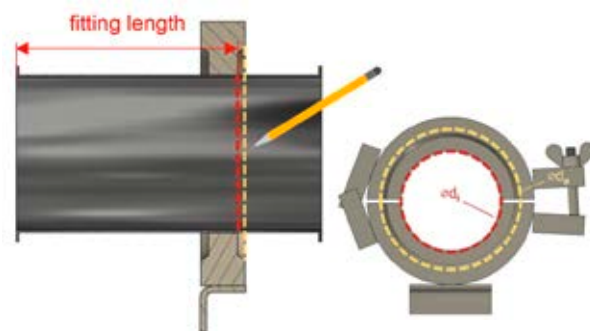


INSTRUCTION MANUAL FOR FLANGING TOOLS



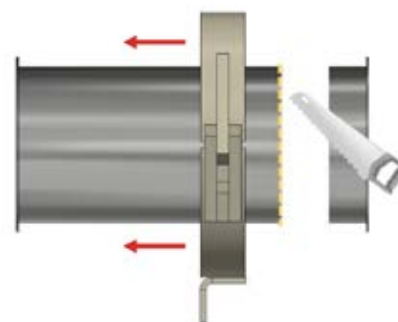
STEP 1

The on-site fitting length is aligned to the edge of the inner diameter (red) and marked. The outer diameter (yellow) produces the 6 mm flange edge in addition to the fitting length. A straight cutting line is marked along this edge around the entire circumference of the pipe.



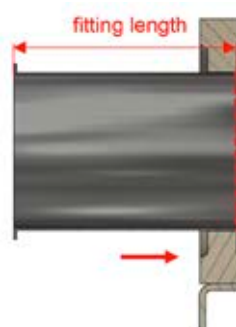
STEP 2

The flanging tool is now pushed back and the pipe is shortened to the appropriate length (fitting length + 6 mm) along the cutting line (yellow).



STEP 3

The flanging tool is now aligned again to the fitting length line (red) so that the pipe protrudes by 6 mm at the end to be flanged.



STEP 4

Finally, the protruding pipe is manually upset with a hammer until an even lip has been created.



Longer pipes must be supported during the flanging process. The flanging tool is suitable for forming steel pipe ends with a material thickness of up to max. 2 mm. Welding ends should be used for pipe connections in case of a material thickness of 3 mm or more.