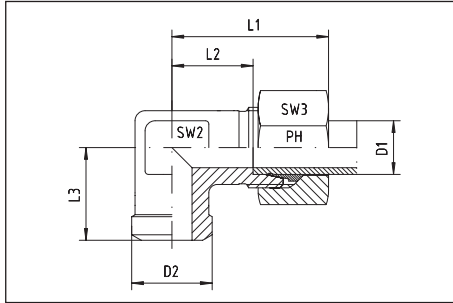
Straight welding bosses



Reihe Series	Druck Pressure PN	Rohr A.D. Tube O.D.		ca. Maße approx. dimensions				Bestellzeichen Order-Code
		D1	D2	L1	L2	SW1	SW3	
L	315	6	10	29	14,0	12	14	ASV-L-06
L	315	8	12	31	16,0	14	17	ASV-L-08
L	315	10	14	33	18,0	17	19	ASV-L-10
L	315	12	16	33	18,0	19	27	ASV-L-12
L	315	15	19	37	22,0	22	27	ASV-L-15
L	315	18	22	40	23,5	27	32	ASV-L-18
L	160	22	27	45	28,5	32	36	ASV-L-22
L	160	28	32	47	30,5	41	41	ASV-L-28
L	160	35	40	54	32,5	46	50	ASV-L-35
L	160	42	46	58	35,0	55	60	ASV-L-42
S	630	6	11	34	19,0	14	17	ASV-S-06
S	630	8	13	36	21,0	17	19	ASV-S-08
S	630	10	15	39	22,5	19	22	ASV-S-10
S	630	12	17	41	24,5	22	24	ASV-S-12
S	630	14	19	45	27,0	24	27	ASV-S-14
S	400	16	21	45	26,5	27	30	ASV-S-16
S	400	20	26	51	29,5	32	36	ASV-S-20
S	400	25	31	56	32,0	41	46	ASV-S-25
S	400	30	36	62	35,5	46	50	ASV-S-30
S	315	38	44	69	38,0	55	60	ASV-S-38

Winkel-Anschweißverschraubungen

Elbow-welding-couplings



Reihe Series	Druck Pressure PN	Rohr A.D. Tube O.D.		ca. Maße approx. dimensions					Bestellzeichen Order-Code
		D1	D2	L1	L2	L3	SW2	SW3	
L	315	6	10	27	12,0	19	12	14	WAS-L-06
L	315	8	12	29	14,0	23	12	17	WAS-L-08
L	315	10	14	30	15,0	24	14	19	WAS-L-10
L	315	12	16	32	17,0	25	17	22	WAS-L-12
L	315	15	19	36	21,0	30	19	27	WAS-L-15
L	315	18	22	40	23,5	33	24	32	WAS-L-18
L	160	22	27	44	27,5	37	27	36	WAS-L-22
L	160	28	32	47	30,5	42	36	41	WAS-L-28
L	160	35	40	56	34,5	49	41	50	WAS-L-35
L	160	42	46	63	40,0	57	50	60	WAS-L-42
S	630	6	11	31	16,0	23	12	17	WAS-S-06
S	630	8	13	32	17,0	24	14	19	WAS-S-08
S	630	10	15	34	17,5	25	17	22	WAS-S-10
S	630	12	17	38	21,5	29	17	24	WAS-S-12
S	630	14	19	40	22,0	30	19	27	WAS-S-14
S	400	16	21	43	24,5	33	24	30	WAS-S-16
S	400	20	26	48	26,5	37	27	36	WAS-S-20
S	400	25	31	54	30,0	42	36	46	WAS-S-25
S	400	30	36	62	35,5	49	41	50	WAS-S-30
S	315	38	44	72	41,0	57	50	60	WAS-S-38

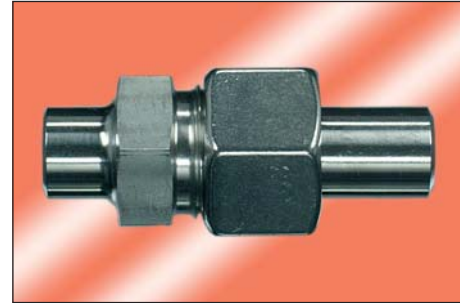
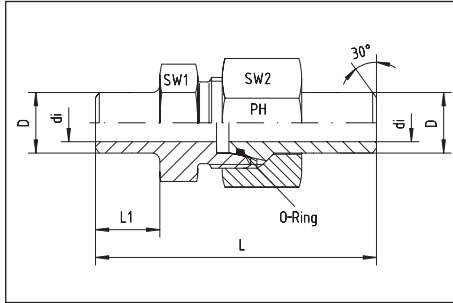
SCHWEISSKEGEL- VERSCHRAUBUNGEN



