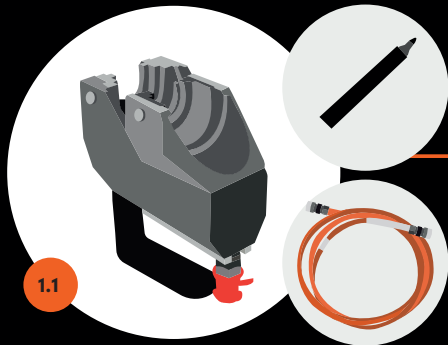


instruction card Lokring[®] MTK45



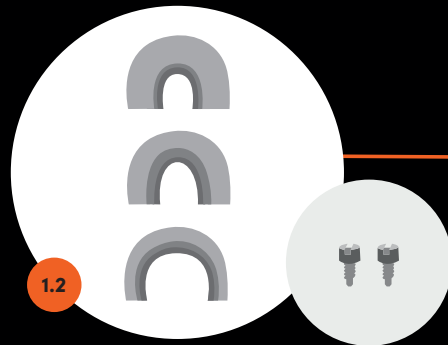
1. check that everything is in the case before starting assembly



1.1

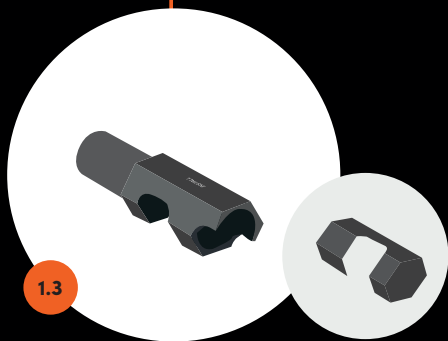
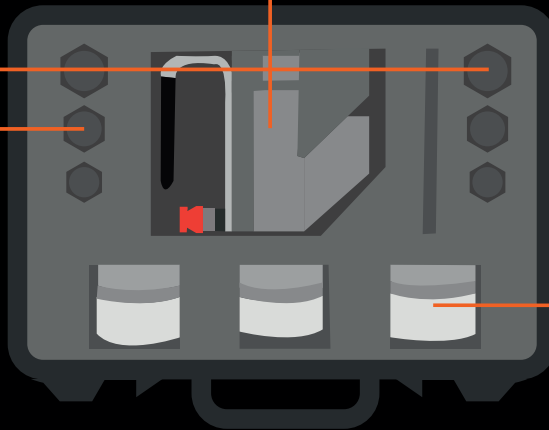
delivered as standard

- 1x foam-lined plastic case
- 1x IT-45 Lokring toolhead
- 1x hydraulic pump
- 1x hydraulic hose
- 1x marker pen
- 1x instruction card



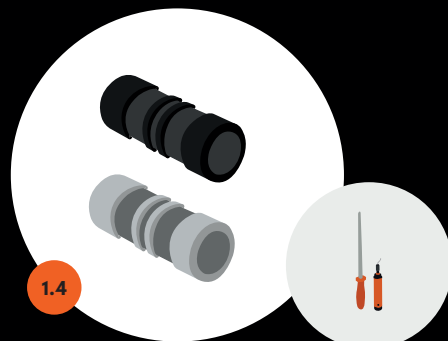
1.2

- 1x insert set for 1/2" fitting
- 1x insert set for 3/4" fitting
- 1x insertset for 1" fitting
- 2x insert retainer screws
- inserts for other materials available on request



1.3

- 1x 1/2" "GO-NOGO" gage for carbon steel fitting
- 1x 3/4" gage for carbon steel fitting
- 1x 1" gage for carbon steel fitting
- 1x 1/2" gage for Stainless Steel fitting
- 1x 3/4" gage for Stainless Steel fitting
- 1x 1" gage for Stainless Steel fitting
- gages for other materials available on request

