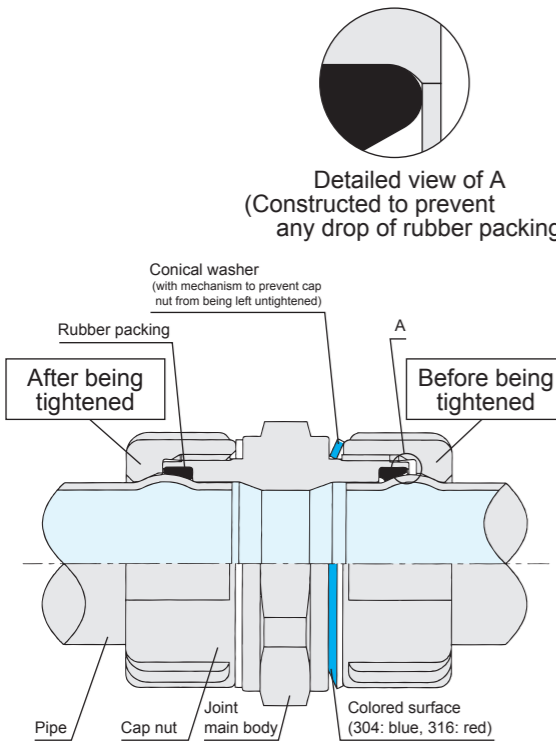

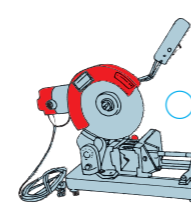
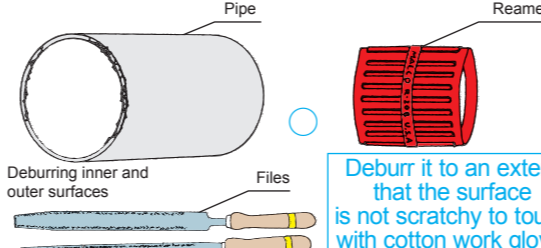
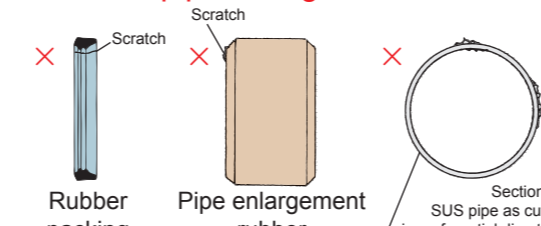
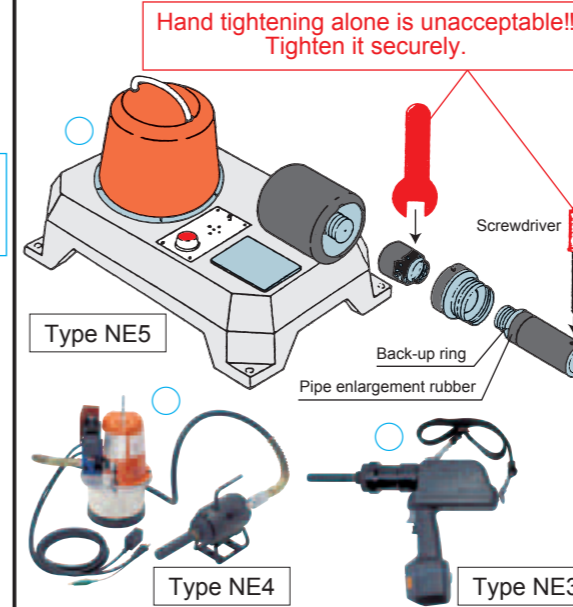
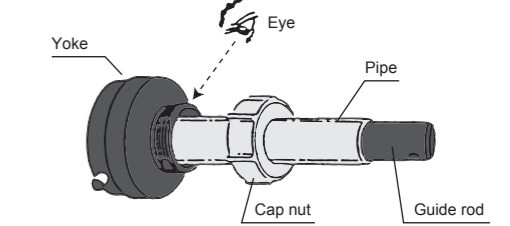
