

插合自锁式管道连接  
使用说明书



成都共同管业有限公司  
CHENGDU COMMON TUBE INDUSTRY CO.,LTD

一、总则

1.1 为指导和规范插合自锁式（以下简称“插锁式”）管道安装操作，确保管道安装质量和施工安全，特制定本说明书。

1.2 本说明书所用管材、管件，适用于公称压力为 1.6MPa,温度范围为 0~80℃ 的民用建筑冷水、热水和直饮水输送。

1.3 插锁式管道施工除应符合本说明书外，还应符合 CECS 383 《插合自锁卡簧式管道连接技术规程》及其他相关国家、行业有关的规范（规程）的要求。

二、产品结构介绍

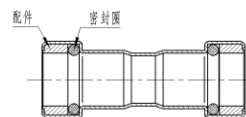


图1 管件示意图

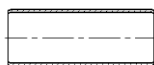


图2 不锈钢管材示意图



图3 不锈钢覆塑管材示意图

三、施工安装

3.1 检查管件各配件是否完整。

3.2 下料断管

应采用专用不锈钢管材断管器进行断管。断面应与管材垂直，并去端面内外毛刺。



当有塑覆层时，请先将覆塑层剥去，剥去的塑覆层距离宜为 30mm~35mm。

3.3 管件插装装配

在管材端部装配深度位置进行标记，将管材插装到管件底端。务必确认管材是否插入到位。

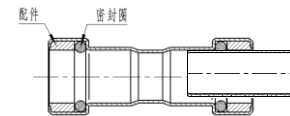


图4 管件与管材装配示意图

插装时，可稍许旋转管材或管件，沿管件轴向推送管材，可减少插装阻力。

过程中不得用力摇摆、撬动管材，以避免密封圈受损。

3.4 试压

装配完成后，应进行试压 2.5MPa 保压 10 分钟。完成后用干净水冲洗管道内部。

四、注意事项

- 1、水质氯化物含量 <1000mg/L(冷)或热水 <250mg/L。
- 2、连接前应检查并确认管材、管件内无异物附着，如：断管铁屑、油污等杂物。
- 3、管道暗埋、暗敷时应采取防腐措施，管材应选用覆塑管。
- 4、活动支架间距可分别参考下表 1:

5、表 4.1 薄壁不锈钢支架最大支撑间距 (m)

规格	DN 15	DN 20	DN 25	DN 32
横管	1.0	1.5	1.5	2.0
立管	1.5	2.0	2.2	2.5

Instruction manual for  
push-fit connection



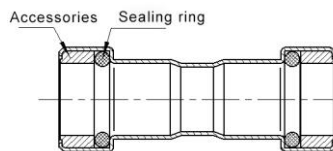
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I. General

1.1 In order to guide and regulate the installation operation of push-fit pipelines, to ensure the pipeline installation quality and construction safety, this manual is specially formulated.

1.2 The pipes and fittings used in the manual are suitable for the transportation of cold water, hot water and direct drinking water for civil buildings with nominal pressure of 1.6 MPa and temperature range of 0 ~ 80 ° C.

II Structure



Fittings diagram



Stainless steel pipe diagram

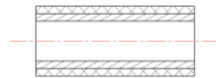


diagram of plastic lining pipe

III Construction and installation

3.1 Check to ensure all the fittings are intact.

3.2 Tube cutting



Use special stainless steel pipe cutters to cut the pipe. The cut should be perpendicular to the pipe and the burrs should be removed. When there is a plastic cladding, please remove the plastic cladding first. The removed length of the plastic cladding should be 30mm-35mm.

3.3 Assembly

Mark the end of the pipe at the assembled depth and dip the end of the pipe in water before insertion then insert the pipe to the bottom of the fittings. Always make sure the pipe is inserted into place.

When inserting, the pipe or fittings can be slightly rotated and pushed axially along the fittings to reduce insertion resistance. In order to prevent damage to the sealing ring, do not forcefully swing or pry the pipe during the insertion process.

3.4 Pressure test

After assembly, test for 10 minutes with 2.5 MPa and rinse the inside of the pipe with clean water.

Notes:

- 1、Water chloride content <1000mg/L (cold) or hot water <250mg/L
- 2、Before connection, check and confirm that there is no foreign objects attached in the pipe and fittings, such as iron dust, oil contamination and other sundries.
- 3、Anti-corrosive measures should be taken when the pipeline is buried or covered, and pipes should be clad.
- 4、Maximum support spacing for thin-walled stainless steel bracket (Meter)

Specification	DN15	DN20	DN25	DN32
Horizontal tube	1.0	1.5	1.5	2.0
Standpipe	1.5	2.0	2.2	2.5