

GF Primofit

EN Technical Information



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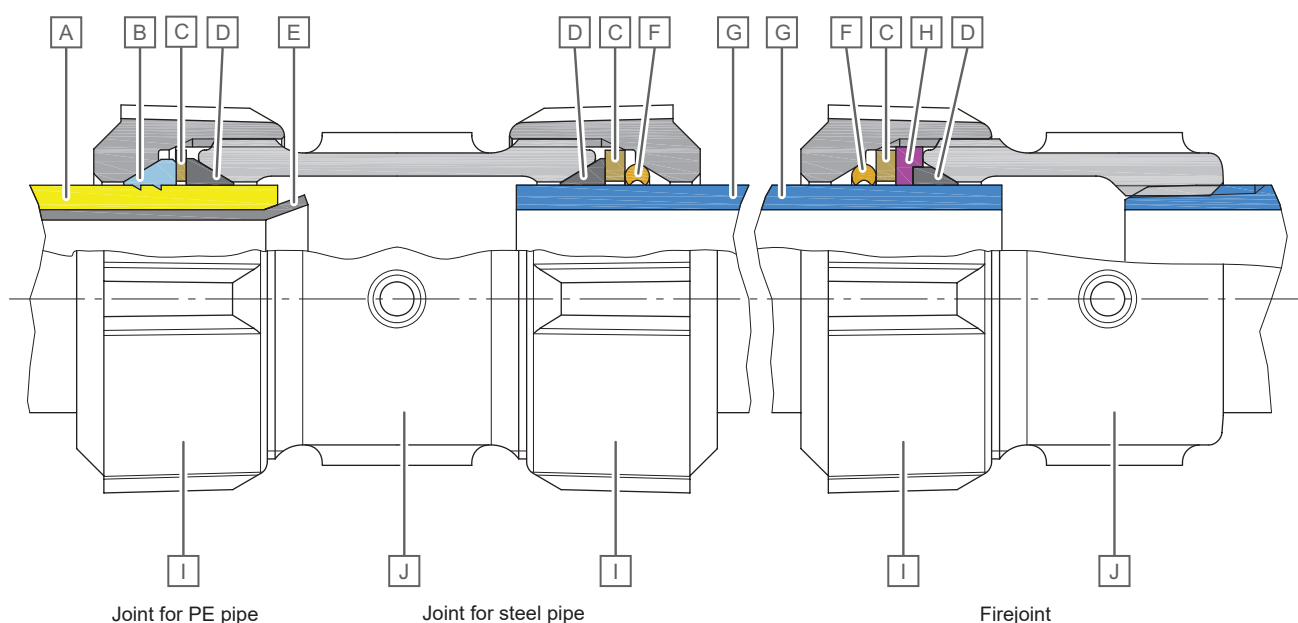
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1 System description

1.1 Benefits

- Primofit compression fittings are preassembled and prepared for installation, disassembly is not necessary.
- Minimal pipe end machining
- The connection resists side load and pull-out force. Pipe support is not necessary
- Made of malleable cast iron, with hot-dip galvanized and/or black finish
- Low assembly costs
- Special tools are not necessary
- Malleable cast iron body made from 100 % recycled metal. More than 35 % of the production energy comes from our own hydropower and photovoltaic power plants. Green Energy shares are being continuously expanded.
- The angular deviation of the pipe in a Primofit connection is maximum 3 °. This results in a maximum axial deviation of 6 ° for two pipes connected by a Primofit compression coupling
- Detachable compression connection
- Compact design – minimum space necessary
- Outer contours make shrink tubing possible
- Longitudinally electrically conductive, applicable for cathodic corrosion protection and equipotential bonding

1.2 Design



Item	Description
A	PE pipe
B	Locking ring for PE pipe
C	Washer
D	Rubber gasket
E	Stiffener
F	Locking ring for steel pipe
G	Steel pipe
H	Graphite ring
I	Nut
J	Fitting body

1.3 Limits of use

Pipes type	Medium	Maximum operating pressure [bar]	Maximum operating temperature [°C]	Colour code ¹⁾	Gasket	Surface/material Primofit
Steel pipe	Fuel gases (including H ₂) ²⁾	10 ³⁾	70	 Yellow	NBR	Black and galvanised
	System water ⁴⁾	16	80			
	Compressed air	16	80			
	Oil	16	80			
	Drinking water (cold < 25 °C)	16	25	 Blue	EPDM	Galvanised
	Drinking water (heated > 25 °C)	16	95			Stainless steel ⁹⁾
	System water ⁴⁾	16	95			Galvanised
	Compressed air	16	95			Black
	Heating water/steam	10	150	 Green	FKM	Galvanised
	Water - Glycol ⁵⁾	10	150			Galvanised
	Compressed air	16	150			Galvanised
	Fuels ⁶⁾	10	40			Galvanised
	Fuel gases (including H ₂) ²⁾	5	60	 Red	NBR + graphite ⁷⁾	Galvanised
PE/PE-Xa pipe	Fuel gases (including H ₂) ²⁾	10 ⁸⁾	40	 Yellow	NBR	Black and galvanised
	System water ⁴⁾	16	40			Galvanised
	Drinking water (cold < 25 °C)	16	25	 Blue	EPDM	Stainless steel ⁹⁾
	Drinking water (heated > 25 °C)	16	40			Stainless steel ⁹⁾

- 1) The colour code on the packaging gives the indication for a gasket material.
- 2) Natural gas (NPG), Liquefied Petroleum Gas (LPG) and Hydrogen (H) with a maximum hydrogen content of 20% by volume. **In Germany, only NBR + graphite (Firejoint) is permitted in buildings.**
- 3) Maximum 5 bar for a connection with thread.
- 4) Primofit **FKM** in black version must be used for heating systems.
- 5) Includes water in ventilation and air conditioning systems. Especially when using antifreeze containing glycol, the use of black fittings with FKM gasket is recommended.
- 6) Diesel and petrol with/without lead.
- 7) Firejoint (NBR + graphite) is the fire resistant version, approved for gas systems in buildings.
- 8) 10 bar for PE100 or 8 bar for PE-Xa or 5 bar for a connection with thread.
- 9) For new installations. For repairs and extensions of galvanised piping, which had no corrosion or hygiene problems before, the galvanised version can be used.

1.4 Compatible pipe diameters overview

DN	10	15	20	25	40	50	65	80	100
Primofit dimension [inch]	3/8	1/2	3/4	1	1 1/2	2	2 1/2	3	4
Steel pipe OD [mm]	17,2	21,3	26,9	33,7	48,3	60,3	76,1	88,9	114,3
Tolerance range [mm]	16,7 - 17,5	21 - 21,8	26,5 - 27,3	33,3 - 34,2	47,9 - 48,8	59,7 - 60,8	75,3 - 76,6	88,0 - 89,5	113,1 - 115,0
Butt weld steel tubes for pressure purposes ¹⁾ OD [mm] ²⁾	-	20,0 ± 0,5	25,0 ± 0,5	31,8 ± 0,5	44,5 ± 0,5	51,0 ± 0,5 57,0 ± 0,5 63,5 ± 0,6	70,0 ± 0,7	-	-
PE/PE-Xa pipe OD [mm]	-	20	25	32	50	63	-	-	-
Tolerance range [mm]		20,0 - 20,3	25,0 - 25,3	32,0 - 32,3	50,0 - 50,4	63,0 - 63,4			
Lead pipe [mm]	-	18,3 - 21,9	23,9 - 27,4	27,3 - 30,9 30,9 - 34,4	45,8 - 46,9 47,5 - 50,7	53,1 - 55,4 56,5 - 57,5 60,4 - 63,8	-	-	-
Minimum bore ³⁾ [mm]	7,9	11,6	16,6	22,7	36,3	46,8	61,5	72,2	95,3
Thread size [inch]	3/8	1/2	3/4	1	1 1/2	2	2 1/2	3	4

1) Only available as gasket spare set. When using spare sets for end-weld steel tubes, with OD = 63,5 mm, a special compression body is necessary. That is to say, the tube cannot be used with standard compression fitting dimension 2!

2) Including ± tolerance

3) It is equal to the smallest internal diameter of the male adaptor. For all other compression fitting types, the smallest internal diameter is the internal diameter of the pipe.

1.5 Terms and abbreviations

Term	Explanation
Steel	For connection to steel pipes
PE/PE-Xa	For connection to PE/PE-Xa pipes
Lead	For connection to lead pipes
Dimension PE	Dimension polyethylene pipe
Dimension St	Dimension steel pipe
Dimension Pb	Dimension lead pipe
Dimension Rp	Dimension parallel female thread according to EN 10226-1 and/or ISO 7-1
Dimension R	Dimension taper male thread according to EN 10226-1 and/or ISO 7-1
Code	Georg Fischer item code
GP	Quantity per carton
Weight	Piece weight in kg
NBR	Nitrile butadiene rubber
EPDM	Ethylene propylene diene monomer rubber
FKM	Fluorinated propylene monomer rubber (fluoroelastomer)
PE-Xa	Peroxide cross-linked polyethylene
POM	Polyoxymethylene
SDR	Pipe diameter/wall thickness ratio (standard dimension ratio)
S	Pipe series
D	Biggest fitting diameter
L	Overall length (face-to-face dimension)
x	Insertion depth of the pipe
DN	Nominal width
ID	Internal diameter
OD	Outside diameter
s	Wall thickness

1.6 Product approvals and certifications



Note

For detailed information about the certificates, please contact GF certification team and primofit.ps@georgfischer.com.

GF operates an integrated management system, which is certified as per EN ISO 9001, EN ISO 14001 and EN ISO 45001. The suitability of PRIMOFIT malleable cast iron compression fittings for gas and drinking water installations is proven by the following certificates, allegations.

Country	Institute		Application	Certificate
AT	ÖVGW		Gas steel pipe	G 2.515
			Drinking water steel and PE/PE-Xa pipe	W 1.602
	ÜA		Drinking water, galvanised Primofit, EPDM for steel / PE/PE - Xa pipe and repair clamps	R-15.2.3-20-17032
			Drinking water, stainless steel Primofit, EPDM for steel / PE/PE - Xa pipe	R-15.2.3-22-17649
DE	DVGW		Drinking water steel pipe	DW-8511BL0157
			Drinking water steel and PE/PE-Xa pipe	DW-7611BT0591
			Gas steel pipe	DG-4502CN0373
			Gas steel and PE/PE-Xa pipe	DG-7521BP5519
			Firejoint (HTL version) steel pipe	DG-4502CN0374
CH	SVGW		Gas steel and PE/PE-Xa pipe	05-045-6
NL	KIWA GASTEC		Drinking water steel pipe	8704-1985
			Gas steel pipe	AR 91 Q 96/086, Nr. 56585
			Gas PE/PE-Xa Pipe	AR 70 Q 96/086, Nr. 56584
			Hydrogen ready steel pipe	AR 214 Q96/086, Nr. 107696
FR	FR	ACS	Hydrogen ready PE/PE-Xa pipe	AR 214 Q96/086, Nr. 107695/01
			Drinking water steel pipe and PE/PE-Xa pipe	25 ACC LY 277
UK	BSI KITEMARK		GIS/ PL3 including Primofit Firejoint (HTL version) steel pipe for gas	KM 539621 (PL3)
BE	ARGB - KVBG		Firejoint (HTL version) steel pipe for gas	C-11-3552-A
IT	KIWA UNI		Gas and drinking water steel pipe	KIP102154
			Gas and drinking water PE/PE-Xa pipe	KIP102153

1.7 Copyright and disclaimer

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2 Variants

2.1 Primofit galvanised for steel pipe

!	Note Spare sets are available for some dimensions of butt-weld steel tubes for pressure purposes of series 2 and 3. For more information, refer to the chapter "Primofit spare sets for steel pipe threaded and butt weld tubes".
!	Note The Primofit stainless steel compression fitting is intended for hot water pipes that are made of hot-dip galvanised steel. All media-contacting materials (body and elastomer gasket) are in accordance with the current drinking water requirements. For more information, refer to the chapter "Primofit stainless steel for steel and PE/PE-Xa pipe".

The PRIMOFIT is a compression fitting with full end-load capability. In addition, each connection can accommodate an angle deviation up to 3 ° between pipe and compression fitting. This compression fitting as per EN 10344 is used to connect hot-dip galvanised steel pipes as per EN 10255 and EN 10220 with the standardised outside diameters according to ISO 65.

Pipe specification

Steel/EN 10255 Steel/EN 10220-S1		
Dimension [inch]	OD [mm]	Tolerance range [mm]
3/8	17,2	16,7 - 17,5
1/2	21,3	21,0 - 21,8
3/4	26,9	26,5 - 27,3
1	33,7	33,3 - 34,2
1 1/4	42,4	42,0 - 42,9
1 1/2	48,3	47,9 - 48,8
2	60,3	59,7 - 60,8
2 1/2	76,1	75,3 - 76,6
3	88,9	88,0 - 89,5
4	114,3	113,1 - 115,0

Material

!	Note For general information on jointing, use methods and pipe specifications, refer to the chapter "General information".
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- Body:** white malleable cast iron **EN-GJMW-400-5** as per EN 1562.
- Gasket material:** refer to the following chapter "Application".
- Corrosion protection by hot dip galvanising:** as per EN 10344.

Application

!	Note When the pipe is installed underground (the compression joint is exposed directly to soil, sand, etc.), the installer must apply more corrosion protection methods (e.g. tape).
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Obey international, European and national use-related requirements and the manufacturer's specification guidelines.

Medium	Maximum operating pressure [bar]	Maximum operating temperature [°C]	Colour code ¹⁾	Gasket
Fuel gases (including H ₂) ²⁾	10 ³⁾	70		
System water ⁴⁾	16	80	Yellow	NBR
Compressed air	16	80		
Oil	16	80		
Compressed air	16	150	Green	FKM ⁵⁾
Fuels ⁶⁾	10	40		

- The colour code on the packaging gives the indication for a gasket material.
- Natural gas (NPG), Liquefied Petroleum Gas (LPG) and Hydrogen (H) with a maximum hydrogen content of 20% by volume. **In Germany, only NBR + graphite (Firejoint) is permitted in buildings.**
- Maximum 5 bar for a connection with thread.
- Primofit **FKM** in black version must be used for heating systems.
- FKM gaskets **are not** useable for drinking water installations and fuel gases!
- Diesel and petrol with/without lead.

Certificates

Country	Institute		Application	Certificate
AT	ÖVGW		Gas steel pipe	G 2.515
DE	DVGW		Gas steel pipe	DG-4502CN0373
			Gas steel and PE/PE-Xa pipe	DG-7521BP5519
CH	SVGW		Gas steel and PE/PE-Xa pipe	05-045-6
NL	KIWA GASTEC		Gas steel pipe	AR 91 Q 96/086, Nr. 56585
			Gas PE/PE-Xa Pipe	AR 70 Q 96/086, Nr. 56584
			Hydrogen ready steel pipe	AR 214 Q96/086, Nr. 107696
			Hydrogen ready PE/PE-Xa pipe	AR 214 Q96/086, Nr. 107695
UK	BSI KITEMARK		Gas PL3	KM 539621 (PL3)
IT	KIWA UNI		Gas and drinking water steel pipe	KIP102154

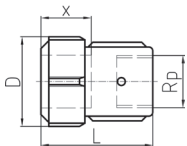
System components

Following fittings are available:

Primofit female adaptor galvanised for steel pipe

Item	Description	Values								
		Dimension St [inch]	Dimension Rp [inch]	NBR code	FKM code	GP	Weight [kg]	D [mm]	L [mm]	x [mm]
	Internal thread Rp according to EN 10226-1	3/8	3/8	775 212 050	-	30	0,227	45	56	30 - 34
		1/2	1/2	775 212 051	775 218 051	30	0,227	45	60	30 - 34
		3/4	3/4	775 212 052	775 218 052	25	0,302	51	63	30 - 34
		1	1	775 212 053	775 218 053	15	0,369	59	68	30 - 34
		1 1/4	1 1/4	775 212 054	775 218 054	10	0,520	68	72	30 - 36
		1 1/2	1 1/2	775 212 055	775 218 055	10	0,600	75	74	32 - 38
		2	2	775 212 056	775 218 056	5	1,120	96	83	36 - 42
		2 1/2	2 1/2	775 212 057	775 218 057	3	2,560	119	138	65 - 75
		3	3	775 212 058	775 218 058	2	3,000	132	148	65 - 75
		4*)	4*)	775 212 059*)	-	1*)	5,300*)	178*)	200*)	65 - 75*)

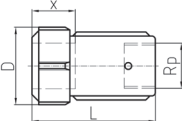
Dimension 4*)

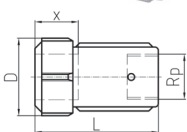


*) Flange design

Primofit female adaptor long galvanised for steel pipe

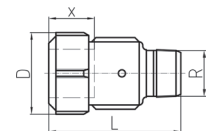
Item	Description	Values							
		Dimension St [inch]	Dimension Rp [inch]	NBR code	GP	Weight [kg]	D [mm]	L [mm]	x [mm]
	The long female adaptor enables the insertion or sliding over of two pipe thread lengths. This allows the installation between two fixed points. Internal thread Rp according to EN 10226-1	1/2	1/2	775 212 951	30	0,227	45	80	30 - 34
		3/4	3/4	775 212 952	25	0,350	51	78	30 - 34
		1	1	775 212 953	15	0,370	59	88	30 - 34
		1 1/4	1 1/4	775 212 954	10	0,520	68	99	30 - 36





Primofit male adaptor galvanised for steel pipe

Item	Description	Values								
		Dimension St [inch]	Dimension R [inch]	NBR code	FKM code	GP	Weight [kg]	D [mm]	L [mm]	x [mm]
  Dimension 4*)	External thread R according to EN 10226-1	3/8	3/8	775 202 050	-	25	0,230	45	70	30 - 34
		1/2	1/2	775 202 051	775 208 051	25	0,234	45	74	30 - 34
		3/4	3/4	775 202 052	775 208 052	20	0,308	51	81	30 - 34
		1	1	775 202 053	775 208 053	10	0,421	59	90	30 - 34
		1 1/4	1 1/4	775 202 054	775 208 054	10	0,554	68	94	30 - 36
		1 1/2	1 1/2	775 202 055	775 208 055	5	0,648	75	94	32 - 38
		2	2	775 202 056	775 208 056	5	1,120	96	106	36 - 42
		2 1/2	2 1/2	775 202 057	775 208 057	3	2,720	119	173	65 - 75
		3	3	775 202 058	775 208 058	2	3,560	132	186	65 - 75
		4*)	4*)	775 202 059*)	-	1*)	5,500*)	178*)	212*)	65 - 75*)

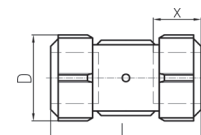


*) Flange design

Primofit coupling short galvanised equal for steel pipe

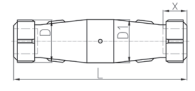
Item	Description	Values							
		Dimension [inch]	NBR code	FKM code	GP	Weight [kg]	D [mm]	L [mm]	x [mm]
  Dimension 4*)	-	3/8	775 102 050	-	25	0,373	45	85	30 - 34
		1/2	775 102 051	775 108 051	25	0,346	45	85	30 - 34
		3/4	775 102 052	775 108 052	20	0,436	51	90	30 - 34
		1	775 102 053	775 108 053	15	0,588	59	96	30 - 34
		1 1/4	775 102 054	775 108 054	10	0,688	68	96	30 - 36
		1 1/2	775 102 055	775 108 055	5	0,840	75	100	32 - 38
		2	775 102 056	775 108 056	5	1,603	96	112	36 - 42
		2 1/2	775 102 057	775 108 057	2	3,650	118	185	65 - 75
		3	775 102 058	775 108 058	2	4,480	132	191	65 - 75
		4*)	775 102 059*)	-	1*)	6,600*)	178*)	216*)	65 - 75*)

Dimension 4*)

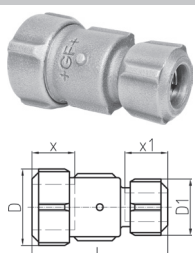


*) Flange design

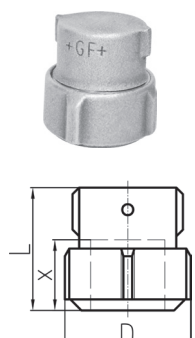
Primofit coupling long galvanised for steel pipe

Item	Description	Values							
		Dimension [inch]	NBR code	GP	Weight [kg]	D [mm]	D1 [mm]	L [mm]	x [mm]
 	-	1	775 152 053	5	1,280	59	65	226	30 - 34
		1 1/4	775 152 054	5	1,420	68	74	229	30 - 36
		1 1/2	775 152 055	5	2,420	75	80	230	32 - 38
		2	775 152 056	4	2,160	96	94	234	36 - 42

