

General notes on laying and screwing the pressure hoses with ½" BSP 60° screw fittings

- The pressure hoses with part no. 1037100228 and 1037100230 differ only in the adapter to the cooler (G ¾" and M22x1.5) and are recommended to be laid as shown in drawing 1037700700. Alternatively, the pressure hoses can also be laid differently. In any case, the following installation instructions must be observed/followed:
- The pressure hoses should be installed as stress-free as possible, i.e. taking into account the minimum bending radius of 51 mm and, if possible, without tensile, compressive or torsional stresses, because these shorten the service life.
- When screwing the BSP G 1/2" 60° fitting (tightening torque: 102 Nm, lightly lubricated), make sure that the hose does not rotate to avoid torsional stresses.
- The pressure hose must be laid with sufficient space to neighbouring components so that these are not touched during operation, when vibrating, as this could chafe it. In addition, it becomes hot (compressed air temperature up to 250°C at 40°C ambient temperature) and could damage temperature-sensitive components if the distance is too small. It is recommended to check the distance to neighbouring components again after the initial start-up, see next point.
- The pressure hose stretches/extends by a few cm during initial operation until the steady-state temperature is reached (after approx. 15 min at 10 bar), and retains this new length even when cold. We therefore recommend that you check the position of the pressure hoses again after initial start-up and, if necessary, loosen the hose connection and realign the pressure hoses. The tightness of the connection pieces on the cylinder head and radiator should also be checked in the process and restored if necessary, ideally by re-gluing the thread, see next point.
- We recommend gluing the connectors to the cylinder heads (G ½") and the radiator (G ¾" and M22x1.5) with a temperature-resistant thread adhesive. Make sure that only the thread that is screwed into the cylinder head and radiator is glued, but not the thread for the pressure hose fitting (side with the 60° cone inside), see Figure 1 and next point. The thread adhesive should have a temperature resistance up to 250°C.
- The fitting on the pressure hose seals via the 60° cone on the inside. No thread sealing aids, such as Teflon tape or adhesives, may be used in the screw connection, as sealing is not via the thread here, but via the internal cone.
- We recommend checking the pressure hoses, their (preferably stress-free) position (sufficient distance to neighbouring components) and the tightness of the screw connections immediately after initial start-up and at every inspection.

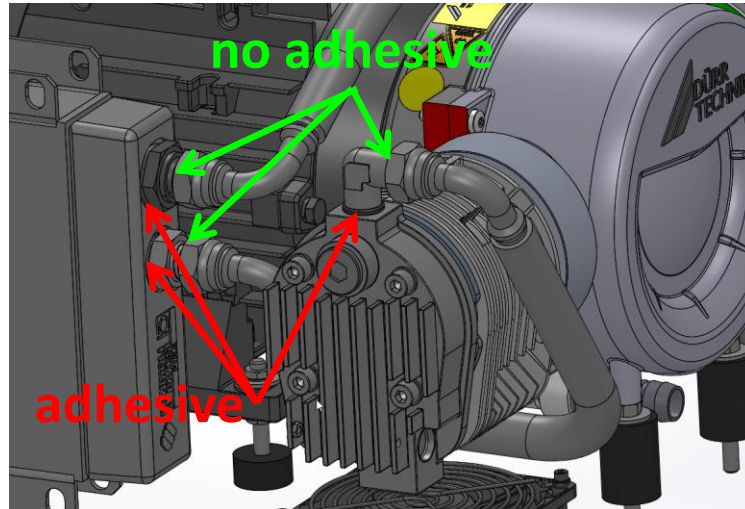


Figure 1: Which threads should be sealed with adhesives