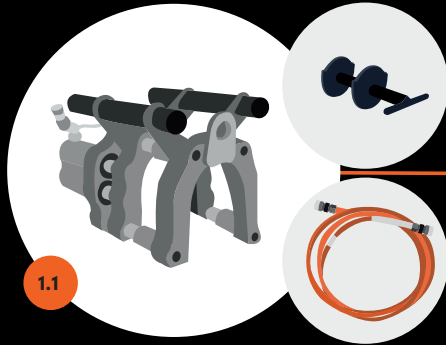


# instruction card Lokring® MTK400



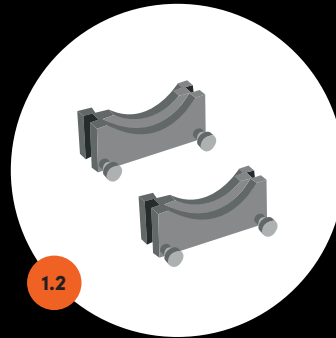
1. check that everything is in the case before starting assembly



1.1

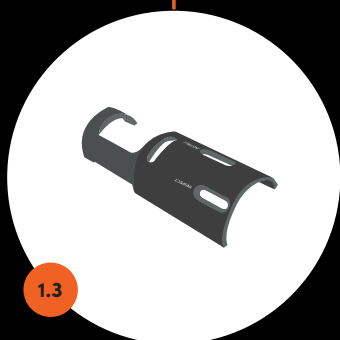
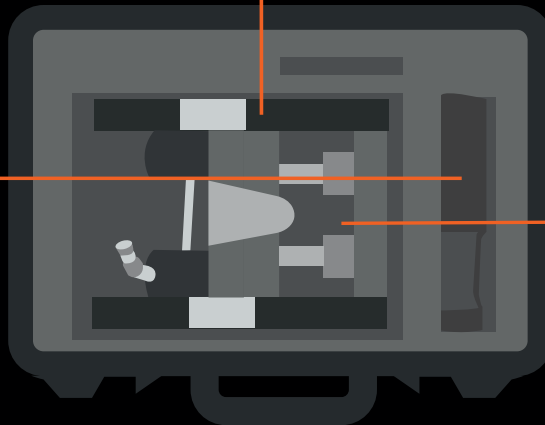
### delivered as standard

- 1x foam-lined plastic case
- 1x IT-400 Lokring toolhead
- 1x hydraulic pump
- 1x hydraulic hose
- 1x Jaw Retraction Tool (JRT)
- 1x marker pen
- 1x instruction card



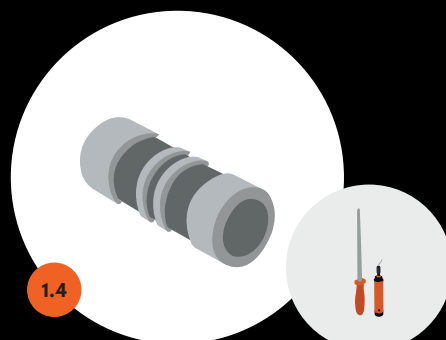
1.2

- 2x 4" insert blocks



1.3

- 1x 4" Multi purpose/GO-NOGO gage

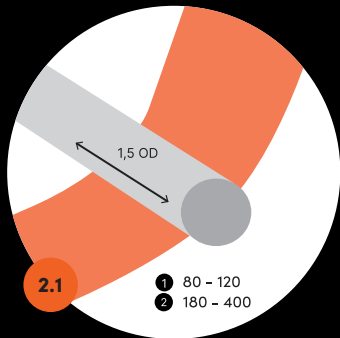


1.4

### not delivered as standard

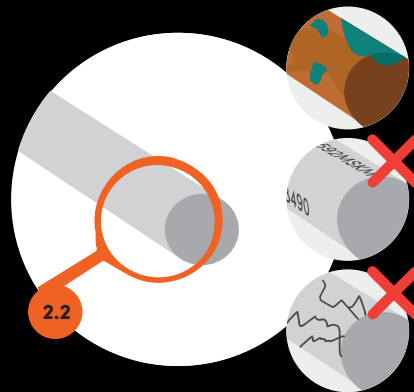
- 1x hacksaw
- 1x file or deburring tool
- 1x low grade sandpaper (80-120 grade)
- 1x high grade sandpaper (180-400 grade)

# assembly stay out of the line of fire at all times



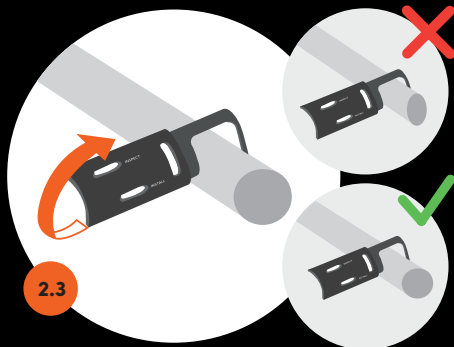
## 2. access the pipe

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

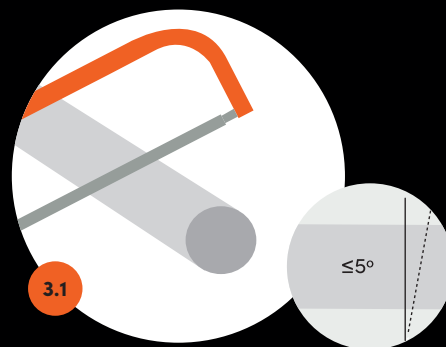


Make sure that the pipe meets the following criteria:

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

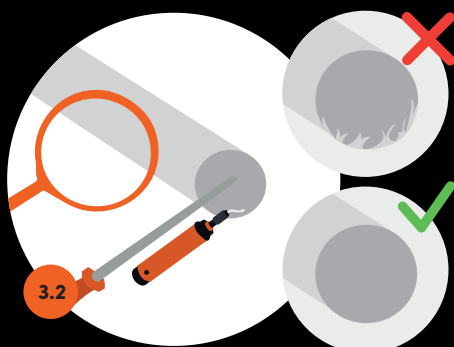


Check the external diameter of the pipe with the gage

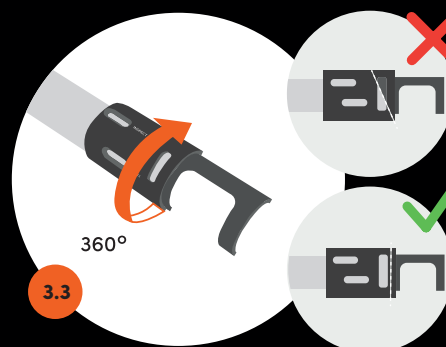


## 3. prepare the pipe

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

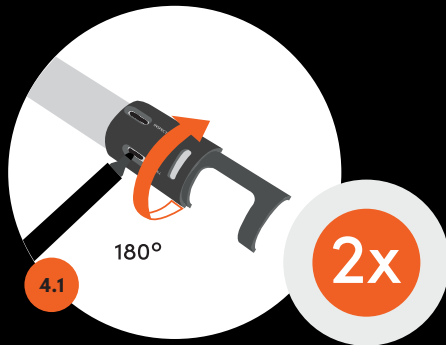


Deburr the end of the pipe

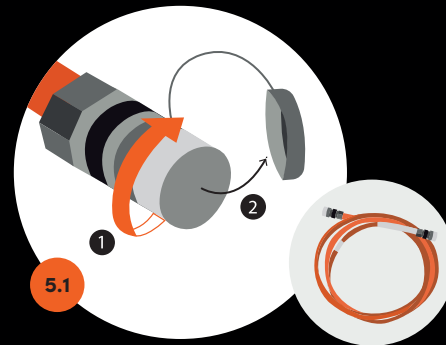


Check that the end of the pipe is cut straight, not skew

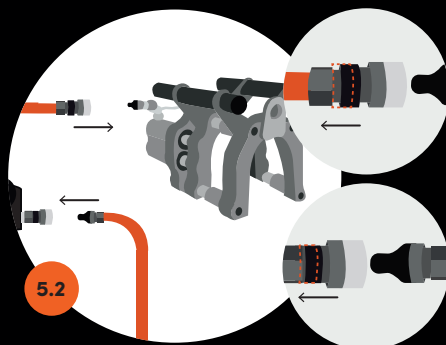
# assembly



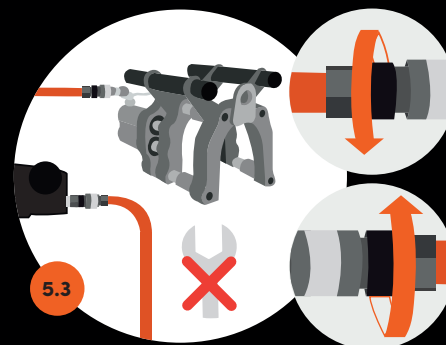
**4. mark the pipe**  
Mark the "inspect" and "install" surface on both sides of the pipe



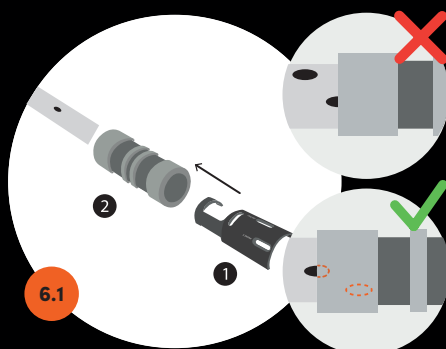
**5. prepare the Lokring tool**  
Twist and remove the protective caps of the hydraulic hose



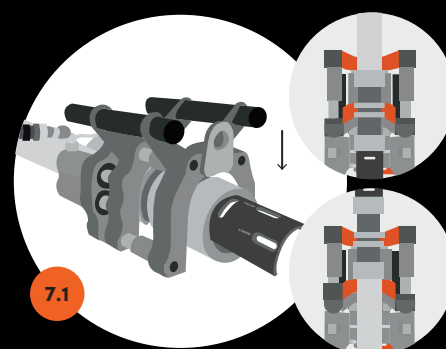
Connect the hydraulic hose to the pump and the Lokring tool