WELDING NIPPLE COUPLINGS

Mit O-ring Abdichtung - NBR
Auf Anfrage: Viton

With O-ring gasket - NBR
On request: Viton



Reihe Series	Druck Pressure PN	Rohr A. D. Tube O. D.	ca. Maße approx. dimensions						O-ring O-ring	Bestellzeichen Order-Code
			L	L1	D	di	SW1	SW3		
S	528	6 x 1,5			6	3	14	17	4,0 x 1,5	ASV K 6x1,5
S	414	8 x 1,5			8	5	17	19	6,0 x 1,5	ASV K 8x1,5
S	528	8 x 2			8	4	17	19	6,0 x 1,5	ASV K 8x2
S	249	10 x 1	58,0	10,0	10	8	19	22	7,5 x 1,5	ASV K 10x1
S	358	10 x 1,5	58,0	10,0	10	7	19	22	7,5 x 1,5	ASV K 10x1,5
S	460	10 x 2	58,0	10,0	10	6	19	22	7,5 x 1,5	ASV K 10x2
S	305	12 x 1,5	63,0	15,0	12	9	22	24	9,0 x 1,5	ASV K 12x1,5
S	393	12 x 2	63,0	15,0	12	8	22	24	9,0 x 1,5	ASV K 12x2
S	476	12 x 2,5	63,0	15,0	12	7	22	24	9,0 x 1,5	ASV K 12x2,5
S	343	14 x 2			14	10	24	27	10,0 x 2,0	ASV K 14x2
S	487	14 x 3			14	8	24	27	10,0 x 2,0	ASV K 14x3
S	305	16 x 2	73,5	16,5	16	12	27	30	12,0 x 2,0	ASV K 16x2
S	372	16 x 2,5	73,5	16,5	16	11	27	30	12,0 x 2,0	ASV K 16x2,5
S	400	16 x 3	73,5	16,5	16	10	27	30	12,0 x 2,0	ASV K 16x3
S	249	20 x 2	83,5	19,0	20	16	32	36	16,3 x 2,4	ASV K 20x2
S	305	20 x 2,5	83,5	19,0	20	15	32	36	16,3 x 2,4	ASV K 20x2,5
S	358	20 x 3	83,5	19,0	20	14	32	36	16,3 x 2,4	ASV K 20x3
S	400	20 x 4	83,5	19,0	20	12	32	36	16,3 x 2,4	ASV K 20x4
S	294	25 x 3	92,5	19,5	25	19	41	46	20,3 x 2,4	ASV K 25x3
S	379	25 x 4	92,5	19,5	25	17	41	46	20,3 x 2,4	ASV K 25x4
S	400	25 x 5	92,5	19,5	25	15	41	46	20,3 x 2,4	ASV K 25x5
S	249	30 x 3	101,5	23,0	30	24	46	50	25,3 x 2,4	ASV K 30x3
S	323	30 x 4	101,5	23,0	30	22	46	50	25,3 x 2,4	ASV K 30x4
S	393	30 x 5	101,5	23,0	30	20	46	50	25,3 x 2,4	ASV K 30x5
S	400	30 x 6	101,5	23,0	30	18	46	50	25,3 x 2,4	ASV K 30x6
S	261	38 x 4	108,0	22,0	38	30	55	60	33,3 x 2,4	ASV K 38x4
S	315	38 x 5	108,0	22,0	38	28	55	60	33,3 x 2,4	ASV K 38x5
S	315	38 x 6	108,0	22,0	38	26	55	60	33,3 x 2,4	ASV K 38x6
S	315	38 x 7	108,0	22,0	38	24	55	60	33,3 x 2,4	ASV K 38x7
S	250	50 x 5	118,0	23,0	50	40	70	80	46,0 x 3,0	ASV K 50x5
S	310	50 x 6	118,0	23,0	50	38	70	80	46,0 x 3,0	ASV K 50x6
S	350	50 x 7	118,0	23,0	50	36	70	80	46,0 x 3,0	ASV K 50x7
L	323	15 x 2	54,5	15,0	15	11	22	27	12,0 x 2,0	ASV K 15x2
L	315	18 x 2	57,5	16,0	18	14	27	32	15,0 x 2,0	ASV K 18x2
L	280	22 x 2,5	74,0	19,0	22	17	32	36	20,0 x 2,0	ASV K 22x2,5
L	265	28 x 3	78,0	19,0	28	22	41	41	26,0 x 2,0	ASV K 28x3
L	231	35 x 3	87,5	22,0	35	29	46	50	32,0 x 2,5	ASV K 35x3
L	182	42 x 3	87,0	22,0	42	36	55	60	38,0 x 2,5	ASV K 42x3