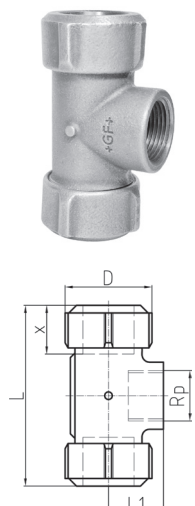
Primofit coupling short galvanised reducing for steel pipe

Item	Description	Values								
		Dimension [inch]	NBR code	GP	Weight [kg]	D [mm]	D1 [mm]	L [mm]	x [mm]	x1 [mm]
	-	$\frac{3}{4}$ - $\frac{1}{2}$	775 102 061	20	0,340	51	45	90	30 - 34	30 - 34
	-	1 - $\frac{1}{2}$	775 102 062	15	0,520	59	45	97	30 - 34	30 - 34
	-	1 - $\frac{3}{4}$	775 102 063	15	0,552	59	51	97	30 - 34	30 - 34
	-	$1\frac{1}{4}$ - $\frac{3}{4}$	775 102 065	10	0,460	68	51	99	30 - 36	30 - 34
	-	$1\frac{1}{4}$ - 1	775 102 066	10	0,692	68	59	97	30 - 36	30 - 34
	-	$1\frac{1}{2}$ - 1	775 102 069	5	0,800	75	59	99	32 - 38	30 - 34
	-	$1\frac{1}{2}$ - $1\frac{1}{4}$	775 102 070	5	0,780	75	68	97	32 - 38	30 - 36
	-	2 - $1\frac{1}{4}$	775 102 074	5	1,280	96	68	109	36 - 42	30 - 36
	-	2 - $1\frac{1}{2}$	775 102 075	5	1,360	96	75	110	36 - 42	32 - 38

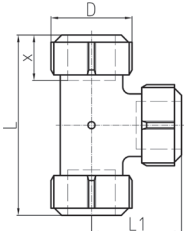
Primofit cap galvanised for steel pipe

Item	Description	Values								
		Dimension [inch]	NBR code	FKM code	GP	Weight [kg]	D [mm]	L [mm]	x [mm]	
	-	$\frac{3}{8}$	775 452 050	-	30	0,201	45	48	30 - 34	
	-	$\frac{1}{2}$	775 452 051	775 458 051	30	0,207	45	48	30 - 34	
	-	$\frac{3}{4}$	775 452 052	775 458 052	30	0,240	51	50	30 - 34	
	-	1	775 452 053	775 458 053	25	0,347	59	53	30 - 34	
	-	$1\frac{1}{4}$	775 452 054	775 458 054	10	0,450	68	54	30 - 36	
	-	$1\frac{1}{2}$	775 452 055	775 458 055	10	0,520	75	55	32 - 38	
	-	2	775 452 056	775 458 056	10	0,940	96	60	36 - 42	

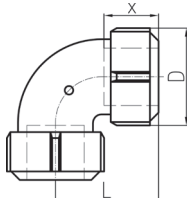
Primofit threaded outlet tee galvanised for steel pipe

Item	Description	Values									
		Dimension St [inch]	Dimension Rp [inch]	NBR code	FKM code	GP	Weight [kg]	D [mm]	L [mm]	L1 [mm]	x [mm]
	Internal thread Rp according to EN 10226-1	$\frac{3}{8}$	$\frac{1}{2}$	775 312 050	-	15	0,403	45	101	27	30 - 34
		$\frac{1}{2}$	$\frac{1}{2}$	775 312 051	775 318 051	15	0,380	45	101	27	30 - 34
		$\frac{3}{4}$	$\frac{3}{4}$	775 312 052	775 318 052	10	0,543	51	107	32	30 - 34
		1	1	775 312 053	775 318 053	5	0,661	59	114	38	30 - 34
		$1\frac{1}{4}$	$1\frac{1}{4}$	775 312 054	775 318 054	5	0,884	68	121	45	30 - 36
		$1\frac{1}{2}$	$1\frac{1}{2}$	775 312 055	775 318 055	6	1,140	75	133	48	32 - 38
		2	2	775 312 056	775 318 056	4	2,000	96	156	62	36 - 42

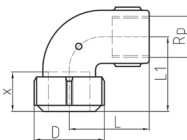
Primofit tee galvanised for steel pipe

Item	Description	Values								
		Dimension [inch]	NBR code	FKM code	GP	Weight [kg]	D [mm]	L [mm]	L1 [mm]	x [mm]
	-	3/8	775 302 050	-	5	0,450	45	110	55	30 - 34
		1/2	775 302 051	775 308 051	5	0,520	45	110	55	30 - 34
		3/4	775 302 052	775 308 052	5	0,660	51	115	58	30 - 34
		1	775 302 053	775 308 053	5	0,880	59	121	61	30 - 34
		1 1/4	775 302 054	775 308 054	5	1,260	68	130	65	30 - 36
		1 1/2	775 302 055	775 308 055	5	1,400	75	144	72	32 - 38
		2	775 302 056	775 308 056	3	2,720	96	166	83	36 - 42
										

Primofit elbow galvanised for steel pipe

Item	Description	Values							
		Dimension [inch]	NBR code	FKM code	GP	Weight [kg]	D [mm]	L [mm]	x [mm]
	-	3/8	775 402 050	-	15	0,375	45	58	30 - 34
		1/2	775 402 051	775 408 051	15	0,397	45	58	30 - 34
		3/4	775 402 052	775 408 052	10	0,494	51	60	30 - 34
		1	775 402 053	775 408 053	10	0,674	59	60	30 - 34
		1 1/4	775 402 054	775 408 054	5	0,820	68	60	30 - 36
		1 1/2	775 402 055	775 408 055	5	1,000	75	76	32 - 38
		2	775 402 056	775 408 056	4	1,860	96	88	36 - 42
									

Primofit female adaptor elbow galvanised for steel pipe

Item	Description	Values								
		Dimension St [inch]	Dimension Rp [inch]	NBR code	GP	Weight [kg]	D [mm]	L [mm]	L1 [mm]	x [mm]
	Internal thread Rp according to EN 10226-1	3/4	3/4	775 432 052	10	0,410	51	62	65	30 - 34
		1	1	775 432 053	10	0,544	59	64	65	30 - 34
		1	3/4	775 432 063	10	0,601	59	65	65	30 - 34
		3/4	1	775 432 081	10	0,780	51	61	65	30 - 34
										

2.2 Primofit galvanised for steel pipe with EPDM gasket for drinking water

	Note
	For use with hot drinking water (> 25 °C) GF recommends using Primofit made of stainless steel. The Primofit stainless steel compression fitting is intended for galvanised hot water pipes made of hot-dip galvanised ferrous materials. All materials in contact with the fluid (body and elastomer gasket) are in accordance with the current drinking water requirements. For more information, refer to the chapter "Primofit stainless steel for steel and PE/PE-Xa pipe".

The PRIMOFIT is a compression fitting with full end-load capability. In addition, each connection can accommodate an angle deviation up to 3 ° between pipe and compression fitting. This compression fitting according to EN 10344 is used to connect hot-dip galvanised steel pipes according to EN 10255 and EN 10220 with the standardised outside diameters according to ISO 65.

Pipe specification

Steel/EN 10255 Steel/EN 10220-S1		
Dimension [inch]	OD [mm]	Tolerance range [mm]
3/8	17,2	16,7 - 17,5
1/2	21,3	21,0 - 21,8
3/4	26,9	26,5 - 27,3
1	33,7	33,3 - 34,2
1 1/4	42,4	42,0 - 42,9
1 1/2	48,3	47,9 - 48,8
2	60,3	59,7 - 60,8
2 1/2	76,1	75,3 - 76,6
3	88,9	88,0 - 89,5
4	114,3	113,1 - 115,0

Material

	Note
	For general information on jointing, use methods and pipe specifications, refer to the chapter "General information".

- Body:** white malleable cast iron **EN-GJMW-400-5** as per EN 1562.
- Gasket material:** refer to the following chapter "Application".
- Corrosion protection by hot dip galvanising:** as per EN 10344.

Application

	Note
	In the field of drinking water, only Primofit compression fittings with EPDM gasket must be used. When the pipe is installed underground (the compression joint is exposed directly to soil, sand, etc.), the installer must apply more corrosion protection methods (e.g. tape).

Obey international, European and national use-related requirements and the manufacturer's specification guidelines.

Medium	Maximum operating pressure [bar]	Maximum operating temperature [°C]	Colour code ¹⁾	Gasket
Drinking water (cold < 25 °C)	16	25	 Blue	EPDM
System water ²⁾	16	95		
Compressed air	16	95		

- The colour code on the packaging gives the indication for a gasket material.
- Primofit **FKM** in black version must be used for heating systems.

Drinking water installation

	Note
	For use with hot drinking water (> 25 °C) GF recommends using Primofit made of stainless steel. For more information, refer to the chapter "Primofit stainless steel for steel and PE/PE-Xa pipe".

When planning and preparing drinking water installations, compliance with the requirements of EN 806-2 is mandatory. Essential information on corrosion prevention for hot-dip galvanised ferrous materials can be found in EN 12502-3. With regard to the compliance with drinking water hygiene in Germany, the requirements of DIN 50930-6, together with the German UBA Criteria for Metallic Materials in its current version, apply and are used by the European 4MS - initiative.

It specifies the installation of hot galvanised iron materials for cold drinking water with a KB8,2 capacity ≤ 0,2 mmol/L and neutral salt ratios S1 < 1. The UBA Criteria for Metallic Materials also gives the requirements for the composition of the zinc layer, compliance with which is demonstrated by GF by the related DVGW certificate. For repair or extension to a current cold and hot water installation on a small scale, as specified in the UBA Criteria for Metallic Materials, in view of the experience from previous operation of the system and the results of a drinking water hygiene analysis, special installation of hot galvanised iron materials is possible.

Certificates

Country	Institute		Application	Certificate
AT	ÖVGW		Drinking water steel and PE/PE-Xa pipe	W 1.602
	ÜA		Drinking water, galvanised Primofit, EPDM for steel / PE/PE - Xa pipe and repair clamps	R-15.2.3-20-17032
DE	DVGW		Drinking water steel pipe	DW-8511BL0157
			Drinking water steel and PE/PE-Xa pipe	DW-7611BT0591
CH	SVGW		Drinking water steel pipe	8704-1985
FR	ACS	ACS	Drinking water steel pipe and PE/PE-Xa pipe	25 ACC LY 277

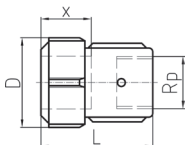
System components

Following fittings are available:

Primofit female adaptor galvanised for steel pipe

Item	Description	Values							
		Dimension St [inch]	Dimension Rp [inch]	EPDM code	GP	Weight [kg]	D [mm]	L [mm]	x [mm]
 	Internal thread Rp according to EN 10226-1	3/8	3/8	775 216 050	30	0,247	45	56	30 - 34
		1/2	1/2	775 216 051	30	0,219	45	60	30 - 34
		3/4	3/4	775 216 052	25	0,289	51	63	30 - 34
		1	1	775 216 053	15	0,309	59	68	30 - 34
		1 1/4	1 1/4	775 216 054	10	0,486	68	72	30 - 36
		1 1/2	1 1/2	775 216 055	10	0,625	75	74	32 - 38
		2	2	775 216 056	5	1,150	96	83	36 - 42
		2 1/2	2 1/2	775 216 057	3	2,660	119	138	65 - 75
		3	3	775 216 058	2	3,074	132	148	65 - 75
		4*)	4*)	775 216 059*)	1*)	5,300*)	178*)	200*)	65 - 75*)

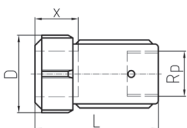
Dimension 4*)



*) Flange design

Primofit female adaptor long galvanised for steel pipe

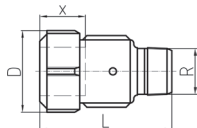
Item	Description	Values							
		Dimension St [inch]	Dimension Rp [inch]	EPDM code	GP	Weight [kg]	D [mm]	L [mm]	x [mm]
	The long female adaptor enables the insertion or sliding over of two pipe thread lengths. This allows the installation between two fixed points. Internal thread Rp according to EN 10226-1	1/2	1/2	775 216 951	30	0,226	45	80	30 - 34
		3/4	3/4	775 216 952	25	0,353	51	78	30 - 34
		1	1	775 216 953	15	0,369	59	88	30 - 34
		1 1/4	1 1/4	775 216 954	10	0,520	68	99	30 - 36



Primofit male adaptor galvanised for steel pipe

Item	Description	Values							
		Dimension St [inch]	Dimension R [inch]	EPDM code	GP	Weight [kg]	D [mm]	L [mm]	x [mm]
	External thread R according to EN 10226-1	3/8	3/8	775 206 050	25	0,210	45	70	30 - 34
		1/2	1/2	775 206 051	25	0,236	45	74	30 - 34
		3/4	3/4	775 206 052	20	0,310	51	81	30 - 34
		1	1	775 206 053	10	0,430	59	90	30 - 34
		1 1/4	1 1/4	775 206 054	10	0,560	68	94	30 - 36
		1 1/2	1 1/2	775 206 055	5	0,630	75	94	32 - 38
		2	2	775 206 056	5	1,184	96	106	36 - 42
		2 1/2	2 1/2	775 206 057	3	2,720	119	173	65 - 75
		3	3	775 206 058	2	3,220	132	186	65 - 75
		4*)	4*)	775 206 059*)	1*)	5,500*)	178*)	212*)	65 - 75*)

Dimension 4*)

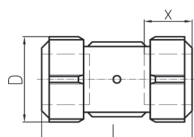


*) Flange design

Primofit coupling short galvanised equal for steel pipe

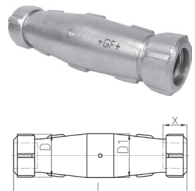
Item	Description	Values						
		Dimension [inch]	EPDM code	GP	Weight [kg]	D [mm]	L [mm]	x [mm]
	-	3/8	775 106 050	25	0,385	45	85	30 - 34
		1/2	775 106 051	25	0,357	45	85	30 - 34
		3/4	775 106 052	20	0,452	51	90	30 - 34
		1	775 106 053	15	0,563	59	96	30 - 34
		1 1/4	775 106 054	10	0,688	68	96	30 - 36
		1 1/2	775 106 055	5	0,860	75	100	32 - 38
		2	775 106 056	5	1,520	96	112	36 - 42
		2 1/2	775 106 057	2	3,712	119	185	65 - 75
		3	775 106 058	2	4,110	132	191	65 - 75
		4*)	775 106 059*)	1*)	6,600*)	178*)	216*)	65 - 75*)

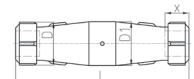
Dimension 4*)



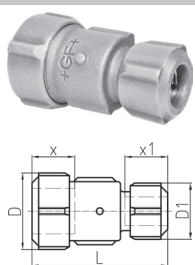
*) Flange design

Primofit coupling long galvanised for steel pipe

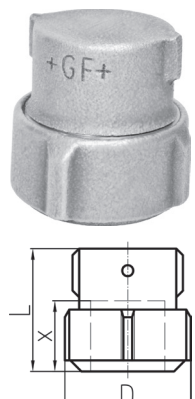
Item	Description	Values							
		Dimension [inch]	EPDM code	GP	Weight [kg]	D [mm]	D [mm]	L [mm]	x [mm]
	-	1	775 156 053	5	1,280	59	65	226	30 - 34
		1 1/4	775 156 054	5	1,420	68	74	229	30 - 36
		1 1/2	775 156 055	5	2,420	75	80	230	32 - 38
		2	775 156 056	4	2,586	96	94	234	36 - 42



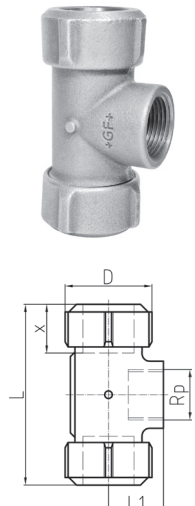
Primofit coupling short galvanised reducing for steel pipe

Item	Description	Values								
		Dimension [inch]	EPDM code	GP	Weight [kg]	D [mm]	D1 [mm]	L [mm]	x [mm]	x1 [mm]
	-	¾ - ½	775 106 061	20	0,340	51	45	90	30 - 34	30 - 34
	-	1 - ½	775 106 062	15	0,520	59	45	97	30 - 34	30 - 34
	-	1 - ¾	775 106 063	15	0,552	59	51	97	30 - 34	30 - 34
	-	1¼ - ¾	775 106 065	10	0,460	68	51	99	30 - 36	30 - 34
	-	1¼ - 1	775 106 066	10	0,692	68	59	97	30 - 36	30 - 34
	-	1½ - 1	775 106 069	5	0,800	75	59	99	32 - 38	30 - 34
	-	1½ - 1¼	775 106 070	5	0,780	75	68	97	32 - 38	30 - 36
	-	2 - 1¼	775 106 074	5	1,280	96	68	109	36 - 42	30 - 36
	-	2 - 1½	775 106 075	5	1,360	96	75	110	36 - 42	32 - 38

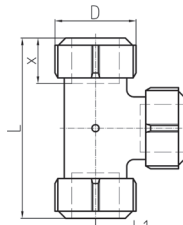
Primofit cap galvanised for steel pipe

Item	Description	Values						
		Dimension [inch]	EPDM code	GP	Weight [kg]	D [mm]	L [mm]	x [mm]
	-	¾	775 456 050	30	0,221	45	48	30 - 34
	-	½	775 456 051	30	0,209	45	48	30 - 34
	-	¾	775 456 052	30	0,240	51	50	30 - 34
	-	1	775 456 053	25	0,296	59	53	30 - 34
	-	1¼	775 456 054	10	0,330	68	54	30 - 36
	-	1½	775 456 055	10	0,460	75	55	32 - 38
	-	2	775 456 056	10	0,935	96	60	36 - 42

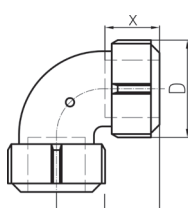
Primofit threaded outlet tee galvanised for steel pipe

Item	Description	Values								
		Dimension St [inch]	Dimension Rp [inch]	EPDM code	GP	Weight [kg]	D [mm]	L [mm]	L1 [mm]	x [mm]
	Internal thread Rp according to EN 10226-1	¾	½	775 316 050	15	0,402	45	101	27	30 - 34
		½	½	775 316 051	15	0,318	45	101	27	30 - 34
		¾	¾	775 316 052	10	0,550	51	107	32	30 - 34
		1	1	775 316 053	5	0,610	59	114	38	30 - 34
		1¼	1¼	775 316 054	5	0,818	68	121	45	30 - 36
		1½	1½	775 316 055	6	1,120	75	133	48	32 - 38
		2	2	775 316 056	4	2,000	96	156	62	36 - 42

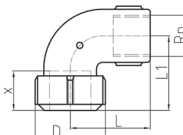
Primofit tee galvanised for steel pipe

Item	Description	Values							
		Dimension [inch]	EPDM code	GP	Weight [kg]	D [mm]	L [mm]	L1 [mm]	x [mm]
	-	3/8	775 306 050	5	0,450	45	110	55	30 - 34
		1/2	775 306 051	5	0,520	45	110	55	30 - 34
		3/4	775 306 052	5	0,660	51	115	58	30 - 34
		1	775 306 053	5	0,880	59	121	61	30 - 34
		1 1/4	775 306 054	5	1,260	68	130	65	30 - 36
		1 1/2	775 306 055	5	1,400	75	144	72	32 - 38
		2	775 306 056	3	2,720	96	166	83	36 - 42
									

Primofit elbow galvanised for steel pipe

Item	Description	Values						
		Dimension [inch]	EPDM code	GP	Weight [kg]	D [mm]	L [mm]	x [mm]
	-	3/8	775 406 050	15	0,434	45	58	30 - 34
		1/2	775 406 051	15	0,317	45	58	30 - 34
		3/4	775 406 052	10	0,359	51	60	30 - 34
		1	775 406 053	10	0,668	59	60	30 - 34
		1 1/4	775 406 054	5	0,840	68	60	30 - 36
		1 1/2	775 406 055	5	1,018	75	76	32 - 38
		2	775 406 056	4	1,460	96	88	36 - 42
								

Primofit female adaptor elbow galvanised for steel pipe

Item	Description	Values								
		Dimension St [inch]	Dimension Rp [inch]	EPDM code	GP	Weight [kg]	D [mm]	L [mm]	L1 [mm]	x [mm]
	Internal thread Rp according to EN 10226-1	¾	¾	775 436 052	10	0,482	51	62	65	30 - 34
		1	1	775 436 053	10	0,544	59	64	65	30 - 34
		1	¾	775 436 063	10	0,601	59	65	65	30 - 34
		¾	1	775 436 081	10	0,780	51	61	65	30 - 34
										

2.3 Primofit black for steel pipe



Note

Spare sets are available for some dimensions of welded steel tubes for pressure purposes of series 2 and 3. For more information, refer to the chapter "Primofit spare sets for steel pipe threaded and butt weld tubes".