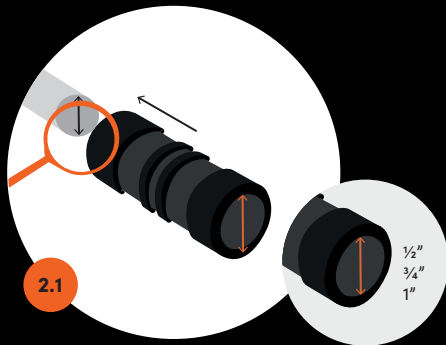


1.4

not delivered as standard

- 1x hacksaw
- 1x file or deburring tools
- 1x low grade sandpaper (80-120 grade)
- 1x high grade sandpaper (180-400 grade)

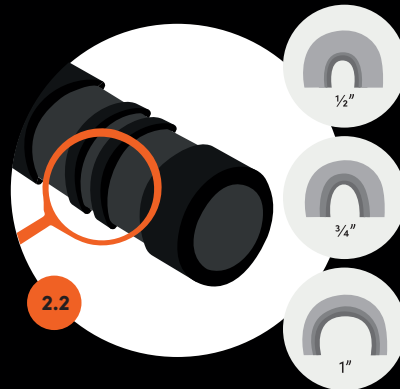
assembly stay out of the line of fire at all times



2.1

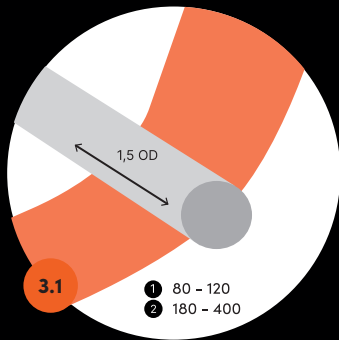
2. select the equipment you need

Check the pipe material (carbonsteel/stainless steel) and size (1/2"/3/4"/1")



2.2

Select the appropriate size insert set and gage

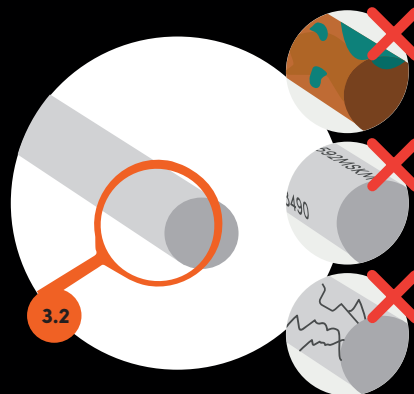


3.1

- 1 80 - 120
- 2 180 - 400

3. access the pipe

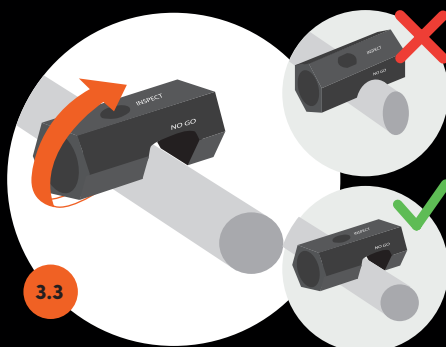
Sand the pipe, first grade 80-120 and then finely grade 180-400



3.2

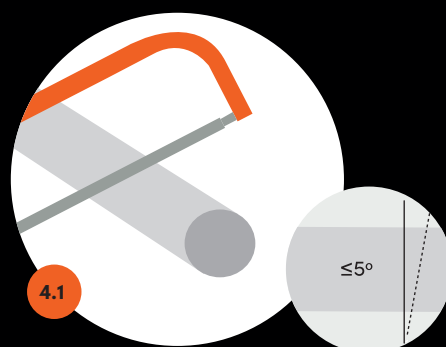
Make sure that the pipe meets the following criteria:

- no corrosion or pitting
- no lettering or engraving
- no lengthwise scratches or grooves