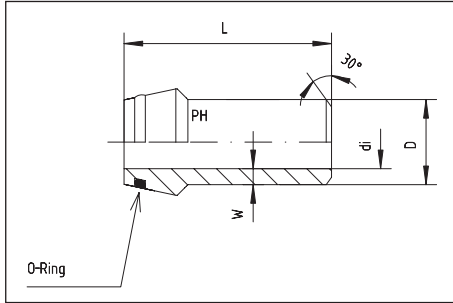
SCHWEISSNIPPEL



WELDING NIPPLES

Mit O-ring
 Abdichtung - NBR
 Auf Anfrage: Viton
 Passend in 24°-Innenkonus (Bohrungsform W DIN 3861)

With O-ring
 Gasket - NBR
 On request: Viton
 Matching type 24°-inside tapers (bore type W DIN 3861)



Reihe Series	Druck Pressure PN	D x W	ca. Maße approx. dimensions		O-ring O-ring	Bestellzeichen Order-Code
			di	L		
L + S	528	6 x 1,5	3	31,0	4,0 x 1,5	SKV 6x1,5
L + S	414	8 x 1,5	5	31,0	6,0 x 1,5	SKV 8x1,5
L + S	528	8 x 2	4	31,0	6,0 x 1,5	SKV 8x2
L + S	249	10 x 1	8	32,5	7,5 x 1,5	SKV 10x1
L + S	358	10 x 1,5	7	32,5	7,5 x 1,5	SKV 10x1,5
L + S	460	10 x 2	6	32,5	7,5 x 1,5	SKV 10x2
L + S	305	12 x 1,5	9	32,5	9,0 x 1,5	SKV 12x1,5
L + S	393	12 x 2	8	32,5	9,0 x 1,5	SKV 12x2
L + S	476	12 x 2,5	7	32,5	9,0 x 1,5	SKV 12x2,5
L + S		12 x 3	6	32,5	9,0 x 1,5	SKV 12x3
S	343	14 x 2	10	40,0	10,0 x 2,0	SKV 14x2
S	415	14 x 2,5	9	40,0	10,0 x 2,0	SKV 14x2,5
S	487	14 x 3	8	40,0	10,0 x 2,0	SKV 14x3
L	270	15 x 1,5	12	36,0	12,0 x 2,0	SKV 15x1,5
L	323	15 x 2	11	36,0	12,0 x 2,0	SKV 15x2
L	393	15 x 2,5	10	36,0	12,0 x 2,0	SKV 15x2,5
S	305	16 x 2	12	38,5	12,0 x 2,0	SKV 16x2
S	372	16 x 2,5	11	38,5	12,0 x 2,0	SKV 16x2,5
S	435	16 x 3	10	38,5	12,0 x 2,0	SKV 16x3
L	225	18 x 1,5	15	37,0	15,0 x 2,0	SKV 18x1,5
L	300	18 x 2	14	37,0	15,0 x 2,0	SKV 18x2
L	335	18 x 2,5	13	37,0	15,0 x 2,0	SKV 18x2,5
S	249	20 x 2	16	44,5	16,3 x 2,4	SKV 20x2
S	305	20 x 2,5	15	44,5	16,3 x 2,4	SKV 20x2,5
S	358	20 x 3	14	44,5	16,3 x 2,4	SKV 20x3
S	460	20 x 4	12	44,5	16,3 x 2,4	SKV 20x4
L	245	22 x 2	18	38,5	20,0 x 2,0	SKV 22x2
L	280	22 x 2,5	17	38,5	20,0 x 2,0	SKV 22x2,5
L	328	22 x 3	16	38,5	20,0 x 2,0	SKV 22x3
S	294	25 x 3	19	49,5	20,3 x 2,4	SKV 25x3
S	337	25 x 3,5	18	49,5	20,3 x 2,4	SKV 25x3,5
S	379	25 x 4	17	49,5	20,3 x 2,4	SKV 25x4
S	460	25 x 5	15	49,5	20,3 x 2,4	SKV 25x5
L	193	28 x 2	24	41,5	26,0 x 2,0	SKV 28x2
L	224	28 x 2,5	23	41,5	26,0 x 2,0	SKV 28x2,5
L	265	28 x 3	22	41,5	26,0 x 2,0	SKV 28x3
S	249	30 x 3	27	52,0	25,3 x 2,4	SKV 30x3
S	323	30 x 4	22	52,0	25,3 x 2,4	SKV 30x4
S	393	30 x 5	20	52,0	25,3 x 2,4	SKV 30x5
S	460	30 x 6	18	52,0	25,3 x 2,4	SKV 30x6
L	154	35 x 2	31	47,0	32,0 x 2,5	SKV 35x2
L	193	35 x 2,5	30	47,0	32,0 x 2,5	SKV 35x2,5
L	231	35 x 3	29	47,0	32,0 x 2,5	SKV 35x3
L	249	35 x 3,5	28	47,0	32,0 x 2,5	SKV 35x3,5
S	261	38 x 4	30	56,5	33,3 x 2,4	SKV 38x4
S	319	38 x 5	28	56,5	33,3 x 2,4	SKV 38x5
S	375	38 x 6	26	56,5	33,3 x 2,4	SKV 38x6
S	429	38 x 7	24	56,5	33,3 x 2,4	SKV 38x7
L	129	42 x 2	38	47,0	38,0 x 2,5	SKV 42x2
L		42 x 2,5	37	47,0	38,0 x 2,5	SKV 42x2,5
L	182	42 x 3	36	47,0	38,0 x 2,5	SKV 42x3
L	238	42 x 4	34	47,0	38,0 x 2,5	SKV 42x4
S	250	50 x 5	40	61,0	46,0 x 3,0	SKV 50x5
S	310	50 x 6	38	61,0	46,0 x 3,0	SKV 50x6
S	350	50 x 7	36	61,0	46,0 x 3,0	SKV 50x7

