

## Operating instructions

Fittings 1500bar, 2500bar, 4500bar / 1/4“, 3/8“, 9/16“ and 10500bar/5/16”

### 1. Safety advice:

Operation and installation of the component parts may only be performed by trained persons. The statutory provisions of the German Employers' Liability Insurance Association (BG) and other institutions must be complied with. In addition, these Operating Instructions have to be studied thoroughly and fully adhered to.

### 2. Method of functioning / Use:

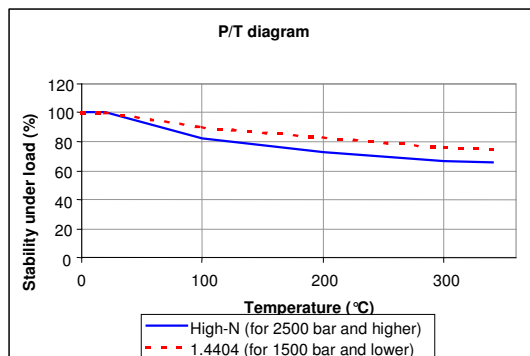
MAXIMATOR® Fittings may only be used for pressure-sealed conveyance of liquids and gases. The fittings must not be subjected to any modifications (e.g.: mechanical alterations, welding, soldering, etc.).

### 3. Technical information:

Media: Only media included in our media endurance list may be used. All other media have to be checked by us for their compatibility with valve materials prior to use. In addition, the respective statutory provisions must be absolutely complied with when inflammable, explosive or toxic substances are used.

Type of load: are designed for static loads. Life expectancy of the fittings is reduced under dynamic load conditions.

Media temperature: -50 °C ..... +350 °C  
Max. pressure drops with rising temperature. (confer P/T diagram)



### 4. Assembly:

Bulkhead stuffing box:

1. Loosen hexagonal-head nut from stuffing box
2. Push stuffing box through bore (bore diameter as indicated in the below table)
3. Retighten hexagonal-head nut

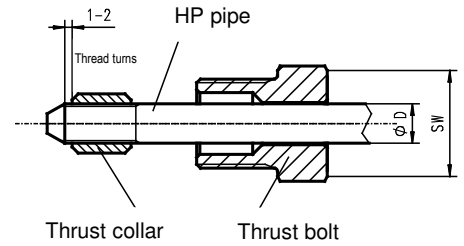
Type	45BF4433	45BF6633	45BF9933	15BFX4466	15BFX6666	15BFX9966	105BF5533
Bore Ø	22mm/0.87"	27mm/1.07"	36mm/1.42"	20mm/0.79"	24mm/0.95"	27mm1.07"	36mm1.42"

HP pipe:

1. Push thrust bolt over the HP pipe.
2. Screw on thrust collar till to end of thread and turn back by one turn (left-handed thread). Make sure that 1-2 threads are free between sealing cone and thrust collar.
3. Screw thrust bolt into the body connecting bore and tighten with tightening moment as indicated in the below table.

Tightening moment for thrust bolts:

Pressure connection	Pipe connection dimensions	∅D	Thrust bolt Width across flats (SW)	Tightening moment
bar	inches	mm	SW in mm	Nm
	1/4"	6.35	SW 13	30
1500	3/8"	9.53	SW 17	40
	9/16"	14.3	SW 24	75
2500 /	1/4"	6.35	SW 17	35
4500	3/8"	9.53	SW 22	70
	9/16"	14.3	SW 32	150
10500	5/16	7.94	SW 19	100



**Remark:** Prior to assembly (and if the medium permits such) all threads and sealing cones should be treated with a suitable lubricant (e.g. copper paste)!

**5. Dismantling:**

Dismantling is performed in reverse order as assembly.

**Remark:** Make sure that the system is depressurised before start of dismantling!

**6. Maintenance:**

MAXIMATOR® Fittings are maintenance-free!

**7. Servicing / Repair:**

Any servicing work may only be performed by trained persons.

Malfunctions:

Malfunction	Possible cause	Remedy
Medium escapes via relief bore at pressure connections	Faulty assembly of pressure connection Cone surface is damaged	Check for proper assembly  Re-machine cone surface with a seat reaming tool or rework pipe

All component parts of fittings can only be obtained from us as spares. Please, indicate in your spare part order the respective serial number, item number and valve type, provided on the fitting body. We also offer repair services in our workshop, performed by our qualified service technicians.

**8. Warranty:**

We grant for MAXIMATOR® Fittings a warranty of twelve (12) months on material quality and workmanship, commencing with the fitting shipment date. Any deficiencies that are due to improper handling, use of inadmissible media or exceeding of maximum operating pressures are not subject to our warranty obligation.

**9. Disposal:**

Fittings are to be disposed of in compliance with national regulations upon the end of their useful lives.