3.3

Check the external diameter of the pipe with the gage

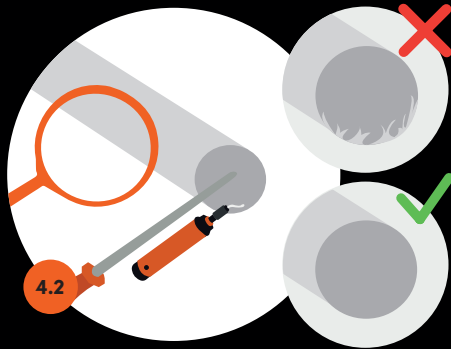


4.1

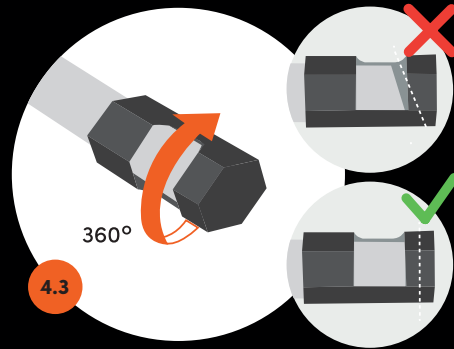
4. prepare the pipe

Cut the pipe square ($\le 5^\circ$)

assembly

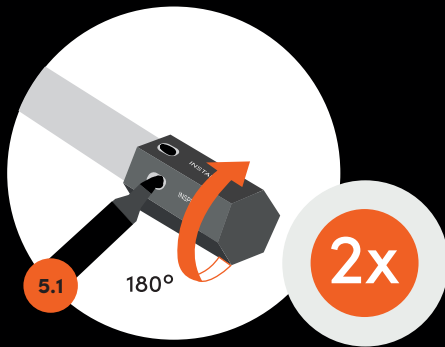


4.2 Deburr the end of the pipe



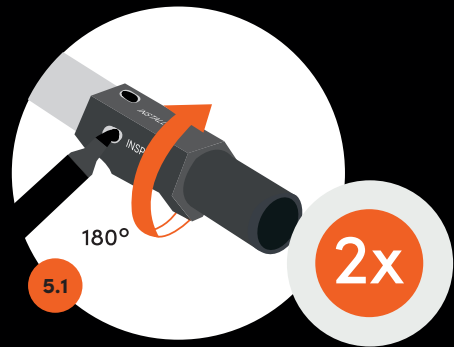
4.3 Check that the end of the pipe is cut straight, not skew

carbon steel

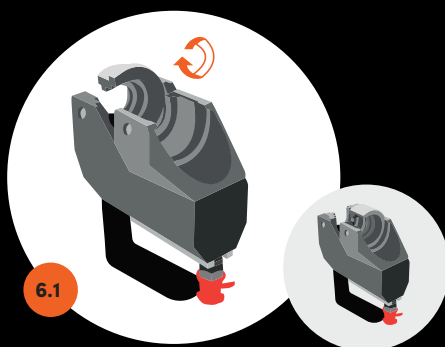


5. mark the pipe
Place the "inspect" and "install" mark on both sides of the pipe

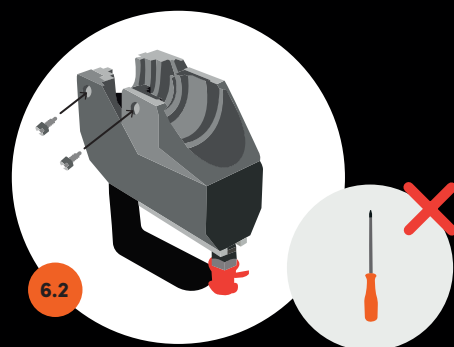
stainless steel



5. mark the pipe
Place the "inspect" and "install" mark on both sides of the pipe