The PRIMOFIT is a compression fitting with full end-load capability. In addition, each connection can accommodate an angle deviation up to 3 ° between pipe and compression joint.

This compression fitting according to EN 10344 is used to connect black steel pipes according to EN 10255 and EN 10220 with the standardised outside diameters according to ISO 65.

Pipe specification

Steel/EN 10255 Steel/EN 10220-S1		
Dimension [inch]	OD [mm]	Tolerance range [mm]
3/8	17,2	16,7 – 17,5
1/2	21,3	21,0 – 21,8
3/4	26,9	26,5 – 27,3
1	33,7	33,3 – 34,2
1 1/4	42,4	42,0 – 42,9
1 1/2	48,3	47,9 – 48,8
2	60,3	59,7 – 60,8
2 1/2	76,1	75,3 – 76,6
3	88,9	88,0 – 89,5
4	114,3	113,1 – 115,0

Material



Note

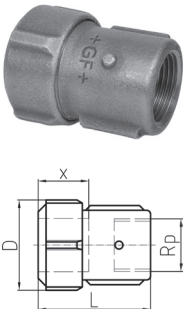
For general information on jointing, use methods and pipe specifications, refer to the chapter "General information".

1. **Body:** white malleable cast iron **EN-GJMW-400-5** as per EN 1562.
2. **Gasket material:** refer to the following chapter "Application".
3. **Corrosion protection:** the installer is responsible for corrosion protection that is necessary.

System components

Following fittings are available:

Primofit tee galvanised for steel pipe

Item	Description	Values							
		Dimension St [inch]	Dimension Rp [inch]	FKM code	GP	Weight [kg]	D [mm]	L [mm]	x [mm]
	Internal thread Rp according to EN 10226-1	3/8	3/8	775 217 050	30	0,227	45	56	30 - 34
		1/2	1/2	775 217 051	30	0,215	45	60	30 - 34
		3/4	3/4	775 217 052	25	0,292	51	63	30 - 34
		1	1	775 217 053	15	0,309	59	68	30 - 34
		1 1/4	1 1/4	775 217 054	10	0,482	68	72	30 - 36
		1 1/2	1 1/2	775 217 055	10	0,595	75	74	32 - 38
		2	2	775 217 056	5	1,108	96	83	36 - 42
		2 1/2	2 1/2	775 217 057	3	2,600	119	138	65 - 75
		3	3	775 217 058	2	3,100	132	148	65 - 75

Application



Note

Primofit compression fittings can be changed for other media, operating conditions and pipe types at all times by using optional spare sets (sealing kits). Thus, Primofit in black version can also be used with NBR seals. For more information, refer to the chapter "Primofit spare sets for steel pipe threaded and butt weld tubes".



Note

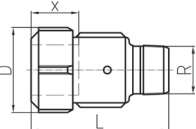
When the pipe is installed underground (the compression joint is exposed directly to soil, sand, etc.), the installer must apply more corrosion protection methods (e.g. tape).

Obey international, European and national use-related requirements and the manufacturer's specification guidelines.

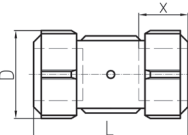
Medium	Maximum operating pressure [bar]	Maximum operating temperature [°C]	Colour code ¹⁾	Gasket
Heating water/steam	10	150	● Green	FKM ²⁾
Water - Glycol ³⁾	10	150		
Compressed air	16	150		
Fuels ⁴⁾	10	40		

- 1) The colour code on the packaging gives the indication for a gasket material.
- 2) FKM seals are not useable for drinking water installations and fuel gases!
- 3) Includes water in ventilation and air conditioning systems. Especially when using antifreeze containing glycol, the use of black fittings with FKM gasket is recommended.
- 4) Diesel and petrol with/without lead.

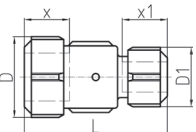
Primofit male adaptor black for steel pipe

Item	Description	Values							
		Dimension St [inch]	Dimension R [inch]	FKM code	GP	Weight [kg]	D [mm]	L [mm]	x [mm]
 	External thread R according to EN 10226-1	$\frac{3}{8}$	$\frac{3}{8}$	775 207 050	25	0,230	45	70	30 - 34
		$\frac{1}{2}$	$\frac{1}{2}$	775 207 051	25	0,200	45	74	30 - 34
		$\frac{3}{4}$	$\frac{3}{4}$	775 207 052	20	0,252	51	81	30 - 34
		1	1	775 207 053	10	0,430	59	90	30 - 34
		$1\frac{1}{4}$	$1\frac{1}{4}$	775 207 054	10	0,547	68	94	30 - 36
		$1\frac{1}{2}$	$1\frac{1}{2}$	775 207 055	5	0,600	75	94	32 - 38
		2	2	775 207 056	5	1,180	96	106	36 - 42
		$2\frac{1}{2}$	$2\frac{1}{2}$	775 207 057	3	2,800	119	173	65 - 75
		3	3	775 207 058	2	3,400	132	186	65 - 75

Primofit coupling short black equal for steel pipe

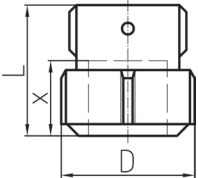
Item	Description	Values						
		Dimension [inch]	FKM code	GP	Weight [kg]	D [mm]	L [mm]	x [mm]
 	-	$\frac{3}{8}$	775 107 050	30	0,323	45	85	30 - 34
		$\frac{1}{2}$	775 107 051	30	0,346	45	85	30 - 34
		$\frac{3}{4}$	775 107 052	20	0,446	51	90	30 - 34
		1	775 107 053	15	0,527	59	96	30 - 34
		$1\frac{1}{4}$	775 107 054	10	0,700	68	96	30 - 36
		$1\frac{1}{2}$	775 107 055	5	0,856	75	100	32 - 38
		2	775 107 056	5	1,560	96	112	36 - 42
		$2\frac{1}{2}$	775 107 057	2	3,500	119	185	65 - 75
		3	775 107 058	2	4,332	132	191	65 - 75

Primofit coupling short black reducing for steel pipe

Item	Description	Values							
		Dimension [inch]	FKM code	GP	Weight [kg]	D [mm]	D1 [mm]	L [mm]	x [mm]
 	-	$\frac{3}{4} - \frac{1}{2}$	775 107 061	20	0,298	51	45	90	30 - 34
		$1 - \frac{1}{2}$	775 107 062	15	0,363	59	45	97	30 - 34
		$1 - \frac{3}{4}$	775 107 063	15	0,399	59	51	97	30 - 34
		$1\frac{1}{4} - 1$	775 107 066	10	0,523	68	59	97	30 - 36
		$1\frac{1}{2} - 1\frac{1}{4}$	775 107 070	5	0,655	75	68	97	32 - 38
		$2 - 1\frac{1}{2}$	775 107 075	5	0,816	96	75	110	36 - 42

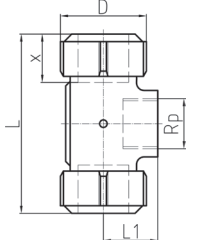
Primofit cap black for steel pipe

Item	Description	Values						
		Dimension [inch]	FKM code	GP	Weight [kg]	D [mm]	L [mm]	x [mm]
	-	3/8	775 457 050	25	0,229	45	48	30 - 34
		1/2	775 457 051	30	0,150	45	48	30 - 34
		3/4	775 457 052	30	0,247	51	50	30 - 34
		1	775 457 053	30	0,345	59	53	30 - 34
		1 1/4	775 457 054	10	0,330	68	54	30 - 36
		1 1/2	775 457 055	10	0,510	75	55	32 - 38
		2	775 457 056	10	0,954	96	60	36 - 42



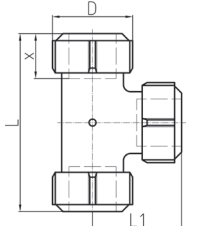
Primofit threaded outlet tee black for steel pipe

Item	Description	Values								
		Dimension St [inch]	Dimension Rp [inch]	FKM code	GP	Weight [kg]	D [mm]	L [mm]	L1 [mm]	x [mm]
	Internal thread Rp according to EN 10226-1	3/8	3/8	775 317 050	15	0,318	45	101	27	30 - 34
		1/2	1/2	775 317 051	15	0,318	45	101	27	30 - 34
		3/4	3/4	775 317 052	10	0,429	51	107	32	30 - 34
		1	1	775 317 053	5	0,711	59	114	38	30 - 34
		1 1/4	1 1/4	775 317 054	5	0,818	68	121	45	30 - 36
		1 1/2	1 1/2	775 317 055	6	1,121	75	133	48	32 - 38
		2	2	775 317 056	3	1,519	96	156	62	36 - 42

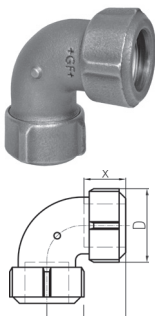


Primofit tee black for steel pipe

Item	Description	Values							
		Dimension [inch]	FKM code	GP	Weight [kg]	D [mm]	L [mm]	L1 [mm]	x [mm]
	-	3/8	775 307 050	5	0,450	45	110	55	30 - 34
		1/2	775 307 051	5	0,417	45	110	55	30 - 34
		3/4	775 307 052	5	0,580	51	115	58	30 - 34
		1	775 307 053	5	1,199	59	121	61	30 - 34
		1 1/4	775 307 054	5	1,505	68	130	65	30 - 36
		1 1/2	775 307 055	5	1,871	75	144	72	32 - 38
		2	775 307 056	3	2,240	96	166	83	36 - 42



Primofit elbow black for steel pipe

Item	Description	Values						
		Dimension [inch]	FKM code	GP	Weight [kg]	D [mm]	L [mm]	x [mm]
	-	3/8	775 407 050	30	0,323	45	58	30 - 34
		1/2	775 407 051	15	0,357	45	58	30 - 34
		3/4	775 407 052	10	0,448	51	60	30 - 34
		1	775 407 053	15	0,510	59	60	30 - 34
		1 1/4	775 407 054	5	0,670	68	60	30 - 36
		1 1/2	775 407 055	5	0,853	75	76	32 - 38
		2	775 407 056	5	1,896	96	88	36 - 42

2.4 Primofit spare sets (sealing kits) for steel pipe threaded and butt-weld tube

Note

Primofit compression fittings can be changed for other media, operating conditions and pipe types at all times by using optional spare sets (sealing kits).

Primofit can be used again by replacing the sealing kit!

By replacing the sealing kits, Primofit can be reused and thus make an important contribution to sustainable environmental protection.

PRIMOFIT is a modular system and offers maximum application flexibility through the possibility of individual combinations of body geometries and spare packs (sealing kits), depending on the application. This eliminates the need for a significant amount of storage. For example, stocked NBR PRIMOFIT can be easily converted to a drinking water-approved EPDM gasket at any time, even on site. Just as PRIMOFIT for steel pipe can be converted for butt weld tubes or even for the use with PE and PE-Xa pipe.

Pipe specification

Note

For general information on jointing, use methods and pipe specifications, refer to the chapter "General information".

Steel/EN 10255 Steel/EN 10220-S1			Steel/EN 10220-S2/3 ¹⁾ (Butt weld tubes)	
Dimension [inch]	OD [mm]	Tolerance range [mm]	Dimension [inch]	DN [mm]
3/8	17,2	16,7 - 17,5	-	-
1/2	21,3	21,0 - 21,8	20,0	19,5 - 20,5
3/4	26,9	26,5 - 27,3	25,0	24,5 - 25,5
1	33,7	33,3 - 34,2	31,8	31,3 - 32,3
1 1/4	42,4	42,0 - 42,9	38,0	44,0 - 45,0
1 1/2	48,3	47,9 - 48,8	44,5	44,0 - 45,0
2	60,3	59,7 - 60,8	51,0	50,5 - 51,5
			57,0	56,4 - 57,6
			63,5	62,9 - 64,1
2 1/2	76,1	75,3 - 76,6	70,0	69,3 - 70,7
3	88,9	88,0 - 89,5	-	-
4	114,3	113,1 - 115,0	-	-

1) Spare sets (sealing kits) for pipe outer diameters of series 2 and 3 are available.

Application

Obey international, European and national use-related requirements and the manufacturer's specification guidelines.

Medium	Maximum operating pressure [bar]	Maximum operating temperature [°C]	Colour code ¹⁾	Gasket	Surface /material Primofit
Fuel gases (including H ₂) ²⁾	10 ³⁾	70			
System water ⁴⁾	16	80	Yellow	NBR	Black and galvanised
Compressed air	16	80			
Oil	16	80			
Drinking water (cold < 25 °C)	16	25			Galvanised
Drinking water (heated > 25 °C)	16	95	Blue	EPDM	Stainless steel ⁸⁾
System water ⁴⁾	16	95			
Compressed air	16	95			Galvanised
Heating water/steam	10	150			
Water - Glycol ⁵⁾	10	150	Green	FKM ⁶⁾	Black
Compressed air	16	150			Galvanised
Fuels ⁷⁾	10	40			

- The colour code on the packaging gives the indication for a gasket material.
- Natural gas (NPG), Liquefied Petroleum Gas (LPG) and Hydrogen (H) with a maximum hydrogen content of 20% by volume. **In Germany, only NBR + graphite (Firejoint) is permitted in buildings.**
- Maximum 5 bar for a connection with thread.
- Primofit **FKM** in black version must be used for heating systems.
- Includes water in ventilation and air conditioning systems. Especially when using antifreeze containing glycol, the use of black fittings with FKM gasket is recommended.
- FKM seals **are not** useable for drinking water installations and fuel gases!

- 7) Diesel and petrol with/without lead.
- 8) For new installations. For repairs and extensions of galvanised piping, which had no corrosion or hygiene problems before, the galvanised version can be used.

System components

Following fittings are available:

Primofit spare packs for steel pipe EN 10255 and butt weld tube EN 10220-S1

Item	Description	Values							
		Dimension St [inch]	D [mm]	EN 10220	NBR code	EPDM code	FKM code	GP	Weight [kg]
	Dimension St refers to the fitting sizes, which need to be combined with the spare packs. D shows the range of the outside diameter of the steel pipe.	3/8	17,2	Series 1	775 958 950	775 959 950	775 967 960	50	0,020
		1/2	21,3	Series 1	775 958 951	775 959 951	775 967 961	50	0,020
		3/4	26,9	Series 1	775 958 952	775 959 952	775 967 962	50	0,028
		1	33,7	Series 1	775 958 953	775 959 953	775 967 963	50	0,033
		1 1/4	42,4	Series 1	775 958 954	775 959 954	775 967 964	50	0,040
		1 1/2	48,3	Series 1	775 958 955	775 959 955	775 967 965	50	0,040
		2	60,3	Series 1	775 958 956	775 959 956	775 967 966	50	0,078
		2 1/2	76,1	Series 1	775 958 917	775 959 957	775 967 967	10	0,140
		3	88,9	Series 1	775 958 918	775 959 958	775 967 968	10	0,160
		4	114,3	Series 1	775 958 919	775 959 959	775 967 969	10	0,204

Primofit spare packs FKM for butt weld tube EN 10220-S2/S3

Item	Description	Values					
		Dimension St [inch]	D [mm]	EN 10220	FKM code	GP	Weight [kg]
	D shows the range of the outside diameter of the butt weld tube ("Siederohr"). Dimension St refers to the fitting sizes, which need to be combined with the spare packs.	1/2*)	20,0*)	Series 2*)	-	-	-
		3/4	25,0	Series 2	775 958 925	20	0,120
		1**)	31,8**)	Series 2**)	-	-	-
		1 1/4	38,0	Series 2	775 958 958	15	0,060
		1 1/2	44,5	Series 3	775 958 959	25	0,100
		2	51,0	Series 2	775 958 960	20	0,130
		2	57,0	Series 2	775 958 957	20	0,129
		2 1/2	70,0	Series 2	775 958 970	20	0,320

*) Use standard compression fitting dimension 1/2 or spare pack 775 967 961

**) Use standard compression fitting dimension 1 or spare pack 775 967 963

Primofit spare pack 3/8 for steel pipe EN 10255

Item	Description	Values					
		Dimension St [inch]	D [mm]	NBR code	FKM code	GP	Weight [kg]
	To adapt 1/2" fittings to 3/8", including nut: NBR = galvanised finish, FKM = black finish. D shows the range of the outside diameter of the steel pipe.	3/8	17,2	775 961 950	775 963 950	25	0,120

Primofit female adaptor set 63,5 for butt weld tube en 10220 D = 63,5mm includes a special female adaptor galvanised



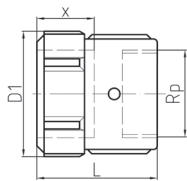
Note

Special dimension for fitting body and nut. Not exchangeable with standard components for 2", only suitable for butt weld tube D = 63,5mm.

Item	Description	Values									
		Dimension St [inch]	Dimension Rp [mm]	D [mm]	EN 10220	FKM code	GP	Weight [kg]	D1 [mm]	L [mm]	x [mm]



D shows the range of the outside diameter of the butt weld tube ("Siederohr").



Primofit seals EPDM for steel pipe EN 10255 and butt weld tube EN 10220-S1

Item	Description	Values					
		Dimension St [inch]	D [mm]	EN 10220	FKM code	GP	Weight [kg]

	Dimension St refers to the fitting sizes, which need to be combined with the spare packs. D shows the range of the outside diameter of the steel pipe.	3/8	17,2	Series 1	775 967 970	20	0,011
		1/2	21,3	Series 1	775 967 971	20	0,012
		3/4	26,9	Series 1	775 967 972	20	0,012
		1	33,7	Series 1	775 967 973	20	0,013
		1 1/4	42,4	Series 1	775 967 974	20	0,015
		1 1/2	48,3	Series 1	775 967 975	20	0,015
		2	60,3	Series 1	775 967 976	20	0,017
		2 1/2	76,1	Series 1	775 967 977	10	0,043
		3	88,9	Series 1	775 967 978	6	0,042
		4	114,3	Series 1	775 967 979	4	0,042

Primofit seals FKM for steel pipe EN 10255 and butt weld tube EN 10220-S1

Item	Description	Values					
		Dimension St [inch]	D [mm]	EN 10220	FKM code	GP	Weight [kg]

	Dimension St refers to the fitting sizes, which need to be combined with the spare packs. D shows the range of the outside diameter of the steel pipe.	3/8	17,2	Series 1	775 967 950	50	0,020
		1/2	21,3	Series 1	775 967 951	50	0,020
		3/4	26,9	Series 1	775 967 952	50	0,030
		1	33,7	Series 1	775 967 953	50	0,080
		1 1/4	42,4	Series 1	775 967 954	50	0,095
		1 1/2	48,3	Series 1	775 967 955	50	0,016
		2	60,3	Series 1	775 967 956	50	0,120
		2 1/2	76,1	Series 1	775 967 957	25	0,077
		3	88,9	Series 1	775 967 958	25	0,078
		4	114,3	Series 1	775 967 959	25	0,099

2.5 Primofit firejoint galvanised fire resistant version for steel pipe



Note

All Primofit compression fittings can be changed into firejoint compression fittings by the use of optional firejoint spare sets (sealing kits). Firejoint spare sets also include a yellow passivated firejoint nut for differentiation.

The PRIMOFIT FIREJOINT is a compression fitting which offers full end-load capability, and resistance against fire impact from outside, for indoor gas line installations 650 °C according to German DVGW and 850 °C according to British Gas test procedures. An additional graphite ring maintains the tension- and shear-resistant connection, as well as the tightness during a fire. In addition, each connection can accommodate an angle deviation up to 3 ° between pipe and compression fitting.

This compression joint according to EN 10344 is used to connect hot-dip galvanised or black steel pipes according to EN 10255 and EN 10220 Series 1 with the standardised outside diameters according to ISO 65. The PRIMOFIT FIREJOINT is available with a yellow passivated FIREJOINT nut for visual differentiation from other PRIMOFIT compression joints.