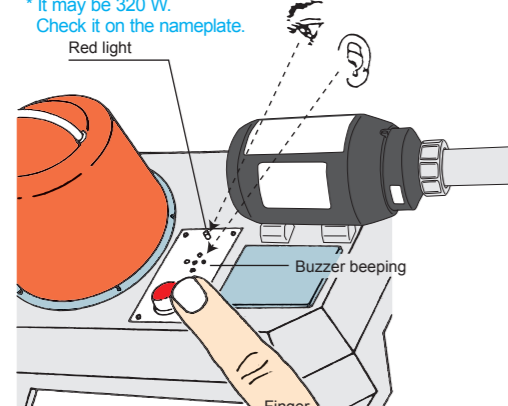
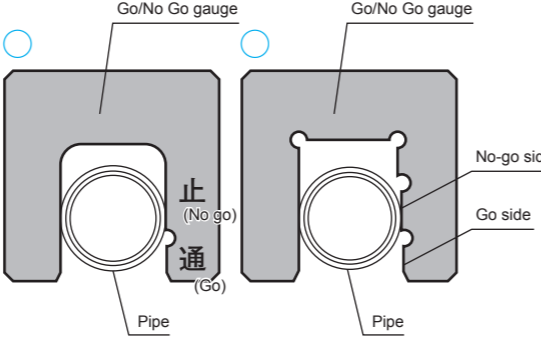
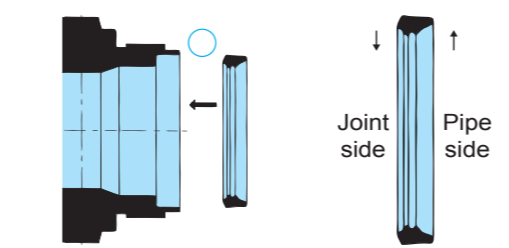
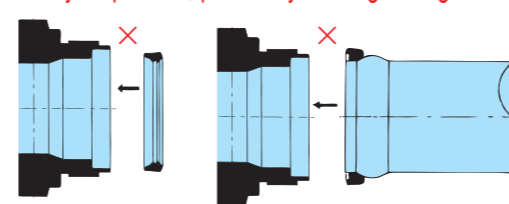
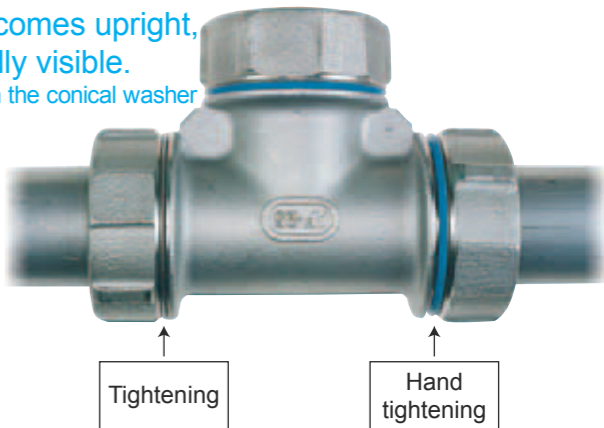
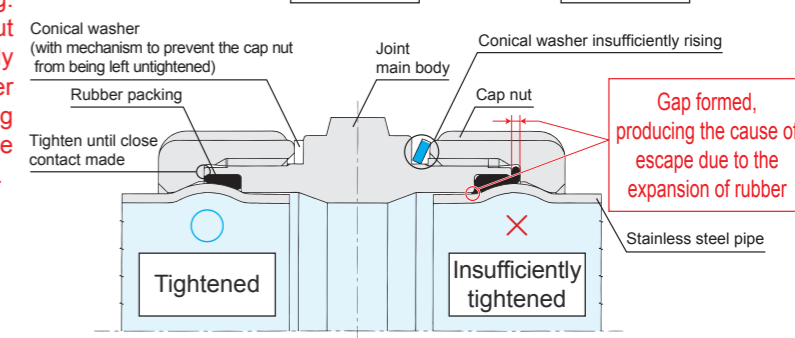