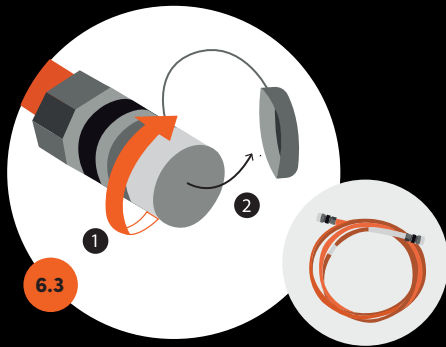


6. prepare the Lokring tool
Place the inserts in the Lokring toolhead

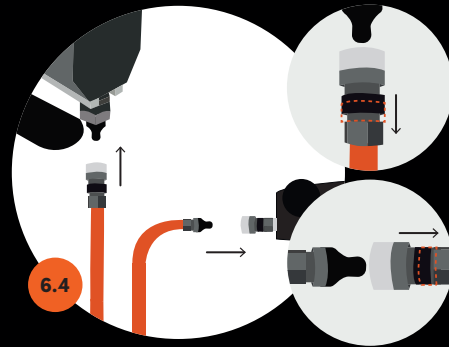


Tighten the retainer screws manually

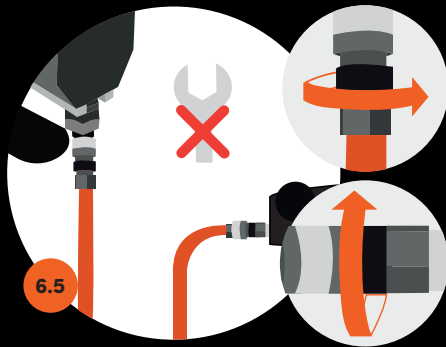
assembly



6.3 Twist and remove the protective caps of the hydraulic hose

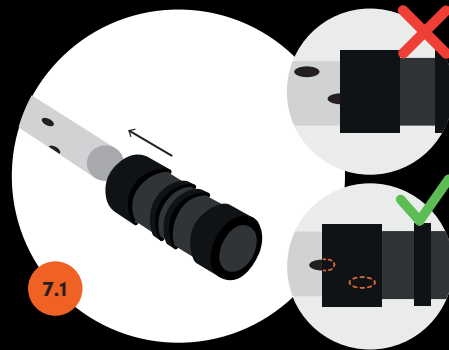


6.4 Connect the hydraulic hose to the pump and the Lokring tool



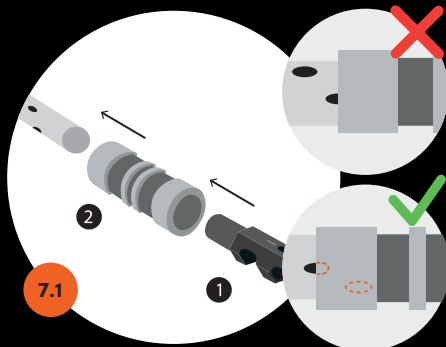
6.5 Tighten the retainer rings manually

carbon steel



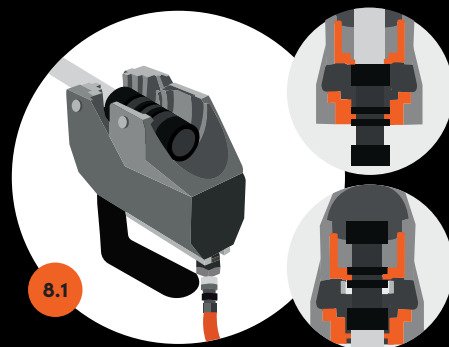
7. put the Lokring fitting in place
Slide the Lokring fitting over the pipe.
Check the "install" mark

stainless steel



7. put the Lokring fitting in place
Slide the Lokring fitting over the pipe.
Check the "install" mark