Pipe specification

Steel/EN 10255 Steel/EN 10220-S1		
Dimension [inch]	OD [mm]	Tolerance range [mm]
1/2	21,3	21,0 - 21,8
3/4	26,9	26,5 - 27,3
1	33,7	33,3 - 34,2
1 1/4	42,4	42,0 - 42,9
1 1/2	48,3	47,9 - 48,8
2	60,3	59,7 - 60,8

Certificates

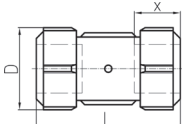
Country	Institute		Application	Certificate
DE	DVGW		Firejoint (fire resistant version) steel pipe for fuel gases	DG-4502CN0374
BE	ARGB - KVBG		Firejoint (fire resistant version) steel pipe for fuel gases	C-11-3552-A
UK	BSI KITEMARK		GIS/PL3 - Firejoint (fire resistant version) steel pipe for fuel gases	KM 539621 (PL3)

System components

Following fittings are available:

Primofit firejoint coupling short galvanised equal for steel pipe

Item	Description	Values							
		Dimension St [inch]	Dimension Rp [inch]	NBR code	GP	Weight [kg]	D [mm]	L [mm]	x [mm]
	-	1/2	1/2	775 104 051	30	0,320	45	83	30 - 34
		3/4	3/4	775 104 052	20	0,410	51	85	30 - 34
		1	1	775 104 053	15	0,560	59	91	30 - 34
		1 1/4	1 1/4	775 104 054	10	0,700	68	93	30 - 36
		1 1/2	1 1/2	775 104 055	5	0,820	75	99	32 - 38
		2	2	775 104 056	5	1,480	96	108	36 - 42



Material



Note

For general information on jointing, use methods and pipe specifications, refer to the chapter "General information".

- Body:** white malleable cast iron **EN-GJMW-400-5** as per EN 1562.
- Gasket material:** refer to the following chapter Application
- Corrosion protection by hot dip galvanising:** as per EN 10344. Firejoint nut additionally galvanised and yellow passivated for colour differentiation.

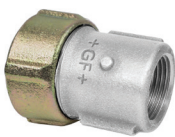
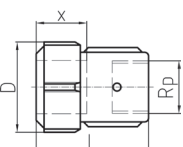
Application

Obey international, European and national use-related requirements and the manufacturer's specification guidelines. Firejoint fulfils the requirements of DVGW TRGI and DIN 3387-1 and has a DVGW certificate for gas systems in buildings and GIS-PL3 certification for the UK.

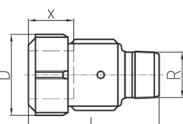
Medium	Maximum operating pressure [bar]	Maximum operating temperature [°C]	Colour code ¹⁾	Gasket
Fuel gases (including H ₂) ²⁾	5	60	 Red	NBR + graphite ³⁾

- The colour code on the packaging gives the indication for a gasket material.
- Natural gas (NPG), Liquefied Petroleum Gas (LPG) and Hydrogen (H) with a maximum hydrogen content of 20% by volume. **In Germany, only NBR + graphite (Firejoint) is permitted in buildings.**
- Firejoint (NBR + graphite) is the fire resistant version, approved for gas systems in buildings.

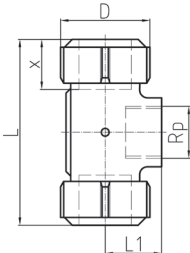
Primofit firejoint female adaptor galvanised for steel pipe

Item	Description	Values							
		Dimension St [inch]	Dimension R [inch]	NBR code	GP	Weight [kg]	D [mm]	L [mm]	x [mm]
	Internal thread Rp according to EN 10226-1	1/2	1/2	775 214 051	30	0,205	45	59	30 - 34
		3/4	3/4	775 214 052	20	0,289	51	61	30 - 34
		1	1	775 214 053	15	0,393	59	67	30 - 34
		1 1/4	1 1/4	775 214 054	10	0,480	68	70	30 - 36
		1 1/2	1 1/2	775 214 055	5	0,620	75	73	32 - 38
		2	2	775 214 056	5	1,120	96	81	36 - 42
									

Primofit firejoint male adaptor galvanised for steel pipe

Item	Description	Values							
		Dimension St [inch]	Dimension Rp [inch]	NBR code	GP	Weight [kg]	D [mm]	L [mm]	x [mm]
	External thread R according to EN 10226-1	1/2	1/2	775 204 051	25	0,240	45	73	30 - 34
		3/4	3/4	775 204 052	20	0,305	51	78	30 - 34
		1	1	775 204 053	10	0,420	59	88	30 - 34
		1 1/4	1 1/4	775 204 054	10	0,554	68	92	30 - 36
		1 1/2	1 1/2	775 204 055	5	0,640	75	94	32 - 38
		2	2	775 204 056	5	1,180	96	104	36 - 42
									

Primofit firejoint male adaptor galvanised for steel pipe

Item	Description	Values								
		Dimension St [inch]	Dimension Rp [inch]	NBR code	GP	Weight [kg]	D [mm]	L [mm]	L1 [mm]	x [mm]
	Internal thread Rp according to EN 10226-1	1/2	1/2	775 314 051	15	0,393	45	99	27	30 - 34
		3/4	3/4	775 314 052	10	0,500	51	102	32	30 - 34
		1	1	775 314 053	5	0,700	59	111	38	30 - 34
		1 1/4	1 1/4	775 314 054	5	0,920	68	117	45	30 - 36
		1 1/2	1 1/2	775 314 055	6	1,140	75	132	48	32 - 38
		2	2	775 314 056	3	2,000	96	152	62	36 - 42
										

Primofit firejoint spare pack

	Note	Primofit is set up as a modular system, each standard Primofit can be used as firejoint Primofit by using a firejoint spare pack. For example: to convert a standard Primofit cap 1" (775 452 053) to firejoint application use a firejoint spare pack (775 958 973).

Item	Description	Values				
		Dimension [inch]	D [mm]	NBR code	GP	Weight [kg]
	Firejoint spare pack includes a golden color coded nut.	1/2	21,3	775 958 971	20	0,120
		3/4	26,9	775 958 972	15	0,140
		1	33,7	775 958 973	20	0,180
		1 1/4	42,4	775 958 974	10	0,200
		1 1/2	48,3	775 958 975	10	0,260
		2	60,3	775 958 996	10	0,460

2.6 Primofit stainless steel for steel and PE/PE-Xa pipe

	Note	This PRIMOFIT Stainless Steel version is used to connect hot-dip galvanised steel pipes according to EN 10255 and EN 10220 with the standardised outside diameters according to ISO 65. The connection of stainless steel pipes is not permitted.

The PRIMOFIT Stainless Steel is a compression fitting which offers full end-load capability and is characterised by low assembly costs and assembly without special tools. In addition, up to 3 ° angular deviation between pipe and compression fitting can be accommodated per connection. 316/V4A stainless steel in contact with the medium according to the German UBA positive list combined with a DVGW (Germany) drinking water certified EPDM gasket ensures unrestricted use in the cold (< 25 °C) and heated (> 25 °C) drinking water sector. PRIMOFIT stainless steel is the first choice alternative to galvanised compression fittings and brass connectors.

Pipe specification

	Note	Primofit stainless steel for PE/PE-Xa pipes can also be used for other plastic pipe systems, for example GF Instaflex (PB) pipe systems, after technical clarification of the operating limits.

Steel/EN 10255 Steel/EN 10220-S1		PE EN 12201-2/water				PE-Xa DIN 16892/93 and EN ISO 15875-2
-		SDR	7,4	11	17,6 (17)	11
-		S	3,2	5	8,3	5
Dimension [inch]	OD [mm]	OD [mm]	s [mm]	s [mm]	s [mm]	s [mm]
1/2	21,3	20	3,0	2,0	-	1,9
3/4	26,9	25	3,5	2,3	2,0 (2,0)	2,3
1	33,7	32	4,4	3,0	2,0 (2,0)	2,9
1 1/4	42,4	40	5,5	3,7	2,3 (2,4)	3,7
1 1/2	48,3	50	6,9	4,6	2,9 (3,0)	4,6
2	60,3	63	8,6	5,8	3,6 (3,8)	5,8

Material

	Note	Questions about material combinations? We will be pleased to give you support. Please contact your responsible technical support team.
	Note	In general, single fittings made of noble materials, for example stainless steel, are not a problem in steel pipe systems made of lower-grade steel because of the large surface difference.

	Note
	For general information on jointing, use methods and pipe specifications, refer to the chapter "General information".
	1. Body: stainless steel 316 (V4A)
	2. Nut: stainless steel 316 (V4A)
	3. Gasket material: refer to the following chapter "Application".
	4. Corrosion protection: Corrosion-free stainless steel.

Application

	Note	Primofit compression fittings can be changed for other media, operating conditions and pipe types at all times by using optional spare sets (sealing kits).
	Note	In the field of drinking water, only Primofit compression fittings with EPDM gasket must be used. When the pipe is installed underground (the compression joint is exposed directly to soil, sand, etc.), the installer must apply more corrosion protection methods (e.g. tape).

Obey international, European and national use-related requirements and the manufacturer's specification guidelines.

Many buildings have galvanised hot water installations without hygienic problems. Section 1 of the German UBA criteria includes the repair of pipes made of hot-dip galvanised iron material if the specified conditions are satisfied. If the specified conditions are not satisfied, use the Primofit stainless steel compression fitting as an alternative. All materials in contact with drinking water (body and elastomer gasket) are in accordance with UBA requirements.

Pipe types	Medium	Maximum operating pressure [bar]	Maximum operating temperature [°C]	Colour code ¹⁾	Gasket
Steel pipe	Drinking water (cold & heated)	16	95	Blue	EPDM
	System water ²⁾	16	95		
	Compressed air	16	95		
	Heating water/steam	10	150	Green	FKM ³⁾
	Water - Glycol	10	150		
	Compressed air	16	150		
	Fuels ⁶⁾	10	40		
	System water ²⁾	16	80	Yellow	NBR ⁴⁾
	Compressed air	16	80		
	Oil	16	80		
PE/PE-Xa pipe	Drinking water (cold & heated)	16	40	Blue	EPDM ⁵⁾
	System water ²⁾	16	40	Yellow	NBR ⁵⁾

- 1) The colour code on the packaging gives the indication for a gasket material.
- 2) For heating systems, use Primofit stainless steel with FKM gaskets.
- 3) For steel pipes optional FKM gasket spare sets (sealing kits) are available.

- 4) For steel pipes optional NBR gasket spare sets (sealing kits) are available. Primofit stainless steel NBR is currently not approved for fuel gases.
- 5) For PE/PE-Xa pipes optional spare sets (sealing kits) are available.
- 6) Diesel and petrol with/without lead.

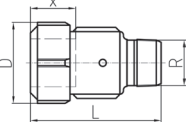
Certificates

Country	Institute		Application	Certificate
AT	ÖVGW		Gas steel pipe	G 2.515
			Drinking water steel and PE/PE-Xa pipe	W 1.602
	ÜA		Drinking water, galvanised Primofit, EPDM for steel / PE/PE - Xa pipe and repair clamps	R-15.2.3-20-17032
			Drinking water, stainless steel Primofit, EPDM for steel / PE/PE - Xa pipe	R-15.2.3-22-17649
DE	DVGW		Drinking water steel pipe	DW-8511BL0157
			Drinking water steel and PE/PE-Xa pipe	DW-7611BT0591
			Gas steel pipe	DG-4502CN0373
			Gas steel and PE/PE-Xa pipe	DG-7521BP5519
			Firejoint (HTL version) steel pipe	DG-4502CN0374
CH	SVGW		Gas steel and PE/PE-Xa pipe	05-045-6
			Drinking water steel pipe	8704-1985
NL	KIWA GASTEC		Gas steel pipe	AR 91 Q 96/086, Nr. 56585
			Gas PE/PE-Xa Pipe	AR 70 Q 96/086, Nr. 56584
			Hydrogen ready steel pipe	AR 214 Q96/086, Nr. 107696
			Hydrogen ready PE/PE-Xa pipe	AR 214 Q96/086, Nr. 107695/01
FR	FR	ACS	Drinking water steel pipe and PE/PE-Xa pipe	25 ACC LY 277
UK	BSI KITEMARK		GIS/ PL3 including Primofit Firejoint (HTL version) steel pipe for gas	KM 539621 (PL3)
BE	ARGB - KVBG		Firejoint (HTL version) steel pipe for gas	C-11-3552-A
IT	KIWA UNI		Gas and drinking water steel pipe	KIP102154
			Gas and drinking water PE/PE-Xa pipe	KIP102153

System components

Following fittings are available:

Primofit stainless steel male adaptor galvanised for steel pipe

Item	Description	Values							
		Dimension St [inch]	Dimension Rp [inch]	EPDM code	GP	Weight [kg]	D [mm]	L [mm]	x [mm]
 	External thread R according to EN 10226-1	1/2	1/2	775 200 051	25	0,200	45	73	30 - 34
		3/4	3/4	775 200 052	20	0,270	51	78	30 - 34
		1	1	775 200 053	10	0,380	59	88	30 - 34
		1 1/4	1 1/4	775 200 054	10	0,480	68	92	30 - 36
		1 1/2	1 1/2	775 200 055	5	0,600	75	94	32 - 38
		2	2	775 200 056	5	1,060	96	104	36 - 42

Primofit spare packs for steel pipe EN 10255 and butt weld tube EN 10220-S1

Item	Description	Values						
		Dimension St [inch]	D [mm]	EN 10220	NBR code	FKM code	GP	Weight [kg]
	Dimension St refers to the fitting sizes, which need to be combined with the spare packs. D shows the range of the outside diameter of the steel pipe.	1/2	21,3	Series 1	775 958 951	775 967 961	50	0,020
		3/4	26,9	Series 1	775 958 952	775 967 962	50	0,028
		1	33,7	Series 1	775 958 953	775 967 963	50	0,033
		1 1/4	42,4	Series 1	775 958 954	775 967 964	50	0,040
		1	48,3	Series 1	775 958 955	775 967 965	50	0,040
		2	60,3	Series 1	775 958 956	775 967 966	50	0,078

Primofit spare packs + insert stiffeners for PE/PE-Xa pipe

Item	Description	Values							
		SDR	Dimension PE [mm]	NBR code	EPDM code	GP	Weight [kg]	Stiffener material	Colour
	-	11	20 x 2,0	775 958 201	775 959 201	25	0,035	Plastic (POM)	White
		11	25 x 2,3	775 958 202	775 959 202	25	0,050	Plastic (POM)	White
		11	32 x 3,0	775 958 203	775 959 203	25	0,062	Plastic (POM)	White
		11	40 x 3,7	775 958 204	775 959 204	25	0,110	Plastic (POM)	White
		11	50 x 4,6	775 958 205	775 959 205	20	0,140	Plastic (POM)	White
		11	63 x 5,8	775 958 206	775 959 206	10	0,170	Plastic (POM)	White

2.7 Primofit galvanised transition from steel to PE/PE-Xa pipe



Note

Please note the different wall thicknesses of the PE/PE-Xa pipes (SDR series).

The PRIMOFIT is a compression fitting with full end-load capability. In addition, each connection can accommodate an angle deviation up to 3 ° between pipe and compression fitting. This compression fitting according to EN 10284 is used to connect hot-dip galvanised steel pipes according to EN 10255 and EN 10220-S1 with the standardised outside diameters according to ISO 65 with polyethylene pipes according to EN 1555-2 with material PE 100 or PE 80, as well as with cross-linked polyethylene pipes PE-Xa according to DIN 16892/93.

Pipe specification



Note

The scope of supply also includes stiffener(s). The use of stiffeners is mandatory.

For correct selection of the compression fitting, monitor the different wall thicknesses of the PE/PE-Xa pipes (SDR series). The wall thickness and pipe diameter are shown in the range table below.

PE EN 1555-2/Gas			PE-Xa DIN 16892/93	Steel/EN 10255 Steel/EN 10220-S1	
SDR	11	17,6	11	-	
S	5	8,3	5	-	
OD [mm]	s [mm]	s [mm]	s [mm]	Dimension [inch]	D [mm]
20	3,0	2,3	1,9	1/2	21,3
25	3,0	2,3	2,3	3/4	26,9
32	3,0	2,3	2,9	1	33,7
40	3,7	2,3	3,7	1 1/4	42,4
50	4,6	2,9	4,6	1 1/2	48,3
63	5,8	3,6	5,8	2	60,3

Material



Note

For general information on jointing, use methods and pipe specifications, refer to the chapter "General information".

- Body:** white malleable cast iron **EN-GJMW-400-5** as per EN 1562.
- Gasket material:** refer to the following chapter "Application".
- Corrosion protection by hot dip galvanising:** as per EN 10284.

Application



Note

When the pipe is installed underground (the compression joint is exposed directly to soil, sand, etc.), the installer must apply more corrosion protection methods (e.g. tape).

Obey international, European and national use-related requirements and the manufacturer's specification guidelines.

The maximum operating pressure is calculated by the pipe specification and local requirements.

Medium	Maximum operating pressure [bar]	Maximum operating temperature [°C]	Colour code ¹⁾	Gasket
Fuel gases (including H ₂) ²⁾	10 ³⁾	40	● Yellow	NBR
System water	16	40		

- The colour code on the packaging gives the indication for a gasket material.
- Natural gas (NPG), Liquefied Petroleum Gas (LPG) and Hydrogen (H) with a maximum hydrogen content of 20% by volume. **In some countries Steel-PE connections in general are not permitted for gas installations in buildings, please check your local regulations!**
- 10 bar for PE100 or 8 bar for PE-Xa or 5 bar for a connection with thread.

Certificates

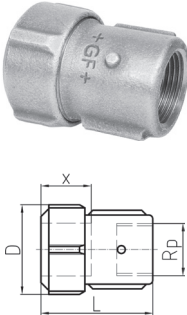
Country	Institute		Application	Certificate
DE	DVGW		Gas steel and PE/PE-Xa pipe	DG-7521BP5519
CH	SVGW		Gas steel and PE/PE-Xa pipe	05-045-6
NL	KIWA GASTEC		Gas steel pipe	AR 91 Q 96/086, Nr. 56585
			Gas PE/PE-Xa Pipe	AR 70 Q 96/086, Nr. 56584
			Hydrogen ready steel pipe	AR 214 Q96/086, Nr. 107696
			Hydrogen ready PE/PE-Xa pipe	AR 214 Q96/086, Nr. 107695
UK	BSI KITEMARK		Gas GIS/PL3	KM 539621 (PL3)
IT	KIWA UNI		Gas and drinking water steel pipe	KIP102154
			Gas and drinking water PE/PE-Xa pipe	KIP102153

For transition to PE pipes no ÖVGW gas certificate is available.