Mit O-ring - NBR

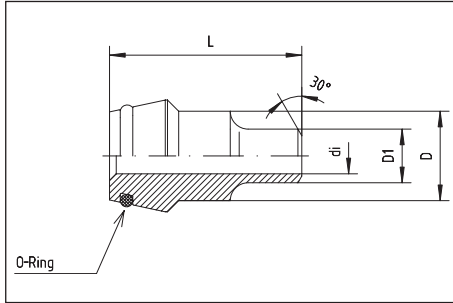
Auf Anfrage: Viton

Passend in 24°-Innenkonus (Bohrungsform W DIN 3861)

With O-ring - NBR

On request: Viton

Matching type 24°-inside tapers (bore type W DIN 3861)



Reihe Series	Druck Pressure PN	ca. Maße approx. dimensions				O-ring O-ring	Bestellzeichen Order-Code
		D	D1	di	L		
S		8	6	4	30	6,0 x 1,5	SKV-R-8/6x1
S	528	8	6	3	30	6,0 x 1,5	SKV-R-8/6x1,5
S	414	10	8	5	32	7,5 x 1,5	SKV-R-10/8x1,5
S	528	10	8	4	32	7,5 x 1,5	SKV-R-10/8x2
S	528	10	6	3	32	7,5 x 1,5	SKV-R-10/6x1,5
S	358	12	10	7	32	9,0 x 1,5	SKV-R-12/10x1,5
S	460	12	10	6	32	9,0 x 1,5	SKV-R-12/10x2
S	414	12	8	5	32	9,0 x 1,5	SKV-R-12/8x1,5
S		12	6	4	32	9,0 x 1,5	SKV-R-12/6x1
S	528	12	6	3	32	9,0 x 1,5	SKV-R-12/6x1,5
S	393	16	12	8	39	12,0 x 2,0	SKV-R-16/12x2
S	460	16	10	6	39	12,0 x 2,0	SKV-R-16/10x2
S	414	16	8	5	39	12,0 x 2,0	SKV-R-16/8x1,5
S	435	20	16	10	43	16,3 x 2,4	SKV-R-20/16x3
S	372	20	16	11	43	16,3 x 2,4	SKV-R-20/16x2,5
S	305	20	16	12	43	16,3 x 2,4	SKV-R-20/16x2
S	393	20	12	8	43	16,3 x 2,4	SKV-R-20/12x2
S	358	20	10	7	43	16,3 x 2,4	SKV-R-20/10x1,5
S	414	20	8	5	43	16,3 x 2,4	SKV-R-20/8x1,5
S	358	25	20	14	50	20,3 x 2,4	SKV-R-25/20x3
S	305	25	20	15	50	20,3 x 2,4	SKV-R-25/20x2,5
S	249	25	20	16	50	20,3 x 2,4	SKV-R-25/20x2
S	435	25	16	10	50	20,3 x 2,4	SKV-R-25/16x3
S	372	25	16	11	50	20,3 x 2,4	SKV-R-25/16x2,5
S	305	25	16	12	50	20,3 x 2,4	SKV-R-25/16x2
S	393	25	12	8	50	20,3 x 2,4	SKV-R-25/12x2
S	460	25	10	6	50	20,3 x 2,4	SKV-R-25/10x2
S	294	30	25	19	52	25,3 x 2,4	SKV-R-30/25x3
S	358	30	20	14	52	25,3 x 2,4	SKV-R-30/20x3
S	435	30	16	10	52	25,3 x 2,4	SKV-R-30/16x3
S	393	30	12	8	52	25,3 x 2,4	SKV-R-30/12x2
S	323	38	30	22	58	33,3 x 2,4	SKV-R-38/30x4
S	249	38	30	24	58	33,3 x 2,4	SKV-R-38/30x3
S	379	38	25	17	58	33,3 x 2,4	SKV-R-38/25x4
S	294	38	25	19	58	33,3 x 2,4	SKV-R-38/25x3
S	358	38	20	14	58	33,3 x 2,4	SKV-R-38/20x3
S	305	38	20	15	58	33,3 x 2,4	SKV-R-38/20x2,5
S	435	38	16	10	58	33,3 x 2,4	SKV-R-38/16x3
S	305	38	16	12	58	33,3 x 2,4	SKV-R-38/16x2
S	393	38	12	8	58	33,3 x 2,4	SKV-R-38/12x2

