



**Transport**  
EFFICIENCY

*"Running Well for You"*

# TECHNICAL BULLETIN

# 12/02a

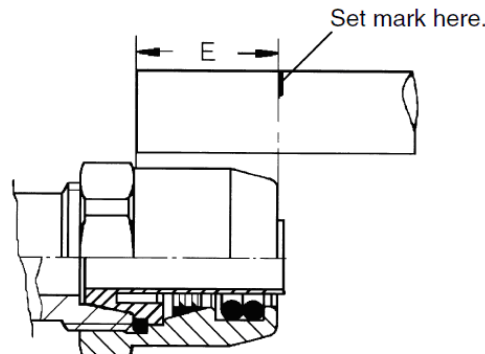
## Assembling Wira fittings



Screw the fitting into the port and tighten to the following torque

Thread size	Torque	Thread size	Torque
M12	24Nm	1/8	18Nm
M14	28Nm	1/4	28Nm
M16	35Nm	3/8	38Nm
M22	40Nm	1/2	42Nm

Cut the pipe squarely, maximum angle of 5°, ensuring there are no burrs on the inside or outside. The inserted length of pipe is measured using the value in the table below or measured as illustrated, and marked on the pipe.



Insert the pipe into the fitting until it comes to a stop. The mark on the pipe should be parallel with the end of the fitting. Pull on the tube (20-50N) to ensure it is locked in

Pipe Diameter	Insertion length	Insertion force
8 mm	18.0mm	90N
10mm	19.5mm	100N
12mm	20.5mm	110N
15mm	20.5mm	125N