Tighten the retainer rings manually

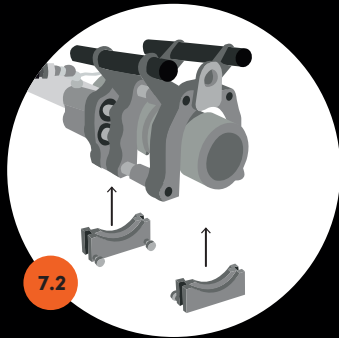


**6. put the Lokring fitting in place**  
Slide the Lokring fitting over the pipe. Check the "install" mark

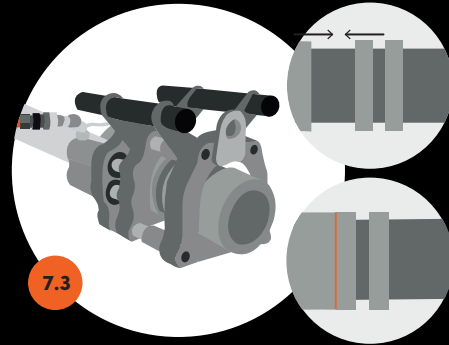


**7. install the Lokring fitting**  
Place the Lokring tool over the Lokring fitting

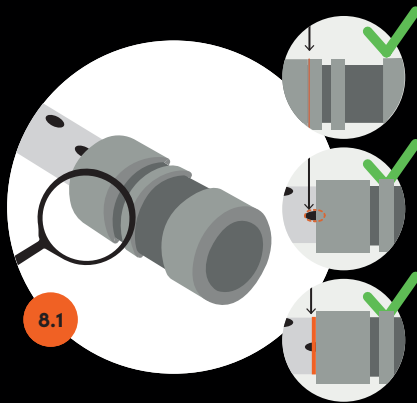
# assembly



7.2 Place the insert blocks in the Lokring tool and fix them in position



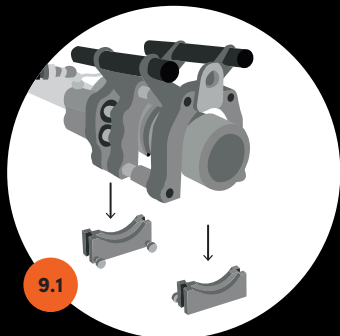
7.3 **⚠ pay attention: stay out of the line of fire!**  
Pump until the driver of the Lokring fitting touches the body



**8. check the assembly**  
Check that the assembly has met the following criteria:

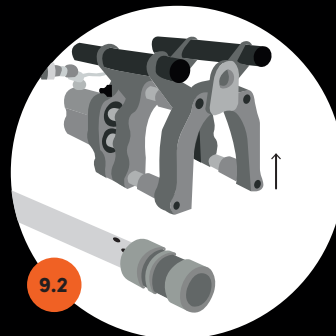
- the driver is completely up against the body of the fitting
- the Lokring fitting is at the "inspect" mark
- the end of the Lokring fitting's body protrude from underneath the driver

# disassembly

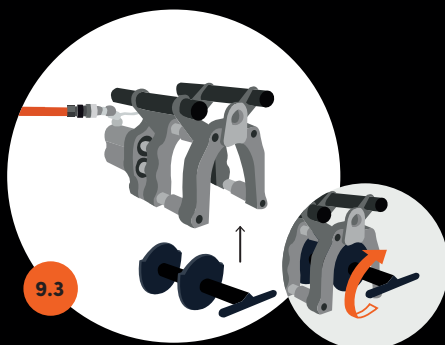


## 9. dismantle the Lokring tool

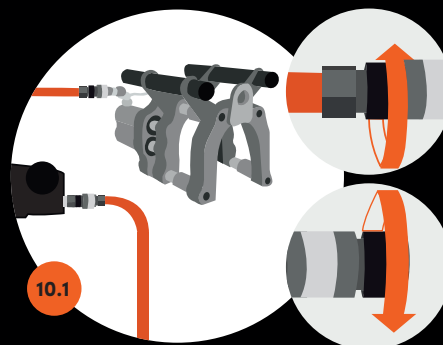
Release the pressure from the Lokring tool and remove it until the jaws have retracted to the original position. Remove the insert blocks



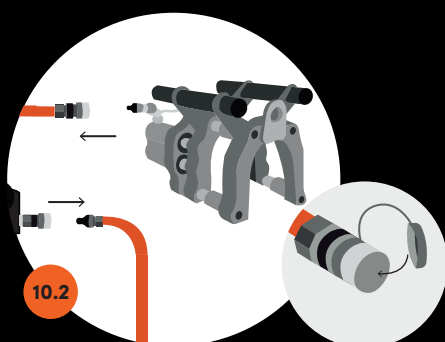
Remove the Lokring tool



Use the JRT if necessary to push the jaws back to the original position



10. disconnect the hydraulic hose  
Undo the retaining rings



Disconnect the hydraulic hose from the Lokring tool and the hydraulic pump. Press the protective caps firmly in place



11. stow the Lokring tool back in the case

Clean the Lokring tool if necessary and stow all the parts back in the case