System components

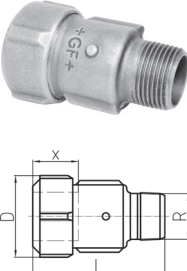
Following fittings are available:

Primofit female adaptor galvanised for PE/PE-Xa pipe

Item	Description	Values								
		SDR	Dimension PE [mm]	Dimension Rp [inch]	NBR code	GP	Weight [kg]	D [mm]	L [mm]	x [mm]
	Internal thread Rp according to EN 10226-1 including insert stiffener	11	20 x 2,0	1/2	775 212 201	30	0,227	45	58	31 - 33
		11	25 x 2,3	3/4	775 212 202	20	0,300	51	62	31 - 33
		11*)	25 x 3,0*)	3/4*)	775 212 442*)	20*)	0,300*)	51*)	62*)	31 - 33*)
		11	32 x 3,0	1	775 212 203	10	0,400	59	68	31 - 33
		11	40 x 3,7	1 1/4	775 212 204	5	0,560	68	70	32 - 38
		11	50 x 4,6	1 1/2	775 212 205	5	0,700	75	75	35 - 43
		11	63 x 5,8	2	775 212 206	5	1,308	96	83	39 - 47
		17,6*)	25 x 2,3*)	3/4*)	775 212 452*)	20*)	0,300*)	51*)	63*)	30 - 34*)
		17,6*)	32 x 2,3*)	1*)	775 212 453*)	10*)	0,400*)	59*)	68*)	30 - 34*)
		17,6*)	40 x 2,3*)	1 1/4*)	775 212 454*)	5*)	0,560*)	68*)	70*)	32 - 38*)
		17,6*)	50 x 2,9*)	1 1/2*)	775 212 455*)	5*)	0,700*)	75*)	75*)	35 - 43*)
		17,6*)	63 x 3,6*)	2*)	775 212 456*)	5*)	1,308*)	96*)	83*)	39 - 47*)

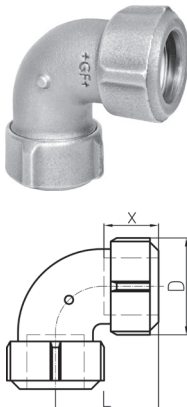
*) According to EN 1555-2

Primofit male adaptor galvanised for PE/PE-Xa pipe

Item	Description	Values								
		SDR	Dimension PE [mm]	Dimension R [inch]	NBR code	GP	Weight [kg]	D [mm]	L [mm]	x [mm]
	External thread R according to EN 10226-1 including insert stiffener	11	20 x 2,0	1/2	775 202 201	20	0,239	45	73	31 - 33
		11	25 x 2,3	3/4	775 202 202	20	0,316	51	79	31 - 33
		11*)	25 x 3,0*)	3/4*)	775 202 442*)	20*)	0,300*)	51*)	79*)	31 - 33*)
		11	32 x 3,0	1	775 202 203	10	0,422	59	89	31 - 33
		11	40 x 3,7	1 1/4	775 202 204	5	0,600	68	92	32 - 38
		11	50 x 4,6	1 1/2	775 202 205	5	0,760	75	96	35 - 43
		11	63 x 5,8	2	775 202 206	5	1,343	96	106	39 - 47
		17,6	25 x 2,0	3/4	775 202 602	20	0,295	51	79	31 - 33
		17,6*)	25 x 2,3*)	3/4*)	775 202 452*)	20*)	0,295*)	51*)	79*)	31 - 33*)
		17,6	32 x 2,0	1	775 202 603	10	0,460	59	89	31 - 33
		17,6*)	32 x 2,3*)	1*)	775 202 453*)	10*)	0,460*)	59*)	89*)	31 - 33*)
		17,6*)	40 x 2,3*)	1 1/4*)	775 202 454*)	5*)	0,600*)	68*)	92*)	32 - 38*)
		17,6*)	50 x 2,9*)	1 1/2*)	775 202 455*)	5*)	0,760*)	75*)	96*)	35 - 43*)
		17,6*)	63 x 3,6*)	2*)	775 202 456*)	5*)	1,343*)	96*)	106*)	39 - 47*)

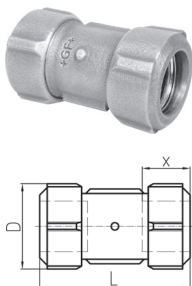
*) According to EN 1555-2

Primofit elbow galvanised for PE/PE-Xa pipe

Item	Description	Values									
		SDR	Dimension PE [mm]	Dimension R [inch]	NBR code	GP	Weight [kg]	D [mm]	L [mm]	x PE [mm]	x St [mm]
	Including insert stiffener	11	20 x 2,0	½	775 402 501	20	0,390	45	58	31 - 33	30 - 34
		11	25 x 2,3	¾	775 402 502	10	0,460	51	59	31 - 33	30 - 34
		11*)	25 x 3,0*)	¾*)	775 402 442*)	10*)	0,460*)	51*)	59*)	31 - 33*)	30 - 34*)
		11	32 x 3,0	1	775 402 503	10	0,660	59	59	31 - 33	30 - 34
		11	40 x 3,7	1¼	775 402 504	5	0,889	68	59	32 - 38	30 - 36
		11	50 x 4,6	1½	775 402 505	5	1,140	75	78	35 - 43	32 - 38
		11	63 x 5,8	2	775 402 506	4	2,060	96	88	39 - 47	36 - 42
		17,6*)	32 x 2,3*)	1*)	775 402 453*)	10*)	0,660*)	59*)	59*)	31 - 33*)	30 - 34*)
		17,6*)	40 x 2,3	1¼*)	775 402 454*)	5*)	0,889*)	68*)	59*)	32 - 38*)	30 - 36*)
		17,6*)	50 x 2,9	1½*)	775 402 455*)	5*)	1,140*)	75*)	78*)	35 - 43*)	32 - 38*)
		17,6*)	63 x 3,6	2*)	775 402 456*)	4*)	1,952*)	96*)	88*)	39 - 47*)	36 - 42*)

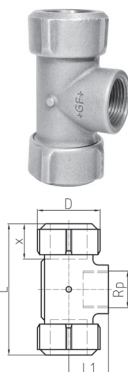
*) According to EN 1555-2

Primofit coupling short galvanised equal for PE/PE-Xa pipe to steel pipe

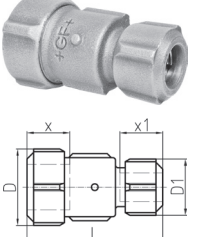
Item	Description	Values									
		SDR	Dimension PE [mm]	Dimension R [inch]	NBR code	GP	Weight [kg]	D [mm]	L [mm]	x PE [mm]	x St [mm]
	Including insert stiffener	7,4	20 x 3,0	1/2	775 102 701	20	0,378	45	85	31 - 33	30 - 34
		7,4	25 x 3,5	3/4	775 102 702	5	0,403	51	89	31 - 33	30 - 34
		7,4	32 x 4,4	1	775 102 703	15	0,632	59	95	31 - 33	30 - 34
		7,4	40 x 5,5	1 1/4	775 102 704	10	0,760	68	96	32 - 38	30 - 36
		7,4	50 x 6,9	1 1/2	775 102 705	5	0,900	75	103	35 - 43	32 - 38
		7,4	63 x 8,6	2	775 102 706	5	1,680	96	113	39 - 47	36 - 42
		11	20 x 2,0	1/2	775 102 501	20	0,363	45	85	31 - 33	30 - 34
		11	25 x 2,3	3/4	775 102 502	20	0,408	51	89	31 - 33	30 - 34
		11*)	25 x 3,0*)	3/4*)	775 102 442*)	20*)	0,408*)	51*)	89*)	31 - 33*)	30 - 34*)
		11	32 x 3,0	1	775 102 503	15	0,595	59	95	31 - 33	30 - 34
		11	40 x 3,7	1 1/4	775 102 504	10	0,760	68	96	32 - 38	30 - 36
		11	50 x 4,6	1 1/2	775 102 505	5	0,920	75	103	35 - 43	32 - 38
		11	63 x 5,8	2	775 102 506	5	1,700	96	113	39 - 47	36 - 42
		17,6	25 x 2,0	3/4	775 102 602	20	0,462	51	89	31 - 33	30 - 34
		17,6*)	25 x 2,3*)	3/4*)	775 102 452*)	20*)	0,462*)	51*)	89*)	31 - 33*)	30 - 34*)
		17,6	32 x 2,0	1	775 102 603	15	0,644	59	95	31 - 33	30 - 34
		17,6*)	32 x 2,3*)	1*)	775 102 453*)	15*)	0,644*)	59*)	95*)	31 - 33*)	30 - 34*)
		17,6	40 x 2,3	1 1/4	775 102 604	10	0,770	68	96	32 - 38	30 - 36
		17,6	50 x 2,9	1 1/2	775 102 605	5	0,900	75	103	35 - 43	32 - 38
		17,6	63 x 3,6	2	775 102 606	5	1,836	96	113	39 - 47	36 - 42

*) According to EN 1555-2

Primofit threaded outlet tee galvanised for PE/PE-Xa pipe

Item	Description	Values									
		SDR	Dimension PE [mm]	Dimension R [inch]	NBR code	GP	Weight [kg]	D [mm]	D1 [mm]	L [mm]	x PE [mm]
	Internal thread Rp according to EN 10226-1 including insert stiffeners	11	32 x 3,0	1	775 312 203	5	0,718	59	112	38	31 - 33
		11	63 x 5,8	2	775 312 206	3	2,250	96	155	62	39 - 47

Primofit coupling short galvanised reducing for PE/PE-Xa pipe to steel pipe

Item	Description	Values										
		SDR	Dimension PE [mm]	Dimension R [inch]	NBR code	GP	Weight [kg]	D [mm]	D1 [mm]	L [mm]	x PE [mm]	x St [mm]
	Including insert stiffener	11	20 x 2,0	¾	775 102 511	20	0,328	51	45	90	31 - 33	30 - 34
		11	25 x 2,3	½	775 102 526	20	0,435	45	51	90	31 - 33	30 - 34
		11	25 x 2,3	1	775 102 513	10	0,540	59	51	97	31 - 33	30 - 34
		11	25 x 2,3	1¼	775 102 515	11	0,700	68	51	98	31 - 33	30 - 36
		11	32 x 3,0	¾	775 102 531	10	0,540	51	59	97	31 - 33	30 - 34
		11	32 x 3,0	1¼	775 102 516	11	0,70	68	59	98	31 - 33	30 - 36
		11	32 x 3,0	1½	775 102 519	5	0,860	75	59	98	31 - 33	32 - 38
		11	40 x 3,7	1	775 102 535	5	0,740	59	68	97	32 - 38	30 - 34
		11	40 x 3,7	1½	775 102 520	5	0,860	75	68	97	32 - 38	32 - 38
		11	40 x 3,7	2	775 102 524	5	1,440	96	98	109	32 - 38	36 - 42
		11	50 x 4,6	1¼	775 102 538	5	0,757	68	75	100	35 - 43	30 - 36
		11	50 x 4,6	2	775 102 525	5	1,440	96	75	112	35 - 43	36 - 42
		11	63 x 5,8	1½	775 102 540	5	1,540	75	96	112	39 - 47	32 - 38

2.8 Primofit galvanised transition from steel to PE/PE-Xa with EPDM gasket for drinking water

The PRIMOFIT is a compression fitting with full end-load capability. In addition, each connection can accommodate an angle deviation up to 3 ° between pipe and compression fitting. This compression fitting according to EN 10284 is used to connect hot-dip galvanised steel pipes according to EN 10255 and EN 10220-S1 with the standardised outside diameters according to ISO 65 with polyethylene pipes according to EN 12201-2 with material PE 100 or PE 80, as well as with cross-linked polyethylene pipes PE-Xa according to DIN 16892/93.

Pipe specification

!	Note					
	The scope of supply also includes stiffener(s). The operation of stiffeners is mandatory.					
!	For correct selection of the compression fitting, monitor the different wall thicknesses of the PE/PE-Xa pipes (SDR series). The wall thickness and pipe diameter are shown in the range table below.					
	Primofit stainless steel for PE/PE-Xa pipes can also be used for other plastic pipe systems, for example GF Instaflex (PB) pipe systems, after technical clarification of the operating limits.					

PE EN 12201-2/water				PE-Xa EN ISO 15875-2	Steel/EN 10255 Steel/EN 10220-S1	
SDR	7,4	11	17,6 (17)	11	-	
S	3,2	5	8,3 (8)	5	-	
OD [mm]	s [mm]	s [mm]	s [mm]	s [mm]	Dimension [inch]	OD [mm]
20	3,0	2,0	-	1,9	½	21,3
25	3,5	2,3	2,0 (2,0)	2,3	¾	26,9
32	4,4	3,0	2,0 (2,0)	2,9	1	33,7
40	5,5	3,7	2,3 (2,4)	3,7	1¼	42,4
50	6,9	4,6	2,9 (3,0)	4,6	1½	48,3
63	8,6	5,8	3,6 (3,8)	5,8	2	60,3

Material

!	Note					
	For general information on jointing, use methods and pipe specifications, refer to the chapter "General information".					

- Body:** white malleable cast iron **EN-GJMW-400-5** as per EN 1562.
- Gasket material:** refer to the following chapter "Application".
- Corrosion protection by hot dip galvanising:** as per EN 10284.

Application

!	Note					
	In the field of drinking water, only Primofit compression fittings with EPDM seal shall be used. When the pipe is installed underground (the compression joint is exposed directly to soil, sand, etc.), the installer must apply more corrosion protection methods (e.g. tape).					

Obey international, European and national use-related requirements and the manufacturer's specification guidelines.

The maximum operating pressure is calculated by the pipe specification and local requirements.

Medium	Maximum operating pressure [bar]	Maximum operating temperature [°C]	Colour code ¹⁾	Gasket
Drinking water (cold < 25 °C)	16	25	Blue	EPDM

- The colour code on the packaging gives the indication for a gasket material.

Drinking water installation

!	Note					
	For use with hot drinking water (> 25 °C) we recommend using Primofit made of stainless steel. For more information, refer to the chapter "Primofit stainless steel for steel and PE/PE-Xa pipe".					

When planning and designing drinking water installations, compliance with the regulations of EN 806-2 is mandatory. Essential information on corrosion prevention for hot-dip galvanised ferrous materials can be found in EN 12502-3. With regard to the compliance with drinking water hygiene in Germany, the requirements of DIN 50930-6, together with the German UBA Evaluation Criteria for Metallic Materials in its currently valid version apply and is adopted by the European 4MS - Initiative. It approves the use of hot-dip galvanised iron materials for cold drinking water with a base capacity of KB8,2 ≤ 0,2 mmol/L and neutral salt ratios S1 < 1. The UBA Evaluation Criteria for Metallic Materials also regulates the requirements for the composition of the zinc coating, compliance with which is demonstrated by GF by the associated DVGW certificate. In the case of a repair or additions to an existing cold and hot water installation on a small scale, according to the UBA Evaluation Criteria for Metallic Materials, based on the experience in the previous operation of the system and the results of a drinking water hygiene analysis, the exceptional use of hot dip galvanized iron materials is possible.

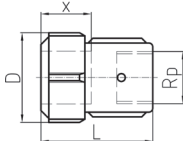
Certificates

Country	Institute		Application	Certificate
AT	ÖVGW		Drinking water steel and PE/PE-Xa pipe	W 1.602
	ÜA		Drinking water, galvanised Primofit, EPDM for steel / PE/PE - Xa pipe and repair clamps	R-15.2.3-20-17032
DE	DVGW		Drinking water steel pipe	DW-8511BL0157
			Drinking water steel and PE/PE-Xa pipe	DW-7611BT0591
CH	SVGW		Drinking water steel pipe	8704-1985
FR	ACS		Drinking water steel pipe and PE/PE-Xa pipe	25 ACC LY 277

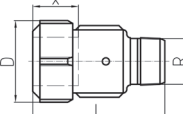
System components

Following fittings are available:

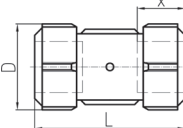
PRIMOFIT female adaptor galvanised for PE/PE-Xa pipe

Item	Description	Values								
		SDR	Dimension PE [mm]	Dimension Rp [inch]	EPDM code	GP	Weight [kg]	D [mm]	L [mm]	x [mm]
 	Internal thread Rp according to EN 10226-1 including insert stiffener	11	20 x 2,0	1/2	775 216 201	30	0,235	45	58	31 - 33
		11	25 x 2,3	3/4	775 216 202	20	0,315	51	62	31 - 33
		11	32 x 3,0	1	775 216 203	10	0,414	59	68	31 - 33
		11	40 x 3,7	1 1/4	775 216 204	5	0,560	68	70	32 - 38
		11	50 x 4,6	1 1/2	775 216 205	5	0,700	75	75	35 - 43
		11	63 x 5,8	2	775 216 206	5	1,216	96	83	39 - 47

PRIMOFIT male adaptor galvanised for PE/PE-Xa pipe

Item	Description	Values								
		SDR	Dimension PE [mm]	Dimension R [inch]	EPDM code	GP	Weight [kg]	D [mm]	L [mm]	x [mm]
 	External thread R according to EN 10226-1 including insert stiffener	11	20 x 2,0	1/2	775 206 201	20	0,239	45	73	31 - 33
		11	25 x 2,3	3/4	775 206 202	20	0,316	51	79	31 - 33
		11	32 x 3,0	1	775 206 203	15	0,422	59	89	31 - 33
		11	40 x 3,7	1 1/4	775 206 204	5	0,600	68	92	32 - 38
		11	50 x 4,6	1 1/2	775 206 205	5	0,760	75	96	35 - 43
		11	63 x 5,8	2	775 206 206	5	1,343	96	106	39 - 47

Primofit coupling short galvanised equal for PE/PE-Xa pipe to steel pipe

Item	Description	Values									
		SDR	Dimension PE [mm]	Dimension R [inch]	EPDM code	GP	Weight [kg]	D [mm]	L [mm]	x PE [mm]	x St [mm]
 	Including insert stiffener	11	20 x 2,0	1/2	775 106 501	20	0,363	45	85	31 - 33	30 - 34
		11	25 x 2,3	3/4	775 106 502	20	0,450	51	89	31 - 33	30 - 34
		11	32 x 3,0	1	775 106 503	15	0,533	59	95	31 - 33	30 - 34
		11	40 x 3,7	1 1/4	775 106 504	10	0,760	68	96	32 - 38	30 - 36
		11	50 x 4,6	1 1/2	775 106 505	5	0,920	75	103	35 - 43	32 - 38
		11	63 x 5,8	2	775 106 506	5	1,700	96	113	39 - 47	36 - 42

2.9 Primofit galvanised for PE/PE-Xa pipe

The PRIMOFIT is a compression fitting with full end-load capability. In addition, each connection can accommodate an angle deviation up to 3 ° between pipe and compression joint. This compression joint acc. to EN 10284 is used to connect polyethylene pipes acc. to EN 1555-2 with material PE 100 or PE 80 and cross-linked polyethylene pipes PE-Xa and DIN 16892/93.

Pipe specification

!	Note		
	The scope of supply also includes stiffener(s). The use of stiffeners is mandatory.		
!	For correct selection of the compression fitting, monitor the different wall thicknesses of the PE/PE-Xa pipes (SDR series). The wall thickness and pipe diameter are shown in the range table below.		
	Note		
	Primofit stainless steel for PE/PE-Xa pipes can also be used for other plastic pipe systems, for example GF Instaflex (PB) pipe systems, after technical clarification of the operating limits.		

PE EN 1555-2/Gas			PE-Xa DIN 16892/93
SDR	11	17,6	11
S	5	8,3	5
OD [mm]	s [mm]	s [mm]	s [mm]
20	3,0	2,3	1,9
25	3,0	2,3	2,3
32	3,0	2,3	2,9
40	3,7	2,3	3,7
50	4,6	2,9	4,6
63	5,8	3,6	5,8

Material

- Note**
For general information on jointing, use methods and pipe specifications, refer to the chapter "General information".
- Body:** white malleable cast iron **EN-GJMW-400-5** as per EN 1562.
 - Gasket material:** refer to the following chapter "Application".
 - Corrosion protection by hot dip galvanising:** as per EN 10284.

Application

- Note**
When the pipe is installed underground (the compression joint is exposed directly to soil, sand, etc.), the installer must apply more corrosion protection methods (e.g. tape).
- Obey international, European and national use-related requirements and the manufacturer's specification guidelines.
- The maximum operating pressure is calculated by the pipe specification and local requirements.

Medium	Maximum operating pressure [bar]	Maximum operating temperature [°C]	Colour code ¹⁾	Gasket
Fuel gases (including H ₂) ²⁾	10 ³⁾	40	Yellow	NBR
System water ⁴⁾	16	40		

- The colour code on the packaging gives the indication for a gasket material.
- Natural gas (NPG), Liquefied Petroleum Gas (LPG) and Hydrogen (H) with a maximum hydrogen content of 20% by volume. **In some countries Steel-PE connections in general are not permitted for gas installations in buildings, please check your local regulations!**
- Maximum 10 bar for PE100 or 8 bar for PE-Xa or 5 bar for a connection with thread.

Certificates

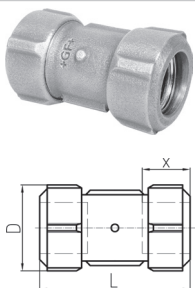
Country	Institute		Application	Certificate
DE	DVGW		Gas steel and PE/PE-Xa pipe	DG-7521BP5519
CH	SVGW		Gas steel and PE/PE-Xa pipe	05-045-6
NL	KIWA GASTEC		Gas PE/PE-Xa Pipe	AR 70 Q 96/086, Nr. 56584
	KIWA GASTEC H ₂		Hydrogen ready PE/PE-Xa pipe	AR 214 Q96/086, Nr. 107695
UK	BSI KITEMARK		Gas GIS/PL3	KM 539621 (PL3)
IT	KIWA UNI		Gas and drinking water steel pipe	KIP102154
			Gas and drinking water PE/PE-Xa pipe	KIP102153

For transition to PE pipes no ÖVGW gas certificate is available.