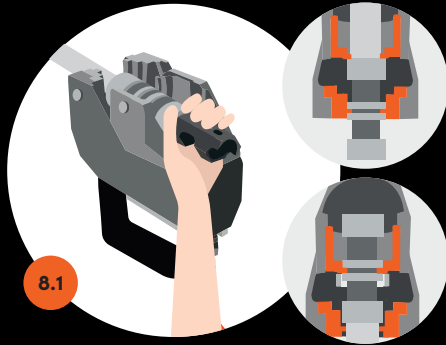
carbon steel



8. install the Lokring fitting
Place the Lokring tool over the Lokring fitting

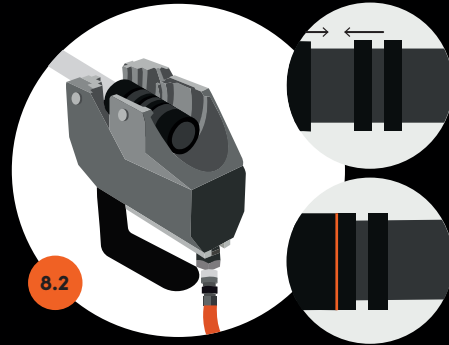
assembly

stainless steel



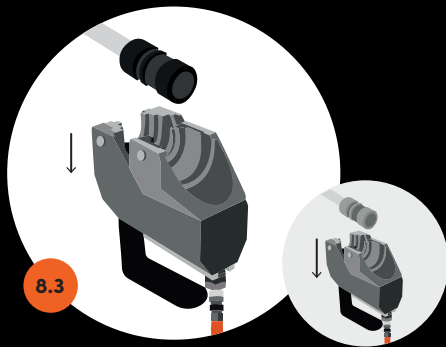
8. install the Lokring fitting

Place the Lokring tool over the Lokring fitting

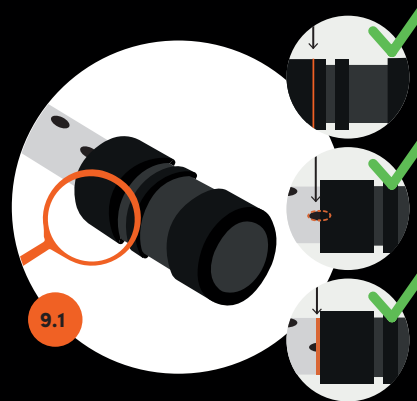


⚠ pay attention: stay out of the line of fire!

Pump until the driver of the Lokring fitting touches the body



Open the release valve on the pump and remove the Lokring tool

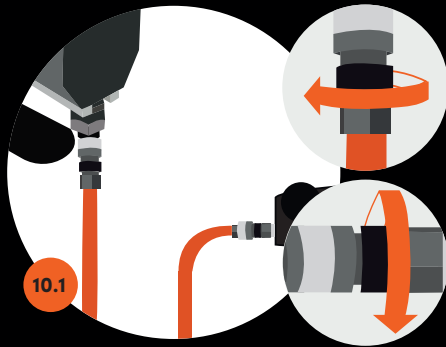


9. check the assembly

Check that the assembly has met the following criteria:

- the driver is completely up against the body of the fitting
- the Lokring fitting is at the "inspect" mark
- the end of the Lokring fitting's body protrudes from underneath the driver

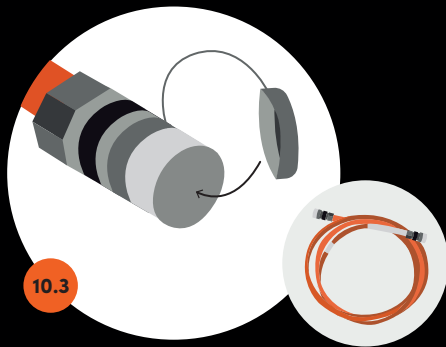
disassembly



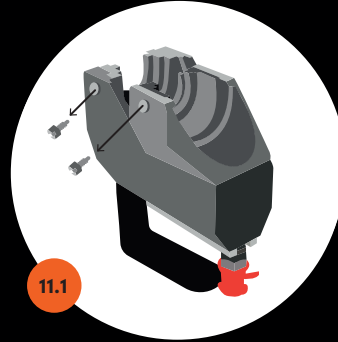
10. disconnect the hydraulic hose
Undo the lock nuts



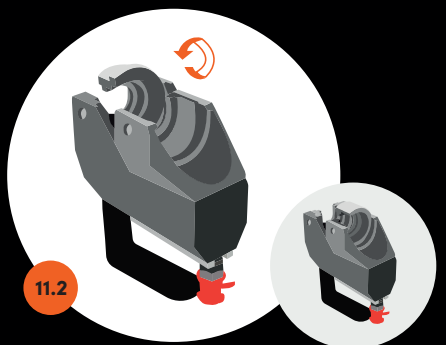
Disconnect the hydraulic hose from the Lokring tool and the Hydraulic pump



Press the protective caps firmly in place



11. dismantle the Lokring tool
Remove the retaining screws from the Lokring tool



Remove the insert from the Lokring tool



12. stow the Lokring tool back in the case
Clean the Lokring tool and put all the accessories back in the case