



ODLEWNIA ŻELIWA  
ZAWIERCIE

## Usage Instruction of whiteheart malleable cast iron unions brand EE



### 1. Conical unions

**Leak tightness of these connections is obtained by conical clip (metallic) that is obtained by exact tightening moment.** Assembling of the unions by using torque wrench.

Dimension in inches	3/8	1/2	3/4	1	1 1/4	1 1/2	2	2 1/2	3	4
Min. tightening moment Nm	60	90	120	170	210	250	340	420	500	600

Newton-meter – unit of the moment of a force 1Nm = 0,1 kGm

#### NOTE:

Conical unions and conical union details **cannot be used again after disassembly** because of surface deformation of the cone. It is recommended to use unions as a complete set due to the fact that union details manufactured by different producers or component parts of a different unions manufactured by the same producer does not have to be mutually interchangeable. The constructions of the cone are not normalized.

### 2. Flat unions

**Leak tightness of these details is obtained by using of the special gaskets:**

dimensions of unions in inches	gasket size [mm]		thread dimension of union nuts
	inner diameter [mm]	outer diameter [mm]	
3/8	19	27	G 7/8
1/2	24	34	G 1 1/8
3/4	27	38	G 1 1/4
1	32	44	G 1 1/2
1 1/4	42	55	G 2
1 1/2	46	62	G 2 1/4
2	60	78	G 2 3/4
2 1/2	75	97	G 3 1/2
3	88	110	G 4
4	120	148	G 5 1/2

The material used for gaskets depends on the usage (the transmitted factor, temperature).

The gaskets of our unions are made from synthetic fibers which does not contain asbestos.

- Max working temperature standard 155 °C

- Max working temperature standard 130 °C

Higher parameters to be agreed upon orders.

The gaskets and other seals measures for the threads used by the customers shall comply with the requirements and standards appropriate to the type of installation.