System components

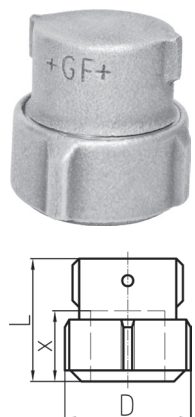
Following fittings are available:

Primofit coupling short galvanised equal for PE/PE-Xa pipe

Item	Description	Values							
		SDR	Dimension PE [mm]	EPDM code	GP	Weight [kg]	D [mm]	L [mm]	x [mm]
	Including insert stiffener	11	20 x 2,0	775 102 201	20	0,358	45	82	31 - 33
		11	25 x 2,3	775 102 202	10	0,468	51	86	31 - 33
		11*)	25 x 2,3*)	775 102 252*)	10*)	0,448*)	51*)	86*)	31 - 33*)
		11	32 x 3,0	775 102 203	10	0,549	59	93	31 - 33
		11	40 x 3,7	775 102 204	10	0,763	68	94	32 - 38
		11	50 x 4,6	775 102 205	5	1,068	75	103	35 - 43
		11	63 x 5,8	775 102 206	4	1,920	96	111	39 - 47

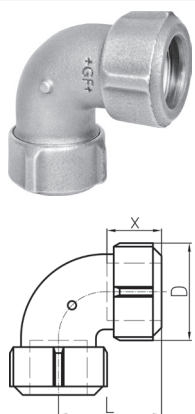
*) According to EN 1555-2

Primofit cap galvanised for PE/PE-Xa pipe

Item	Description	Values							
		SDR	Dimension PE [mm]	EPDM code	GP	Weight [kg]	D [mm]	L [mm]	x [mm]
	Including insert stiffener	11	20 x 2,0	775 452 201	30	0,200	45	46	31 - 33
		11	25 x 2,3	775 452 202	30	0,240	51	48	31 - 33
		11	25 x 3,0	775 452 442*)	30*)	0,240*)	59*)	48*)	31 - 33*)
		11	32 x 3,0	775 452 203	15	0,329	59	52	31 - 33*)
		11	40 x 3,7	775 452 204	10	0,492	68	53	32 - 38
		11	50 x 4,6	775 452 205	10	0,620	75	57	35 - 43
		11	63 x 5,8	775 452 206	5	1,140	96	60	39 - 47

*) According to EN 1555-2

Primofit elbow galvanised for PE/PE-Xa pipe

Item	Description	Values							
		SDR	Dimension PE [mm]	NBR code	GP	Weight [kg]	D [mm]	L [mm]	x [mm]
	Including insert stiffener	11	20 x 2,0	775 402 201	20	0,339	45	58	31 - 33
		11	25 x 2,3	775 402 202	10	0,508	51	59	31 - 33
		11*)	25 x 3,0*)	775 402 252*)	10*)	0,508*)	51*)	59*)	31 - 33*)
		11	32 x 3,0	775 402 203	10	0,664	59	59	31 - 33
		11	40 x 3,7	775 402 204	5	0,729	68	59	32 - 38
		11	50 x 4,6	775 402 205	5	1,068	75	78	35 - 43
		11	63 x 5,8	775 402 206	4	2,236	96	88	39 - 47

*) According to EN 1555-2

2.10 Primofit spare packs (sealing kits) for PE/PE-Xa pipe

!	Note
	Primofit compression fittings can be changed for other media, operating conditions and pipe types at all time by using optional spare sets (sealing kits).
	Primofit can be used again by replacing the sealing kit! Thus make a important contribution to sustainable environmental protection.

PRIMOFIT is a modular system and offers maximum application flexibility through the possibility of individual combinations of body geometries and spare packs (sealing kits), depending on the application. This eliminates the need for a significant amount of storage. For example, stocked NBR PRIMOFIT can be easily converted to a drinking water-approved EPDM gasket at any time, even on site. Just as PRIMOFIT for steel pipe can be converted for butt weld tubes or even for the use with PE and PE-Xa pipe.

Pipe specification

!	Note
	The scope of supply also includes stiffener(s). The operation of stiffeners is mandatory.
	For correct selection of the compression fitting, monitor the different wall thicknesses of the PE/PE-Xa pipes (SDR series). The wall thickness and pipe diameter are shown in the range table below.

PE EN 12201-2/Water				PE EN 1555-2/Gas		PE-Xa DIN 16892/93 and EN ISO 15875-2
SDR	7,4	11	17,6 (17)	11	17,6	11
S	3,2	5	8,3 (8)	5	8,3	5
OD [mm]	s [mm]	s [mm]	s [mm]	s [mm]	s [mm]	s [mm]
20	3,0	2,0	-	3,0	2,0	1,9
25	3,5	2,3	2,0 (2,0)	3,0	2,3	2,3
32	4,4	3,0	2,0 (2,0)	3,0	2,3	2,9
40	5,5	3,7	2,3 (2,4)	3,7	2,3	3,7
50	6,9	4,6	2,9 (3,0)	4,6	2,9	4,6
63	8,6	5,8	3,6 (3,8)	5,8	3,6	5,8

Application

!	Note
	For general information on jointing, use methods and pipe specifications, refer to the chapter "General information".

Obey international, European and national use-related requirements and the manufacturer's specification guidelines.

The maximum operating pressure is calculated by the pipe specification and local requirements.

Medium	Maximum operating pressure [bar]	Maximum operating temperature [°C]	Colour code ¹⁾	Gasket	Surface/ material Primofit
Fuel gases (including H ₂) ²⁾	10 ³⁾	40	● Yellow	NBR	Black and galvanised
System water	16	40			
Drinking water (cold < 25 °C)	16	25	● Blue	EPDM	Galvanised
Drinking water (heated > 25 °C)	16	40			Stainless steel ⁴⁾

- 1) The colour code on the packaging gives the indication for a gasket material.
- 2) Natural gas (NPG), Liquefied Petroleum Gas (LPG) and Hydrogen (H) with a maximum hydrogen content of 20% by volume. **In some countries Steel-PE connections in general are not permitted for gas installations in buildings, please check your local regulations!**
- 3) 10 bar for PE100 or 8 bar for PE-Xa or 5 bar for a connection with thread.
- 4) For new installations. For repairs and extensions of galvanised piping, the galvanised version can be used.

System components

Following fittings are available:

Primofit spare packs + insert stiffeners for PE/PE-Xa pipe

Item	Description	Values							
		SDR	Dimension PE [mm]	NBR code	EPDM code	GP	Weight [kg]	Stiffener material	Colour
	-	11	20 x 2,0	775 958 201	775 959 201	25	0,035	Plastic (POM)	White
	-	11	25 x 2,3	775 958 202	775 959 202	25	0,050	Plastic (POM)	White
	-	11*)	25 x 3,0*)	775 958 202*)	-	25*)	0,053*)	Plastic (POM)*)	White*)
	-	11	32 x 3,0	775 958 203	775 959 203	25	0,062	Plastic (POM)	White
	-	11	40 x 3,7	775 958 204	775 959 204	25	0,110	Plastic (POM)	White
	-	11	50 x 4,6	775 958 205	775 959 205	20	0,140	Plastic (POM)	White
	-	11	63 x 5,8	775 958 206	775 959 205	10	0,170	Plastic (POM)	White

*) According to EN 1555-2

Primofit spare packs for PE/PE-Xa all SDR/S (without insert stiffeners)

Item	Description	Values			
		Dimension PE [mm]	NBR code	GP	Weight [kg]
	-	20	775 958 961	50	0,020
	-	25	775 958 962	50	0,030
	-	32	775 958 963	50	0,040
	-	40	775 958 964	50	0,050
	-	50	775 958 965	50	0,050
	-	63	775 958 966	50	0,060

Primofit insert stiffeners for PE/PE-Xa pipe

Item	Description	Values						
		SDR	Dimension PE [mm]	Code	GP	Weight [kg]	Stiffener material	Colour marking
	-	7,4	20 x 3,0	775 950 701	50	0,020	Steel, galvanised	Red
		7,4	25 x 3,5	775 950 702	50	0,050	Steel, galvanised	Red
		7,4	32 x 4,4	775 950 703	50	0,050	Steel, galvanised	Red
		7,4	40 x 5,5	775 950 704	25	0,120	Steel, galvanised	Red
		7,4	50 x 6,9	775 950 705	25	0,099	Steel, galvanised	Red
		7,4	63 x 8,6	775 950 706	15	0,180	Steel, galvanised	Red
		11	20 x 2,0	775 950 201	50	0,020	Plastic (POM)	White
		11	25 x 2,3	775 950 202	50	0,016	Plastic (POM)	White
		11*)	25 x 3,0*)	780 881 125*)	40*)	0,020*)	Plastic (POM)*)	Yellow*)
		11	32 x 3,0	775 950 203	50	0,018	Plastic (POM)	White
		11	40 x 3,7	775 950 204	25	0,070	Plastic (POM)	White
		11	50 x 4,6	775 950 205	25	0,107	Plastic (POM)	White
		11	63 x 5,8	775 950 206	15	0,209	Plastic (POM)	White
		17,6*)	25 x 2,3*)	780 888 925*)	30*)	0,040*)	Plastic (POM)*)	White*)
		17,6*)	32 x 2,3*)	780 925 551*)	30*)	0,053*)	Plastic (POM)*)	Yellow*)
		17,6	40 x 2,3	775 950 354	25	0,044	Plastic (POM)	Green
		17,6	50 x 2,9	775 950 255	25	0,061	Plastic (POM)	Green
		17,6	63 x 3,6	775 950 256	14	0,094	Plastic (POM)	Green

*) According to EN 1555-2

2.11 Primofit galvanised for lead pipe

The Primofit is a compression fitting with full end-load resistance. Each connection has a maximum angular deviation of 3 ° between the pipe and the compression fitting.

This compression fitting is in accordance with EN 10344. It connects pressure-bearing guide pipes with specified outer diameters. For more information, refer to the following chapter "Pipe specification (lead pipe)".

- Body and nut:** white malleable cast iron **EN-GJMW-400-5** as per EN 1562.
- Gasket material:** refer to the following chapter "Application".
- Corrosion protection by hot dip galvanising:** as per EN 10344.

Application

Pipe specification (lead pipe)

Dimension [inch]	OD [mm]
1/2	18,3 - 21,9
3/4	23,9 - 27,4
1	27,3 - 30,9
1	30,9 - 34,4
1 1/4	36,5 - 37,6
1 1/4	39,6 - 43,1
1 1/2	45,8 - 46,9
1 1/2	47,5 - 50,7
2	53,1 - 55,5
2	56,5 - 57,5
2	60,4 - 63,8

Material



Note

For general information on jointing, use methods and pipe specifications, refer to the chapter "General information".



Note

In compliance with the Directive EU 2020/2184 ("Quality of water intended for human consumption"), installed lead pipes must be removed from the drinking water installations. Primofit compression fittings are used exclusively for repairs or extension (transitions to other systems) of installed lead pipes and let temporary operation until the final removal of the lead pipe installation.

Compliance with installation instructions is mandatory. For more information, refer to the chapter "Jointing of lead pipes".

When the pipe is installed underground (the compression joint is exposed directly to soil, sand, etc.), the installer must apply more corrosion protection methods (e.g. tape).

Obey international, European and national use-related requirements and the manufacturer's specification guidelines.

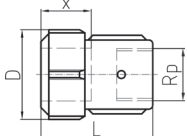
Medium	Maximum operating pressure [bar]	Maximum operating temperature [°C]	Colour code ¹⁾	Gasket
Drinking water (cold < 25 °C)	10	25	● Blue	EPDM

- 1) The colour coding on the packaging indicates the gasket material.

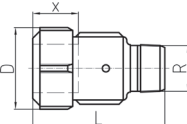
System components

Following fittings are available:

Primofit female adaptor galvanised for lead pipe

Item	Description	Values							
		Dimension Pb [mm]	Dimension Rp [inch]	EPDM code	GP	Weight [kg]	D [mm]	L [mm]	x [mm]
 	Internal thread Rp according to EN 10226-1 Dimension Pb shows the range of the outside diameter of the lead pipe	23,9 - 27,4	3/4	775 212 802	10	0,332	51	62	31 - 33
		27,3 - 30,9	1	775 212 813	10	0,440	59	68	31 - 33
		30,9 - 34,4	1	775 212 803	10	0,382	59	68	31 - 33
		36,5 - 37,6	1 1/4	775 212 814	5	0,671	68	70	32 - 38
		45,8 - 46,9	1 1/2	775 212 815	5	0,776	75	75	35 - 43
		53,1 - 55,4	2	775 212 816	5	0,900	96	83	36 - 42
		56,5 - 57,5	2	775 212 817	5	0,900	96	83	36 - 42

Primofit male adaptor galvanised for lead pipe

Item	Description	Values							
		Dimension Pb [mm]	Dimension R [inch]	EPDM code	GP	Weight [kg]	D [mm]	L [mm]	x [mm]
 	External thread R according to EN 10226-1 Dimension Pb shows the range of the outside diameter of the lead pipe.	18,3 - 21,9	1/2	775 202 801	25	0,246	45	73	31 - 33
		23,9 - 27,4	3/4	775 202 802	10	0,300	51	79	31 - 33
		27,3 - 30,9	1	775 202 813	10	0,440	59	89	31 - 33
		30,9 - 34,4	1	775 202 803	10	0,420	59	89	31 - 33
		36,5 - 37,6	1 1/4	775 202 814	5	0,671	68	92	32 - 38
		39,6 - 43,1	1 1/4	775 202 804	5	0,671	68	92	32 - 38
		45,8 - 46,9	1 1/2	775 202 815	5	0,776	75	96	35 - 43
		47,5 - 50,7	1 1/2	775 202 805	5	0,776	75	96	35 - 43
		53,1 - 55,4	2	775 202 816	5	0,900	96	106	36 - 42
		56,5 - 57,5	2	775 202 817	5	0,900	96	106	36 - 42

Primofit spare packs for lead pipe

Item	Description	Values				
		Dimension Pb [mm]	Dimension St [inch]	NBR code	GP	Weight [kg]
	Dimension Pb shows the range of the outside diameter of the lead pipe. Dimension St refers to the fitting sizes, which need to be combined with the spare packs.	18,3 - 21,9	1/2	775 958 841	50	0,020
		23,9 - 27,4	3/4	775 958 842	50	0,020
		27,3 - 30,9	1	775 958 813	50	0,040
		30,9 - 34,4	1	775 958 843	50	0,020
		36,5 - 37,6	1 1/4	775 958 814	50	0,035
		39,6 - 43,1	1 1/4	775 958 844	50	0,040
		45,8 - 46,9	1 1/2	775 958 815	50	0,034
		47,5 - 50,7	1 1/2	775 958 845	50	0,060
		53,1 - 55,4	2	775 958 816	25	0,107
		56,5 - 57,5	2	775 958 817	25	0,142
		60,4 - 63,8	2	775 958 846	50	0,060

2.12 Primofit repair systems

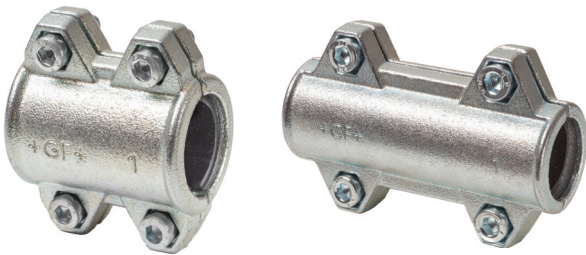
Primofit repair and tapping clamps

Used for temporary sealing of local damage of pipes. Made of proven, highest quality white malleable cast iron EN-GJMW-400-5 from GF with drinking water approved EPDM gasket.

Features

- Fast assembly - gaskets and nuts are attached in the half-shells. No more steps are necessary. The gasket does not move out of position. The nuts stay in position.
- Installation is possible in tight spaces - hold the clamp in position with one hand and put in and tighten the bolts with the other hand. No counter-holding of the nuts is necessary.
- Hexagon socket screws advantages - in tight installation spaces, a slim hexagon socket wrench is useful. You can also use a cordless screwdriver.
- Correct alignment - the half-shells interlock with serrations. The screw always engages in the same nut.
- Multiple operation - screws, nuts and gasket can be replaced.
- Reliable sealing - the new GF construction gives good force transmission to the sealing surfaces.

Repair clamps



Application: for temporary sealing of local damage to pipes caused by pores or small longitudinal fissures (other applications on request).

Pipe material: for steel pipes in accordance with EN 10255 and EN 10220-S1 with measurements in accordance with ISO 65 (other pipes on request).

Media: Drinking water, system water and compressed air.

Maximum operating pressure: 16 bar.

Maximum operating temperature: EPDM 95 °C.

Other pipe materials and media are available on inquiry.

Tapping clamps



Application: for extension and modification of installed pipe systems (other applications on request).

Pipe material: for steel pipes in accordance with EN 10255 and EN 10220-S1 with measurements in accordance with ISO 65 (other pipes on request).

Media: Drinking water, system water and compressed air.

Maximum operating pressure: 16 bar

Maximum operating temperature: EPDM 95 °C.

Other pipe materials and media are available on inquiry.

Primofit brass repair clamp



Application: for temporary repair of pipes with leakage caused by pores or small longitudinal fissures (other applications on request).

Pipe material: for copper pipes in accordance with EN 1057 and for stainless steel tubes with outer diameters equal to those of the copper tube (other pipes on request).

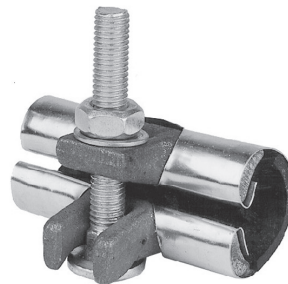
Media: Drinking water and system water.

Maximum operating pressure: 10 bar.

Maximum operating temperature: EPDM 95 °C.

Other pipe materials and media are available on inquiry.

Primofit snap clamp



Application: for temporary repair of pipes with leakage caused by pores or small longitudinal fissures (other applications on request).

Pipe material: for pipes made out of steel, copper, grey cast iron or ductile iron (other pipes on request).

Media: water and compressed air.

Maximum operating pressure: diameter 21 to 111 mm 16 bar, diameter 112 to 117 mm 10 bar.

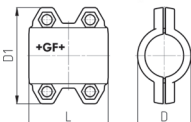
Maximum operating temperature: NBR 80 °C.

Other pipe materials and media are available on inquiry.

System components

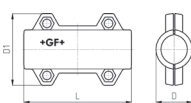
Following fittings are available:

Primofit repair clamp short galvanised for steel pipe

Item	Description	Values							
		Dimension St [inch]	d*) [mm]	EPDM code	GP	Weight [kg]	L [mm]	D [mm]	D1 [mm]
	-	1/2	21,3	775 722 051	20	0,159	70	38	72
		3/4	26,9	775 722 052	20	0,177	70	44	77
		1	33,7	775 722 053	20	0,200	70	51	84
		1 1/4	42,4	775 722 054	16	0,264	80	61	93
		1 1/2	48,3	775 722 055	11	0,367	100	67	101
		2	60,3	775 722 056	8	0,472	100	80	115
									

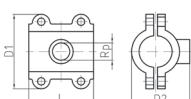
* Suitable for pipe outer diameter d

Primofit repair clamp long galvanised for steel pipe

Item	Description	Values							
		Dimension St [inch]	d*) [mm]	EPDM code	GP	Weight [kg]	L [mm]	D [mm]	D1 [mm]
	-	½	21,3	775 712 051	17	0,340	140	38	80
		¾	26,9	775 712 052	13	0,373	140	44	85
		1	33,7	775 712 053	11	0,417	140	51	92
		1¼	42,4	775 712 054	9	0,488	140	61	101
		1½	48,3	775 712 055	5	0,542	140	67	107
		2	60,3	775 712 056	5	0,684	140	80	120
		2½	76,1	775 712 057	4	2,180	140	105	138
		3	88,9	775 712 058	2	2,760	160	117	152
		4	114,3	775 712 059	1	3.320	160	144	176
									

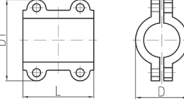
* Suitable for pipe outer diameter d

Primofit tapping clamp galvanised for steel pipe

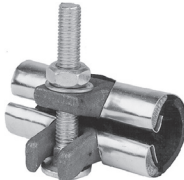
Item	Description	Values								
		Dimension St [inch]	d*) [mm]	Dimension Rp [inch]	EPDM code	GP	Weight [kg]	L [mm]	D [mm]	D1 [mm]
	Internal thread Rp according to EN 10226-1	1/2	21,3	1/2	775 732 051	25	0,423	70	67	43
		3/4	26,9	3/4	775 732 061	30	0,440	70	73	49
		1	33,7	1	775 732 062	23	0,489	70	80	57
		1 1/4	42,4	1 1/4	775 732 065	14	0,639	80	94	68
		1 1/2	48,3	1 1/2	775 732 068	10	0,865	100	99	73
		2	60,3	2	775 732 073	8	1,042	100	114	89
										

* Suitable for pipe outer diameter d

Primofit brass repair clamp

Item	Description	Values						
		DN [mm]	EPDM code	GP	Weight [kg]	L [mm]	D [mm]	D1 [mm]
 	-	10	775 723 050	100	0,080	45	18	31
		12	775 723 051	40	0,080	45	20	32
		15	775 723 052	50	0,120	50	22	42
		18	775 723 053	35	0,160	50	26	45
		22	775 723 054	50	0,200	60	31	50
		28	775 723 055	30	0,300	70	39	57
		35	775 723 056	20	0,400	70	45	69
		42	775 723 057	20	0,540	80	55	78
		54	775 723 058	10	0,900	100	65	92

Primofit snap clamp

Item	Description	Values						
		DN [inch]	Diameter range [mm]	Length [mm]	PN [bar]	NBR code	GP	Weight [kg]
	-	1/2	21 - 25	75	16	724 856 400	10	0,260
		3/4	26 - 30	75	16	724 856 401	10	0,260
		1	33 - 37	75	16	724 856 402	10	0,300
		1 1/4	42 - 45	75	16	724 856 403	5	0,320
		1 1/2	48 - 51	75	16	724 856 404	10	0,320
		1 1/2	50 - 54	75	16	724 856 405	10	0,340
		2	60 - 64	75	16	724 856 406	5	0,360
		2	69 - 73	75	16	724 856 407	5	0,460
		2 1/2	71 - 76	75	16	724 856 408	5	0,500
		2 1/2	74 - 80	75	16	724 856 438	5	0,500
		3	87 - 93	75	16	724 856 409	5	0,500
		3	105 - 111	75	16	724 856 412	5	0,520
		4	112 - 117	75	10	724 856 413	5	0,520

3 General information

3.1 Material

The body and coupling nut of the Primofit compression fittings are made in accordance with EN 10284 and EN 10344. The material used is white malleable iron **EN-GJMW-400-5** in accordance with EN 1562. The material designation is A.

