

Installation

- Only use tubes within the permitted tolerances and permissible standards as detailed in the HAELOK®-Product catalogue listed.
- Loose rolling skin, scale and rust must be removed. Remove paint coatings with sandpaper. But do not use an angle grinder/cutting disc!
- Make sure that the tubes fit and have no tension.

Press tool.

- The HAELOK® pressing tools are exclusively designed for the installation of HAELOK® fittings.
- If the pressing cycle could not be completed due to an error or insufficient power, you can release the pressure manually with the black release button on the side of the tool.
- To minimize the risk of injury, read the operating instructions in the toolbox and observe the warning symbols and notes.

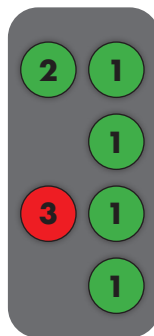
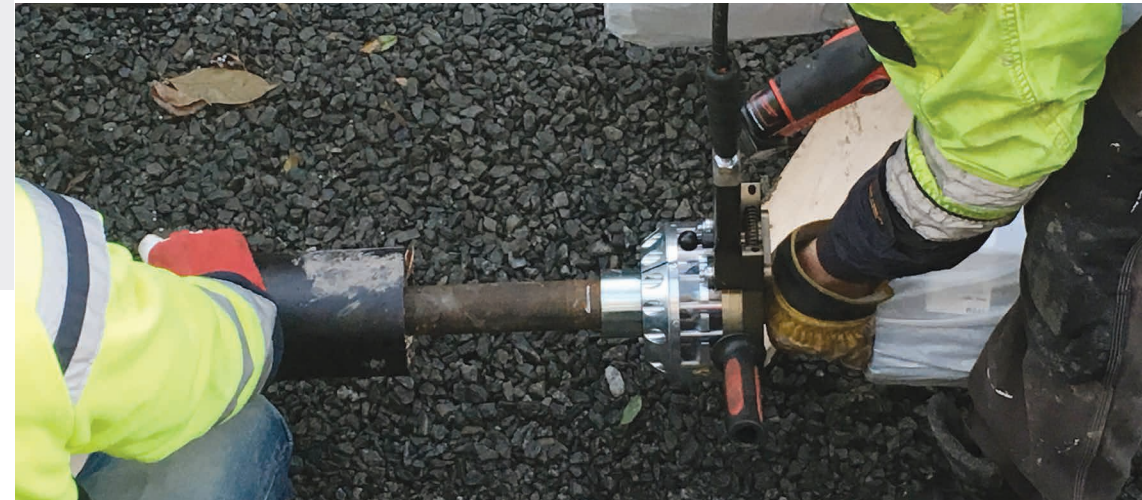
Use pressing tool

- Make sure that the corresponding inlays are correctly inserted and fixed.
- Press the button until the pressing cycle is completely finished and the tool is automatically released.
- Never press a fitting with an unlocked or not properly locked tool.
- Never use a damaged tool.

Maintenance

- Protect the tool from dirt, sand and water with a bag or box in extreme environments. Observe the maintenance intervals.
- Clean the tool after use with a damp cloth and grease the pistons weekly (e.g. with the Brunox spray supplied)
- Never use a hose or high-pressure cleaner for cleaning!

Installation guideline for PT0613 - PT3060



- ① LED indicates the battery charge status (all four lights on - fully charged)
- ② Constant green light - ready
- ② Flashing green light - insufficient battery status
- ③ Constant red light - Pump too hot
- ③ Flashing red light - Error message*
- ② Flashing green and red light - Service interval reached

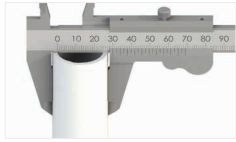
* Please contact the HAELOK® service

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Subject to technical changes and availability. Our AGBs apply to the sale.

**AN INNOVATIVE COMPANY.
A STRONG BRAND. HAELOK®**

Application steps. Grouting with a HAELOK®- Tool.



1. Measure

Measure the pipe size and wall thickness and check the measured values against our permitted tolerances. If questions arise here, please do not hesitate to contact us.



2. Cutting to length

Cut the pipe at the appropriate point to use our fittings (tolerance $\pm 5^\circ$). If you want to use our fittings on a pre-insulated pipe, first peel off the insulation.



3. Deburring and grinding

Deburr the cut side created during cutting to length inside and outside. Remove loose rust stains, grooves and dirt. Do not use an angle grinder. Serial numbers and deep scratches are not allowed in the first 25-50mm of the pipe end.



4. Mark

Use the HAELOK® marking tool to mark the fitting position. If you do not have the tool at hand, you can also use an unpressed fitting to help you, so that you have a control point for a successful pressing.



5. Insert

Insert the pipe up to the stop of the fitting. Make sure that the insertion depth is correct. The fitting must lie in the fitting without tension. Also note the weight of the tool.



6. Apply

Place the pressing tool in place, making sure that the insert of the pressing tool is correctly seated in the groove of the fitting. Close the tool until it locks.



7. Press

Now you only have to press and hold the press button on the hydraulic unit - the pressing process is started. The process stops automatically when the fitting is pressed.

Ready! Make another visual inspection based on your marking. The press ring is in line with the fittings body. Your HAELOK® connection is ready.

Remember:

Fittings must be installed without torsion and stress during installation. Only trained and instructed personal are allowed to work with HAELOK® machines.

Application steps. Using the HAELOK® marking tool.

Step 1

Pipe stop

Place the template with the pipe stop firmly against the pipe end and mark the pipe at the corresponding mark for the appropriate fitting and press tool to be used.

Step 2

Fitting $\leq 13\text{mm}$

Use this marking when using a fitting of 13 mm or smaller to indicate the correct fitting position on the pipe.

Fitting 14-28mm

Use this marker if you want to use a fitting in the size range from 14 mm to 28 mm to mark the correct fitting position on the pipe.

Step 3

3.1

Press tool $< 13\text{mm}$

Use this marker to mark all fittings smaller than 13 mm or smaller with the PT0613 tool to check the tool edge on the pipe.

3.2

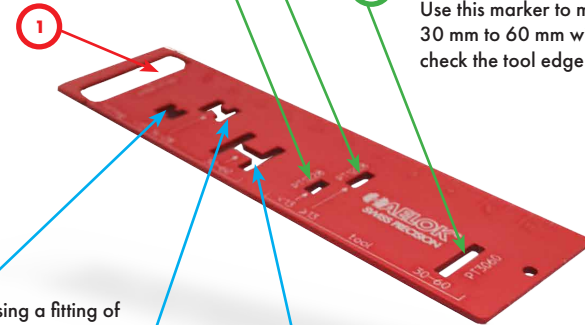
Press tool 14-28mm

Use this marker to mark all fittings smaller than 13 mm or smaller with the PT0613 tool to check the tool edge on the pipe.

3.3

Press tool 30-60mm

Use this marker to mark all fittings from 30 mm to 60 mm with the PT3060 tool to check the tool edge on the pipe.



The H shape shows the marking before and after the pressing process.

We recommend using the supplied Permanent Marker 1-4mm for marking.