

## Brazing Copper End Feed Applications: 66.7mm - 159mm

# Installation Instructions

### General

Conex Bänninger Series 5000 (Delbraze) copper fittings should be professionally installed by an appropriately trained and qualified installer. All installations **must** be completed in line with local regulations and by-laws governing the installation, and all applicable health and safety practices must be adhered to.

### Tube compatibility & standards

- To suit copper tube to **EN 1057**.
- Meets standards: **EN 1254-1 & 4**, **EN 1254-5**.
- Threads meet: **ISO 7-1 & EN 10226-1**.

### Joint information

- When brazed correctly to copper tubes, Series 5000 (Delbraze) capillary fittings form a mechanically strong leak-proof joint.
- Fittings are manufactured from copper, DZR brass and gunmetal, makes them resistant or immune to dezincification.
- Fittings are designed for brazing applications only and are **not suitable** to be jointed using the soft soldering technique. Low Temperature brazing which takes place within the temperature range of 600°C to 850°C, normally using filler metals based on silver and copper.
- Fitting sizes 66.7mm - 159mm.

**Do not** force tube ends together prior to making joints. Joints should only be made on an unstressed pipework assembly.

### Further technical information

Please visit - [www.conexbanninger.com](http://www.conexbanninger.com) or email - [technical@ibpgroup.com](mailto:technical@ibpgroup.com), for further information.

### Applications

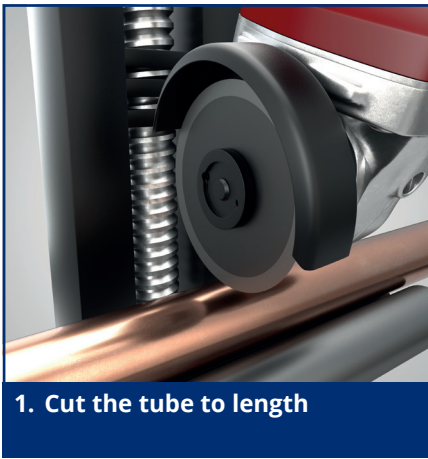
- Drinking water
- Hot and cold water services
- Solar
- Natural and LPG gas
- Waste
- Refrigeration and air-conditioning
- Compressed air with and without oil content
- Vacuum
- Rainwater

### Tube preparation

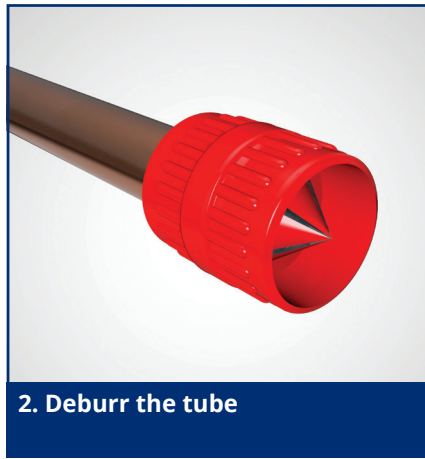
**Note:** Avoid hand held grinding wheels, fast cutting saws and hacksaws, as these are **not suitable** for cutting tube ends square. If tube ends do become distorted, remove the damaged section, using an appropriate cutting method.

**Safety Note: Working with an exposed flame can be potentially dangerous, ensure that all appropriate health and safety regulations and requirements are met when using this product.**

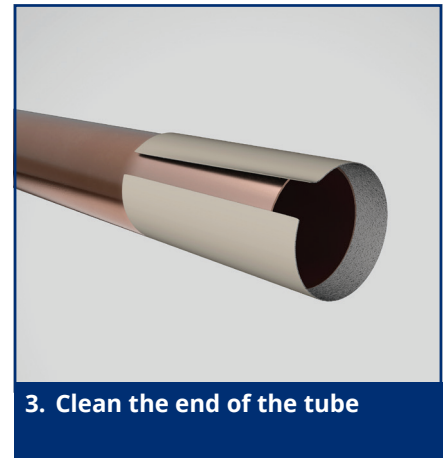
Leave the fittings in the packaging prior to installation, to protect them from contamination.



- Cut the tube to the required length ensuring it has retained its shape.



- Deburr the tube internally and externally.



- Clean the end of the tube, ensuring that it is round and undamaged.



- Mark the correct insertion depth on the tube.



- Insert the tube fully into the socket to ensure joint integrity.



- Apply heat, moving the flame to ensure that parent metals and fitting are evenly heated.



- Touch a brazing rod, strip or wire to the joint mouth and melt in the flame.



- Once brazed, discontinue heating. During cooling, **do not** move or twist the components.



- Flux residue **must** be removed so the joint can be properly inspected, and tested.

The content of this publication is for general information only. It is the user's responsibility to determine suitability of any product, product data and specifications, for the purpose intended and reference should be made to our Technical Department if clarification is required – [technical@ibpgroup.com](mailto:technical@ibpgroup.com). All products must be installed in accordance with our installation instructions. In the interests of technical development we reserve the right to change specification, design and materials without notice.

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