Material symbol	Material grade in accordance with EN 1562 approved in accordance with EN 10284/EN 10344
A	EN-GJMW-400-5 EN-GJMB-350-10

Primofit compression fittings are available in black or hot-dip galvanised version. A preservation fluid gives more protection against flash rust. The hot-dip galvanised version is in accordance with EN 10284 and EN 10344 or DIN 50930-6 and with the Requirements for Metallic Materials in the current version published by the UBA (German Environment Agency). Primofit compression fittings made of 316 stainless steel (V4A) different from these standards. This version is also in accordance with the Requirements for Metallic Materials published by the German UBA.

Gasket material

Gasket materials NBR, EPDM, NBR + graphite (Firejoint) and FKM are available to cover a wide range of operations. To distinguish the materials, NBR gaskets are black and FKM gaskets are green. EPDM gaskets are also black, but have a blue dot for identification from NBR gaskets. The EPDM gasket is in accordance with the German UBA Elastomer Guideline and is approved for drinking water operation.

Each Primofit compression joint is supplied in a PE bag together with assembly instructions and an integrated insertion depth gauge. The colour code of the packaging shows the gasket material.

Gasket materials	Colour coding
NBR	Yellow
EPDM	Blue
FKM	Green
NBR + graphite (Firejoint)	Red

3.2 Application

Use of Primofit compression fittings under ground

If Primofit compression fittings are installed underground, the installer must apply permanent protection against external corrosion. The corrosion protection must be in accordance with EN 12068 ("Cathodic protection – external organic coatings for corrosion protection of buried or immersed steel pipelines used with cathodic protection – tapes and shrinkable materials") and with national standards and usually accepted rules or guidelines. The specifications of the responsible water or gas network operator or engineering office are mandatory.

Corrosion protection material must be in accordance with the standards given above.

Use of Primofit compression fittings in masonry (flush mounted)

If Primofit compression fittings are installed in masonry, the installer must apply permanent protection against corrosion. The corrosion protection must be in accordance with national standards and usually accepted rules or pipe installation guidelines. The specifications of the responsible water or gas network operator or engineering office are mandatory.

Reuse of Primofit compression fittings

When reusing Primofit compression fittings, replace the gasket, washer and locking ring. Spare sets (sealing kits) are available as individual items.

If there is no mechanical damage, wear or corrosion on the body and nut, these components can be used again.

3.3 Installation video

Please watch our installation video to see the use of Primofit compression joints first hand. In addition to various product requirements, the assembly process is also explained.

Moreover, different application examples can also be viewed.

Installation video

Find the video at: <https://www.fittings.at>



3.4 Limits of use

Primofit is a compression fitting with full end-load resistance. Each connection has a maximum angular deviation of 3 ° between the pipe and the compression fitting. The modular construction of the Primofit, the replacement of the sealing kits (locking ring, washer and seal) by spare sets can also be used by the customer to change to other types of pipe.

For use of the Primofit compression fitting in the intended areas, consultation of international, European and national requirements (for example standards, directives and rules of local utilities) is mandatory.

Select the correct gasket material (NBR, EPDM, FKM or NBR + graphite) and the fitting material or surface finish (black or hot dip galvanised) in accordance with the "Limits of Use" table. This selection is essential for correct material use. For more information, refer to the chapter "Limits of Use".

3.5 Pressure equipment directive 2014/68/EU

Primofit compression fittings are not pressure equipment in the sense of the Pressure Equipment Directive. They are not intended for CE identify in connection with this EU directive. Primofit compression fittings are pressure equipment components in accordance with EN 10284 or EN 10344 and the Pressure Equipment Directive – in the operating limits specified in EN 10284 and EN 10344. The material is in accordance with the requirement of the PED by compliance with the requirements of EN 1562.

Primofit must only be used for media for which the material malleable cast iron, surface finish and the selected gasket material. If necessary, GF will gladly give test report 2.2, together with a manufacturer's declaration.

4 Planning/design

4.1 Jointing technology for steel pipes

This range of compression fittings in accordance with EN 10344. Use these fittings to connect black steel pipes or hot-dip galvanized steel pipes in accordance with EN 10255, EN 10220-S1 and ISO 65 (nominal outer diameter). Spare sets (sealing kits) are available for some dimensions of welded steel tubes for pressure purposes in accordance with EN 10220 Series 2 and Series 3.

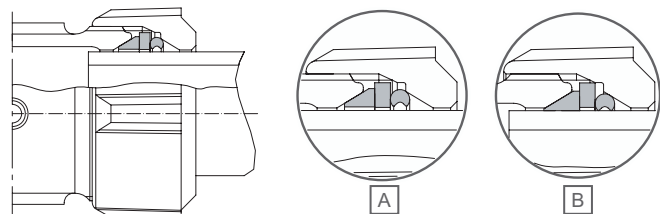
The Primofit compression fitting is ready for installation and is preassembled. The internal diameters of the seal, washer and locking ring are larger than the maximum permitted outer diameter of the pipe. This condition lets you insert the pipe without disassembly.

Tightening the nut has two functions:

- First, the seal presses against the jointing faces of the tapered seal chamber and the pipe surface.
- Subsequently, the locking function of the locking ring in order to make sure push and pull out resistance of the compression fitting.

Other than using a nut when tightening a pipe joint, the compression fitting 4 inch uses screws on a flange system to get the same effect. The principle of sealing and clamping shown here is the same as for smaller dimensions.

Connection for steel pipe

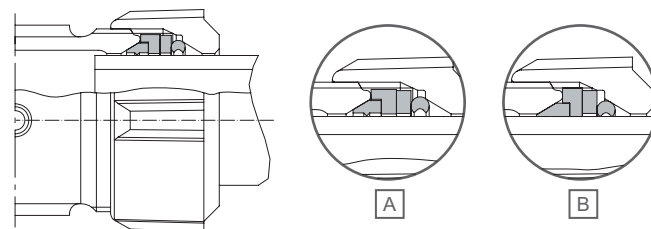


Item	Description
A	Loose connection
B	Tightened connection

4.2 Firejoint-jointing for steel pipes (fire resistant version)

The Primofit firejoint compression joint is the fire-resistant version, which is mandatory for gas pipes installed in buildings in accordance with DVGW. This compression fitting connects black or hot dip galvanized steel pipes in accordance with EN 10255 and EN 10220-S1 and ISO 65 (nominal outside diameter). The yellow passivated coupling nut makes it easy to recognise the Primofit firejoint. The pipe connection is the same as for steel pipes, except for its different sealing kit (with additional graphite ring). This compression joint is for gas installations and is in accordance with the requirements for increased fire resistance, as specified by standardised test methods. A additional graphite ring keeps the end load resistance and tight seal during a fire. For sealing purposes in usual operation, an NBR gasket is embedded in the graphite ring.

Connection for steel pipe (fire resistant version)



Item	Description
A	Loose connection
B	Tightened connection

4.3 Jointing of Primofit compression fittings stainless steel for steel pipe



Note

The principle of the connection corresponds to that of the steel pipe connection. For more information, refer to the chapter "Jointing technology for steel pipes"

The development of the Primofit stainless steel version follows the proven advantages of the Primofit compression fittings made of malleable cast iron. Primofit stainless steel compression fittings are also preassembled and supplied for installation, no disassembly is necessary before assembly. Minimal pipe end machining is necessary. Primofit tightness and high tensile strength of the connection are kept.

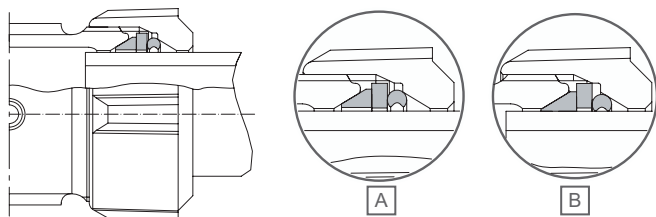
The Primofit stainless steel fitting has low assembly cost and special tools are not necessary. Each connection has a maximum angular deviation of 3 ° between the pipe and the compression fitting. 316/ V4A stainless steel is in contact with the fluid and is in accordance with the UBA positive list (Germany). The EPDM gasket has DVGW certification for drinking water. This combination is for cold (< 25 °C) and hot (> 25 °C) drinking water. It is an alternative to galvanised and brass compression fittings for corrosive water conditions.

In the ready-to-install, preassembled condition of the Primofit compression fitting, the internal diameters of the gasket, washer and locking ring are larger than the largest specified outer diameter of the pipe. This guarantees that the pipe can be pushed in without disassembly. Tightening the coupling nut has two functions:

- First, the gasket presses against the jointing faces of the tapered seal chamber and the pipe surface.
- Subsequently, the locking function of the locking ring in order to make sure pull out resistance of the compression fitting.

Other than using a nut when tightening a pipe joint, the compression fitting 4 inch uses screws on a flange system to get the same effect. The principle of sealing and clamping shown here is the same as for smaller dimensions.

Connection for steel pipe



Item	Description
A	Loose connection
B	Tightened connection

4.4 Jointing of PE and PE-Xa pipes



Note

Each PE/PE-Xa connection includes a stiffener. The stiffener is mandatory.



Note

Primofit stainless steel compression fittings can connect PE, PE-Xa and lead pipes. Use the correct sealing kit for these pipe types. For more information, refer to the chapter "Primofit Stainless Steel for Steel and PE/PE-Xa Pipe".

Transition fittings connect the specified steel pipes to PE/PE-Xa pipes. Joints for PE/PE-Xa to PE/PE-Xa pipes are also available. These compression fittings comply with EN 10284. They are suitable for PE pipes in accordance with EN 12201-2 (water) and EN 1555-2 (gas) and cross-linked polyethylene pipes PE-Xa in accordance with DIN 16892/93 and EN ISO 15875-2.

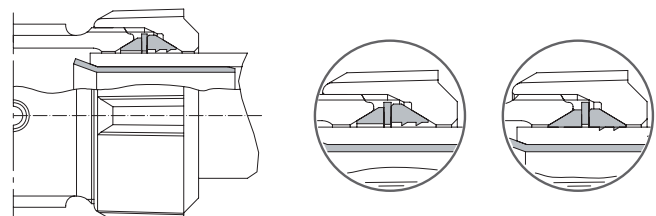
The permitted pipe materials are PE 80 (PE-MD), PE 100 (PE-HD) and PE-Xa.

When using a stiffener with the Primofit PE/PE-Xa connection, the wall thicknesses (SDR series) specified in the assortment section of the catalogue in "Dimension PE" must be taken into account when selecting the compression joint.

The principle of the jointing method is the same as that of the steel pipe connection. In contrast, a stiffener with the same internal diameter as the pipe is necessary. This stiffener increases the resistance of the PE/PE-Xa pipe against radial forces.

Gasket, washer and locking ring are selected for the pipe material and pipe diameter. Check the special shape of the locking ring for PE/PE-Xa pipes. The joint has small rigidity and tolerates a $\pm 3^\circ$ angular deviation of the pipe when tightened.

Connection for PE- and PE-Xa-pipe



Item	Description
A	Loose connection
B	Tightened connection

4.5 Jointing of lead pipes



Note

In compliance with the directive EU 2020/2184 "Quality of water intended for human consumption", installed lead pipes must be removed from the drinking water installations. Primofit compression fittings are used exclusively for repairs or extensions (changes to other systems) of installed lead pipes and are for temporary operation until the removal of the lead pipe installation.



Note

Gasket, washer and locking ring are selected for the pipe material and diameter.

The shape of the locking ring for lead pipes require special attention.

Lead pipes can have different consistencies as per the installation conditions. Follow the instructions below when installing Primofit compression fittings on lead pipes:

- The surface of the lead pipe must not be damaged and dirt in the insertion area must be removed.
- The outer diameter of the lead pipe must be in the tolerances identified on the packaging label. This diameter can also be found in the dimension chart for lead pipes
- The out-of-roundness of the lead pipe must not be more than 1 mm. This value is the difference between the minimum and maximum outer diameter.
- The insertion depth of the lead pipe and the number of revolutions necessary to tighten the coupling nut can be found in the assembly instructions. For lead pipes, the values of the related PE pipe dimensions must be used. Example: Lead pipe 30 mm, use the values for PE 32 mm: Insertion depth 32 mm $\pm$ 1 mm.
- After installation, do a pressure test in accordance with national guidelines and check for possible leaks. The test pressure must be at minimum 1.5 time the nominal pressure ($1.5 \times PN$) or minimum 10 bar. Use the higher value.

4.6 Jointing threads

The Primofit range includes fittings, for example adaptors with internal threads (female adaptors), adaptors with external threads (male adaptors), Tees and elbows with jointing threads.

Jointing threads are pipe threads where pressure-tight joints are made on the threads in accordance with EN 10226-1 or ISO 7-1. The current national edition of EN 10226 replaces DIN 2999, BS 21 and other national standards.

When using jointing threads in accordance with EN 10226-1, the internal thread designated with the letters Rp is cylindrical. The external thread designated with the letter R is tapered.

Design and function of jointing threads (sealing inside the thread)

Standard EN 10226-1 (ISO 7-1) specifies the thread profile, dimensions, tolerances and designations for each thread dimension. The primary dimensions of these jointing threads and the weight and data of medium-duty and heavy-duty threaded pipes, are given in the chapter "Pipe Threads - Dimensions". The thread profile and its primary features are given in the chapter "Thread Profile".

Tapered external thread

When using tapered external thread (refer to the chapter "Tapered external thread R"). Consider the specified data. The thread has a taper ratio of 1:16 (refer to the chapter "Taper of an External Thread").

The pipe thread length has three sections (refer to the chapter "Taper of an External Thread"):

- The **gauge length** a is specified and the tolerance is applied. The smallest internal thread diameter makes easy mating. The external thread can be turned in easily and the small quantity of sealant goes into the connection.
- The **fitting allowance** b is the threaded part that sets the sealing effect. The threaded length, with fully cut thread roots behind the gauge plane, is selected to give sufficient contact length when a tool is used. The thread has a cone ratio of 1:16. The pressure between the threads gives a permanent tight seal.
- The **washout thread**, which is not fully cut at the root, must stay in view. If the thread is engaged too far, the internal thread can leak or crack on the side of the fitting (or on the valve). To prevent a leak path between the peaks of the male thread and the root of the internal thread in the assembled joint, the thread crests on the male thread must be fully cut over the full useful thread length.

Parallel internal thread

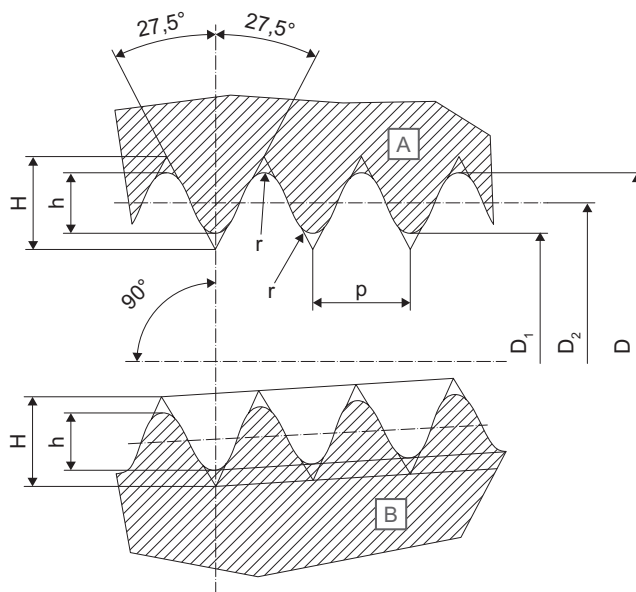
When using the parallel internal thread (refer to the chapter "Parallel Internal Thread Rp"), make sure that the useful thread length gives full mating of the external thread until the sealing effect occurs. This also applies to the largest specified gauge length of the external thread.

The different steps of a threaded connection that is tightened manually and subsequently tightened with a tool are shown in the chapter "Thread Connection - Item A".

- For a manually threaded connection (refer to the chapter "Thread Connection - Item A"), $2\frac{3}{4}$ threads are available. These threads make it possible to use a tool for tightening of the thread (refer to the chapter "Pipe Threads - Dimensions").
- A threaded connection tightened in accordance with the standard is shown in the chapter "Thread Connection - Item B".

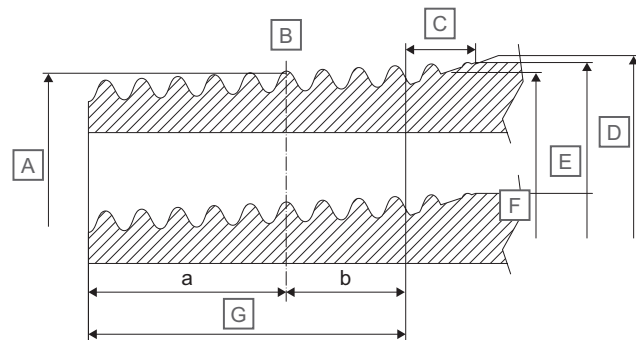
To adjust the outlet direction of the fitting or the length of the assembled pipeline, screw the thread in slightly more or slightly less. The connection remains tight.

Thread profile



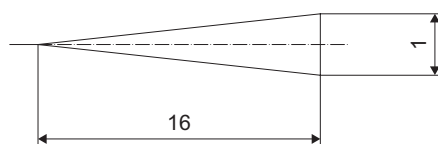
Item	Description
A	Internal thread
B	External thread
p	Pitch
H	$0,960491 \cdot p$
h	$0,640327 \cdot p$
r	$0,137329 \cdot p$
D	Major diameter
D ₁	Minor diameter
D ₂	Pitch diameter

Tapered external thread R



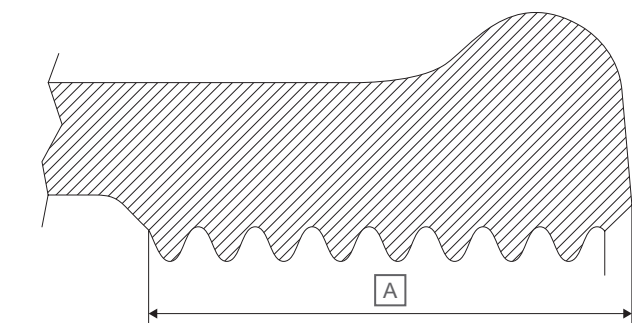
Item	Description
A	Thread diameter
B	Gauge plane
C	Washout thread
D	Pipe diameter maximum
E	Pipe diameter nominal
F	Pipe diameter minimum
G	Useful threads length
a	(Gauge length) $\pm$ tolerance
b	Fitting allowance

Tapered external thread



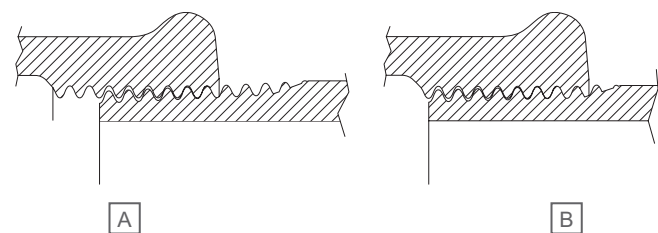
The thread profile is perpendicular to the pipe's axis.