SCHWEISSNIPPEL-ROHRBÖGEN



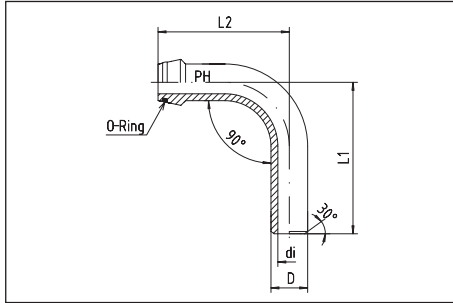
WELDING NIPPLE ELBOWS

90°

Abdichtung - NBR

Auf Anfrage: Viton

Passend in 24°-Innenkonus (Bohrungsform W DIN 3861)



90°

Gasket - NBR

On request: Viton

Matching type 24°-inside tapers (bore type W DIN 3861)



Reihe Series	Druck Pressure PN	Rohr Tube	ca. Maße approx. dimensions				O-ring O-ring	Bestellzeichen Order-Code
			D	di	L1	L2		
S	460	10 x 2	10	6	49	51	7,5 x 1,5	SKV-RB-10x2
S	393	12 x 2	12	8	50	51	9,0 x 1,5	SKV-RB-12x2
S	476	12 x 2,5	12	7	50	51	9,0 x 1,5	SKV-RB-12x2,5
S	305	16 x 2	16	12	72	67	12,0 x 2,0	SKV-RB-16x2
S	372	16 x 2,5	16	11	72	67	12,0 x 2,0	SKV-RB-16x2,5
S	435	16 x 3	16	10	72	67	12,0 x 2,0	SKV-RB-16x3
S	249	20 x 2	20	16	89	86	16,3 x 2,4	SKV-RB-20x2
S	305	20 x 2,5	20	15	89	86	16,3 x 2,4	SKV-RB-20x2,5
S	358	20 x 3	20	14	89	86	16,3 x 2,4	SKV-RB-20x3
L		22 x 3	22	16	79	85	19,0 x 2,0	SKV-RB-22x3
S	294	25 x 3	25	19	93	89	20,3 x 2,4	SKV-RB-25x3
S	379	25 x 4	25	17	93	89	20,3 x 2,4	SKV-RB-25x4
S	460	25 x 5	25	15	93	89	20,3 x 2,4	SKV-RB-25x5
S	323	30 x 4	30	22	112	105	25,3 x 2,4	SKV-RB-30x4
S	393	30 x 5	30	20	112	105	25,3 x 2,4	SKV-RB-30x5
S	460	30 x 6	30	18	112	105	25,3 x 2,4	SKV-RB-30x6
S	261	38 x 4	38	30	145	137	33,3 x 2,4	SKV-RB-38x4
S	319	38 x 5	38	28	145	137	33,3 x 2,4	SKV-RB-38x5
S	375	38 x 6	38	26	145	137	33,3 x 2,4	SKV-RB-38x6
S	429	38 x 7	38	24	145	137	33,3 x 2,4	SKV-RB-38x7