O.N. Fitting Work Execution Instructions

○ = standard operation; × = defective example

Construction of Nice Joint	(1) Operation type: Pipe cutting	(2) Operation type: Pipe deburring	(3) Operation type: Attachment setup	(4) Operation type: Pipe insertion
 <p>Detailed view of A (Constructed to prevent any drop of rubber packing)</p> <p>Conical washer (with mechanism to prevent cap nut from being left untightened)</p> <p>Rubber packing</p> <p>After being tightened</p> <p>Before being tightened</p> <p>Pipe</p> <p>Cap nut</p> <p>Joint main body</p> <p>Colored surface (304: blue, 316: red)</p>	<p>○ = stainless steel pipe cutting machine 122J-S, band saw, metal saw, or chip saw used</p> <p>Stainless steel pipe cutting machine 122J-S</p> <p>* The system causes no outer burr. (Equipped with inner surface reamer intended for inner burrs)</p>  <p>× = Do not use a pipe cutter. It reduces the inner diameter, making it impossible to fit into the guide rod.</p> 	<p>○ = Use a round file, half round file and/or reamer.</p>  <p>Deburring inner and outer surfaces</p> <p>Files</p> <p>Reamer</p> <p>Deburr it to an extent that the surface is not scratchy to touch with cotton work glove.</p> <p>× = If the deburring is insufficient: Outer burr: Rubber packing will be damaged, causing leakage. Inner burr: Causes scratch on the pipe enlargement rubber.</p>  <p>Scratch</p> <p>Rubber packing</p> <p>Pipe enlargement rubber</p> <p>Section of SUS pipe as cut in circumferential direction</p>	<p>○ = Use spanner and screwdriver contained in the toolbox.</p> <p>Hand tightening alone is unacceptable!! Tighten it securely.</p>  <p>Type NE5</p> <p>Type NE4</p> <p>Type NE3</p> <p>Back-up ring</p> <p>Pipe enlargement rubber</p> <p>Screwdriver</p> <p>× = Hand tightening will make the pipe enlargement defective.</p>	<p>○ = Insert the pipe all the way until it hits. Hand-tighten the cap nut as far as it goes.</p>  <p>Yoke</p> <p>Eye</p> <p>Pipe</p> <p>Cap nut</p> <p>Guide rod</p> <p>× = Any insufficient insertion may cause a bend in piping and/or leakage. Insufficient hand-tightening of nut may cause defective pipe enlargement, resulting in leakage.</p>
<p>(5) Operation type: Pipe enlargement</p> <p>○ = Type NE5 Once the buzzer beeps and light illuminates, take your finger off the button. Motor capacity = 400 W, power supply 100 VAC * It may be 320 W. Check it on the nameplate.</p>  <p>Red light</p> <p>Buzzer beeping</p> <p>Finger</p> <p>○ = Type NE4 Keep the button pressed for 2-3 seconds after a change in the hydraulic sound.</p> <p>○ = Type NE3 Once you hear a sound "click, click, click," take your finger off the button and press the return switch.</p> <p>× = If the button is released on the way, it will cause an insufficient pipe enlargement, potentially causing leakage.</p>	<p>(6) Operation type: Enlarged section measurement</p> <p>○ = Pass if the enlarged section stops on the No-go side.</p> <p>(1) Conduct the inspection when replacing the attachment.</p> <p>(2) Conduct it once for every 50 times.</p> <p>Pipe enlargement rubber is consumable (with service life of about 400 times).</p>  <p>Go/No Go gauge</p> <p>Go/No Go gauge</p> <p>No-go side</p> <p>Go side</p> <p>○ = Fail if the enlarged section passes on the No-go side, because it may cause leakage. Replace the pipe enlargement rubber. Re-inspect the tightening of the tool.</p>	<p>(7) Operation type: Rubber packing direction</p> <p>○ = Fitting onto the joint main body</p> <p>The rubber packing will not drop since the joint is constructed to prevent the packing from dropping. However, be careful of the direction of the packing when replacing it.</p>  <p>Joint side</p> <p>Pipe side</p> <p>× = If fitted in reversed direction, the packing will decrease in the service life, potentially resulting in leakage. If the packing is inserted as fitted onto the pipe, it may be pinched, potentially causing leakage.</p> 	<p>(8) Operation type: Cap nut tightening (equipped with a mechanism to prevent cap nut from being left untightened)</p> <p>○ = Tighten until the conical washer becomes upright, and the blue color will become hardly visible. (When the cap nut is tightened, the gap between the conical washer and the joint main body is 0.1 mm maximum.)</p> <p>1. Any insufficient tightening will cause a gap between the cap nut and the end surface of the joint, which will, under any heat applied to the joint, cause the rubber packing to expand and escape to the gap between the cap nut and the joint end surface from the packing box, eventually causing leakage.</p> <p>2. When adjusting the angle of the joint or the valve, do it after the tightening. Rotating the pipe with the nut hand-tightened or insufficiently tightened will twist the rubber packing, potentially causing leakage that cannot be detected by the pressure test.</p> <p>× = Insufficient tightening causes leakage.</p>  <p>Tightening</p> <p>Hand tightening</p>  <p>Conical washer (with mechanism to prevent the cap nut from being left untightened)</p> <p>Rubber packing</p> <p>Joint main body</p> <p>Cap nut</p> <p>Conical washer insufficiently rising</p> <p>Gap formed, producing the cause of escape due to the expansion of rubber</p> <p>Tightened</p> <p>Insufficiently tightened</p> <p>Stainless steel pipe</p> <p>Tighten until close contact made</p>	

Note: See the work execution manual for further details.