Parallel internal thread Rp



Item	Description
A	Useful threads length

Thread connection



Item	Description
A	Tightened manually
B	Tightened with a tool

Sealing effect and sealant

Note

Ensuring the sealing effect:

To make sure that the sealing effect of the cylindrical/tapered connection occurs, follow these instructions is mandatory:

- Set the thread cutting tool. The fitting must turn onto the unsealed thread by hand. There must be sufficient remaining threads for tightening with a correct tool. This gives the necessary sealing pressure for the largest specified internal thread diameter.
- Do not turn the end of the useful external thread (length a + b, refer to chapter "Tapered External Thread R") more with a tool than the first fully cut thread of the internal thread (refer to the chapter "Thread Connection"). If the thread is turned too far, the sealing pressure can decrease because of the thread root of the washout that is not fully cut.

The sealing effect in the thread occurs because the internal and external threads (flank diameter) touch each other at run-up and are compressed when a tool is used.

Consequently, in a cylindrical/tapered connection, the only task of a sealant is to fill in unavoidable deviations from the theoretical profile of the threads and roughnesses of the threaded surfaces. Use only small quantity of sealant, applicable for its purpose must be used.

Tensile load, compression or bending force of the connection are absorbed by the metal-to metal contact.

The most important dimensions of the pipe thread in accordance with EN 10226-1 (ISO 7-1)

Pipe threads - dimensions

DN	10	15	20	25	32	40	50	65	80	100
Primofit dimension [inch]	$\frac{3}{8}$	$\frac{1}{2}$	$\frac{3}{4}$	1	$1\frac{1}{4}$	$1\frac{1}{2}$	2	$2\frac{1}{2}$	3	4
Pipe threads										
Gauge diameter (thread major diameter in the gauge plane) [mm]	16,662	20,955	26,441	33,249	41,910	47,803	59,614	75,184	87,884	113,030
Pitch [mm]	1,337	1,814	1,814	2,309	2,309	2,309	2,309	2,309	2,309	2,309
Number of threads per inch [25,4 mm]	19	14	14	11	11	11	11	11	11	11
Gauge length "a" of the tapered external thread [mm]	6,4	8,2	9,5	10,4	12,7	12,7	15,9	17,5	20,6	25,4
Tolerance for "a" [mm]	± 1,3	± 1,8	± 1,8	± 2,3	± 2,3	± 2,3	± 2,3	± 3,5	± 3,5	± 3,5
Fitting allowance "b" [mm]	3,7	5,0	5,0	6,4	6,4	6,4	7,5	9,2	9,2	10,4
Number of threads [inch]	$2\frac{3}{4}$	$2\frac{3}{4}$	$2\frac{3}{4}$	$2\frac{3}{4}$	$2\frac{3}{4}$	$2\frac{3}{4}$	$3\frac{1}{4}$	4	4	$4\frac{1}{2}$
Medium thread engagement length [mm]	10,0	13,0	15,0	17,0	19,0	19,0	24,0	27,0	30,0	36,0

5 Installation

5.1 Installation process

Each Primofit compression fitting comes with its own assembly instruction.

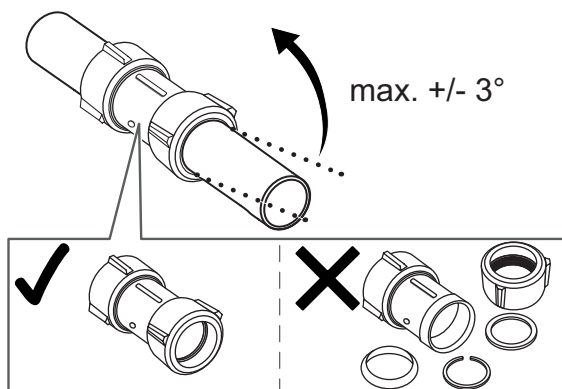
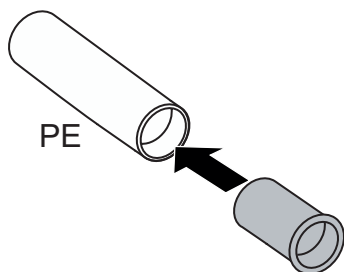
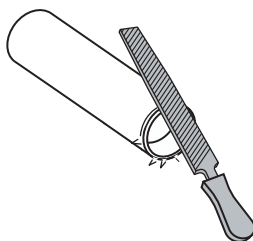
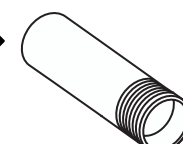
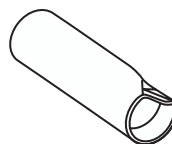
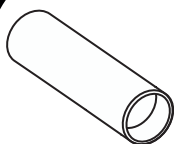
For Primofit 4" flange version, firejoint, lead and welded steel tubes for pressure purposes, individual assembly instructions are supplied with the material.

Installation video

Steel



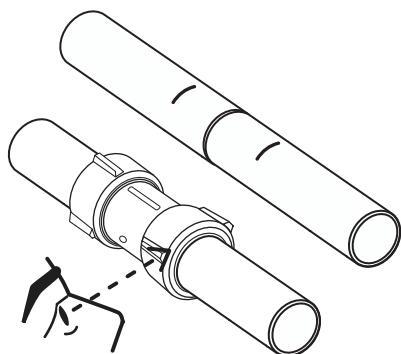
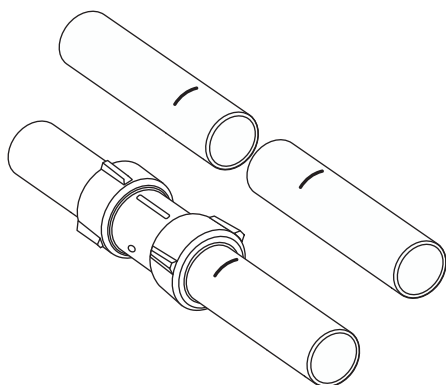
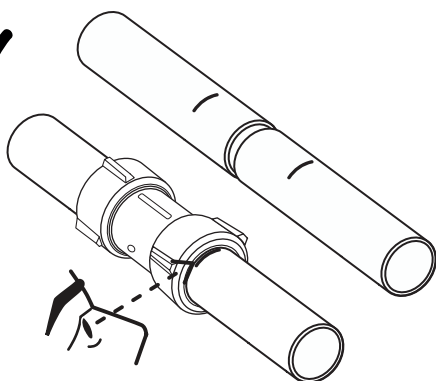
PE/PE-Xa



1. Mark the insertion depth



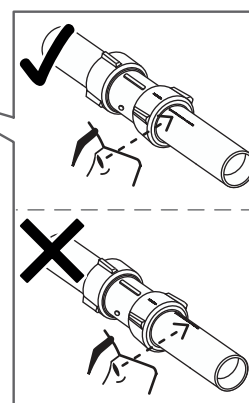
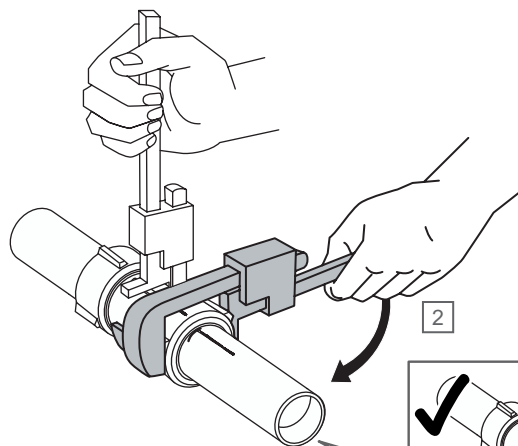
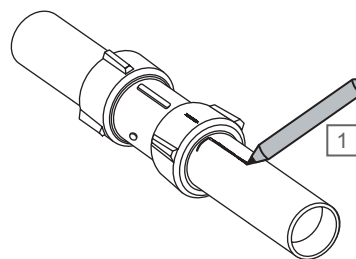
2. Pipe alignment



3. Pipe tightening by hand



4. Pipe tightening with tool



	 360°		Ø
	Steel	1 x	⅜, ½, ¾ inch
		2 x	1, 1¼, 1½, 2, 2½ inch
		1¾ x	3 inch
PE/ PE-Xa	1½ x	20 mm	
	2½ x	25, 32, 40 mm	
	2¾ x	50, 63 mm	

6 Technical data

6.1 Pipe specification

The pipes to be used must comply with the tables below

Relation of compression fitting dimension and outer pipe diameter (for equal compression fittings) and smallest internal diameter

DN	10	15	20	25	32	40	50	65	80	100
Primofit dimension [inch]	$\frac{3}{8}$	$\frac{1}{2}$	$\frac{3}{4}$	1	$1\frac{1}{4}$	$1\frac{1}{2}$	2	$2\frac{1}{2}$	3	4
Steel pipe [mm]	17,2	21,3	26,9	33,7	42,4	48,3	60,1	76,1	88,9	114,3
Tolerance range [mm]	16,7 - 17,5	21,0 - 21,8	26,5 - 27,3	33,3 - 34,2	42,0 - 42,9	47,9 - 48,8	59,7 - 60,8	75,3 - 76,6	88,0 - 89,5	113,1 - 115,0
Welded steel tubes for pressure purposes ¹⁾²⁾ [mm]	-	20,0 ± 0,5	25,0 ± 0,5	31,8 ± 0,5	38,0 ± 0,5	44,5 ± 0,5	51,0 ± 0,5 57,0 ± 0,5 63,5 ± 0,6	70,0 ± 0,7	-	-
PE-u, PE-Xa pipe [mm]	-	20	25	32	40	50	63	-	-	-
Tolerance range [mm]		20,0 - 20,3	25,0 - 25,3	32,0 - 32,3	40,0 - 40,4	50,0 - 50,4	63,0 - 63,4	-	-	-
Lead pipe [mm]	-	18,3 - 21,9	23,9 - 27,4	27,3 - 30,9 30,9 - 34,4	36,5 - 37,6 39,6 - 43,1	45,8 - 46,9 47,5 - 50,7	53,1 - 55,4 56,5 - 57,5 60,4 - 63,8	-	-	-
Minimum internal diameter ³⁾ [mm]	7,9	11,6	16,6	22,7	30,9	36,3	46,8	61,5	72,2	95,3
Thread size [inch]	$\frac{3}{8}$	$\frac{1}{2}$	$\frac{3}{4}$	1	$1\frac{1}{4}$	$1\frac{1}{2}$	2	$2\frac{1}{2}$	3	4

- 1) Only available as a spare set (sealing kit); if using spare sets (sealing kits) for welded steel tubes for pressure purposes, measuring 63,5 mm, a special compression joint body is necessary, that is to say, the latter cannot be mixed with standard compression joints of dimension 2!
- 2) Including ± tolerance
- 3) It is equal to the smallest internal diameter of the change piece with external thread. For all other compression fitting types, the smallest internal diameter is the inner diameter of the pipe.

Steel pipes: threaded pipes in accordance with EN 10255 (formerly DIN 2440, DIN 2441), welded steel tubes for pressure purpose in accordance with EN 10220 series 1 (formerly DIN 2448/2458 series 1)



Note

Limiting deviations of the out of roundness margins are included in the diameter limits. By contrast, maximum out of roundness shape of 0,5 mm apply to Firejoint

DN		10	15	20	25	32	40	50	65	80	100
Primofit dimension [inch]		$\frac{3}{8}$	$\frac{1}{2}$	$\frac{3}{4}$	1	1 $\frac{1}{4}$	1 $\frac{1}{2}$	2	2 $\frac{1}{2}$	3	4
Threaded pipes (EN 10255)	OD [mm]	17,2	21,3	26,9	33,7	42,4	48,3	60,3	76,1	88,9	114,3
	Surface of the smooth pipe [m ² /m]	0,054	0,067	0,085	0,106	0,133	0,152	0,189	0,239	0,279	0,359
Light-weight pipe type	Wall thickness [mm]	1,8	2,0	2,3	2,6	2,6	2,9	2,9	3,2	3,2	3,6
	Internal diameter [mm]	13,6	17,3	22,3	28,5	37,2	42,5	54,5	69,7	82,5	107,1
	Internal cross-section [cm ²]	1,45	2,35	3,91	6,38	10,87	14,19	23,33	38,16	53,46	90,09
	Volume [L/m]	0,145	0,235	0,391	0,638	1,087	1,419	2,333	3,816	5,346	9,009
	Pipe weight, of the smooth pipe, not galvanised [kg/m]	0,670	0,947	1,380	1,980	2,540	3,230	4,080	5,710	6,720	9,750
Medium heavy series	Wall thickness [mm]	2,3	2,6	2,6	3,2	3,2	3,2	3,6	3,6	4,0	4,5
	Internal diameter [mm]	12,6	16,1	21,7	27,3	36	41,9	53,1	68,9	80,9	105,3
	Internal cross-section [cm ²]	1,25	2,04	3,7	5,85	10,18	13,79	22,15	37,28	51,4	87,09
	Volume [L/m]	0,125	0,204	0,37	0,585	1,018	1,379	2,215	3,728	5,140	8,709
	Pipe weight, of the smooth pipe, not galvanised [kg/m]	0,839	1,210	1,560	2,410	3,100	3,560	5,030	6,420	8,360	12,200
Heavy duty series	Wall thickness [mm]	2,9	3,2	3,2	4,0	4,0	4,0	4,5	4,5	5,0	5,4
	Internal diameter [mm]	11,4	14,9	20,5	25,7	34,4	40,3	51,3	67,1	78,9	103,5
	Internal cross-section [cm ²]	1,02	1,74	3,3	5,19	9,29	12,76	20,67	35,36	48,89	84,13
	Volume [L/m]	0,102	0,174	0,330	0,519	0,929	1,276	2,067	3,536	4,889	8,413
	Pipe weight, of the smooth pipe, not galvanised [kg/m]	1,020	1,440	1,870	2,930	3,790	4,370	6,190	7,930	10,300	14,500
Welded steel tubes for pressure purposes EN 10220 series 1 ¹⁾	OD [mm]	17,2	21,3	26,9	33,7	42,4	48,3	60,3	76,1	88,9	114,3
	Wall thickness [mm]	1,8	2,0	2,3	2,6	2,6	2,6	2,9	2,9	3,2	3,6
	Internal diameter [mm]	13,6	17,3	22,3	28,5	37,2	43,1	54,5	70,3	82,5	107,1
	Internal cross-section [cm ²]	1,45	2,35	3,91	6,38	10,87	14,59	23,33	38,82	53,46	90,09
	Volume [L/m]	0,145	0,235	0,391	0,683	1,087	1,459	2,333	3,882	5,346	9,009
	Pipe weight, of the smooth pipe, not galvanised [kg/m]	0,684	0,952	1,4	1,99	2,55	2,93	4,11	5,24	6,76	9,83

- 1) Along with series 1, there are special spare sets (sealing kits) for the lower pipe diameters 20, 25, 31,8, 38, 44,5, 51, 57, 63,5 and 70 mm.

Maximum operating pressure of the PE/PE-Xa pipes

Pressure level [bar]	EN 12201-2		DIN 8047 ¹⁾		EN ISO 15875-2 ²⁾
Pipe specification	PE 80	PE 100	PE 80	PE 100	PE-Xa
SDR 7,4/S 3,2	20	25	16	25	-
SDR 11/S 5	12,5	16	10	16	12,5
SDR 17/S 8	8	10	6,2	10	-
SDR 17,6/S 8,3	-	-	6,0	9,6	-

1) SF = 1,6 , 50 years , TB = 20 °C

2) SF = 1,5 , 100 years , TB = 50 °C

Common PE/PE-Xa pipe series in accordance with EN 1555-2, EN 12201-2, DIN 8074 and EN ISO 15875-2

OD ¹⁾ [mm]		20	25	32	40	50	63
SDR 7,4/S 3,2 in accordance with EN 12201-2/ water	Wall thickness [mm]	3,0	3,5	4,4	5,5	6,9	8,6
	Internal diameter [mm]	14	18	23,2	29	36,2	45,8
	Internal cross-section [cm ²]	1,54	2,54	4,23	6,61	10,29	16,47
	Volume [L/m]	0,154	0,254	0,423	0,661	1,029	1,647
	Pipe weight [kg/m]	0,16	0,238	0,383	0,596	0,930	1,464
SDR 7,4/S 3,2 in accordance with DIN 8074	Wall thickness [mm]	2,8	3,5	4,4	5,5	6,9	8,6
	Internal diameter [mm]	14,4	18	23,2	29	36,2	45,8
	Internal cross-section [cm ²]	1,63	2,54	4,23	6,61	10,29	16,47
	Volume [L/m]	0,163	0,254	0,423	0,661	1,029	1,647
	Pipe weight [kg/m]	0,154	0,238	0,383	0,596	0,930	1,464
SDR 11/S 5 in accordance with EN 1555-2/Gas	Wall thickness [mm]	3,0	3,0	3,0	3,7	4,6	5,8
	Internal diameter [mm]	14	19	26	32,6	40,8	51,4
	Internal cross-section [cm ²]	1,54	2,84	5,31	8,35	13,07	20,75
	Volume [L/m]	0,154	0,284	0,531	0,835	1,307	2,075
	Pipe weight [kg/m]	0,160	0,208	0,275	0,425	0,660	1,043
SDR 11/S 5 in accordance with EN 12201-2/ water	Wall thickness [mm]	2,0	2,3	3,0	3,7	4,6	5,8
	Internal diameter [mm]	16	20,4	26	32,6	40,8	51,4
	Internal cross-section [cm ²]	2,01	3,27	5,31	8,35	13,07	20,75
	Volume [L/m]	0,201	0,327	0,531	0,835	1,307	2,075
	Pipe weight [kg/m]	0,115	0,168	0,275	0,425	0,660	1,043
SDR 11/S 5 in accordance with DIN 8074/EN ISO 15875-2	Wall thickness [mm]	1,9	2,3	2,9	3,7	4,6	5,8
	Internal diameter [mm]	16,2	20,4	26,2	32,6	40,8	51,4
	Internal cross-section [cm ²]	2,06	3,27	5,39	8,35	13,07	20,75
	Volume [L/m]	0,206	0,327	0,539	0,835	1,307	2,075
	Pipe weight [kg/m]	0,112	0,171	0,272	0,425	0,660	1,043

OD ¹⁾ [mm]		20	25	32	40	50	63
SDR 17/S 8 in accordance with EN 12201-2/ water	Wall thickness [mm]	-	-	2,0	2,4	3,0	3,8
	Internal diameter [mm]	-	-	28	35,2	44	55,4
	Internal cross-section [cm²]	-	-	6,16	9,73	15,21	24,11
	Volume [L/m]	-	-	0,616	0,973	1,521	2,411
	Pipe weight [kg/m]	-	-	0,192	0,29	0,447	0,713
SDR 17/S 8 in accordance with DIN 8074	Wall thickness [mm]	-	1,8	1,9	2,4	3,0	3,8
	Internal diameter [mm]	-	21,4	28,2	35,2	44	55,4
	Internal cross-section [cm²]	-	3,6	6,25	9,73	15,21	24,11
	Volume [L/m]	-	0,360	0,625	0,973	1,521	2,411
	Pipe weight [kg/m]	-	0,137	0,187	0,290	0,447	0,713
SDR 17,6/S 8,3 in accordance with EN 1555-2/ Gas	Wall thickness [mm]	2,3	2,3	2,3	2,3	2,9	3,6
	Internal diameter [mm]	15,4	20,4	27,4	35,4	44,2	55,8
	Internal cross-section [cm²]	1,86	3,27	5,9	9,84	15,34	24,45
	Volume [L/m]	0,186	0,327	0,590	0,984	1,534	2,445
	Pipe weight [kg/m]	0,131	0,168	0,220	0,280	0,434	0,680
SDR 17, 6/S 8,3 in accordance with EN 12201-2/ water	Wall thickness [mm]	-	-	2,0	2,3	2,9	3,6
	Internal diameter [mm]	-	-	28	35,4	44,2	55,8
	Internal cross-section [cm²]	-	-	6,16	9,84	15,34	24,45
	Volume [L/m]	-	-	0,616	0,984	1,534	2,445
	Pipe weight [kg/m]	-	-	0,192	0,28	0,434	0,68
SDR 17,6/S 8,3 in accordance with DIN 8074	Wall thickness [mm]	-	-	1,8	2,3	2,9	3,6
	Internal diameter [mm]	-	-	28,4	35,4	44,2	55,8
	Internal cross-section [cm²]	-	-	6,33	9,84	15,34	24,45
	Volume [L/m]	-	-	0,633	0,984	1,534	2,445
	Pipe weight [kg/m]	-	-	0,179	0,280	0,434	0,680

- 1) Permitted for nominal outer diameter for PE-Xa pipe 25 and 32 s = 2,0 mm if installed pipe installations < 0,1 bar.



Georg Fischer Fittings GmbH

Georg Fischer Fittings GmbH
Mariazeller Straße 75
3160 Traisen
Austria

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