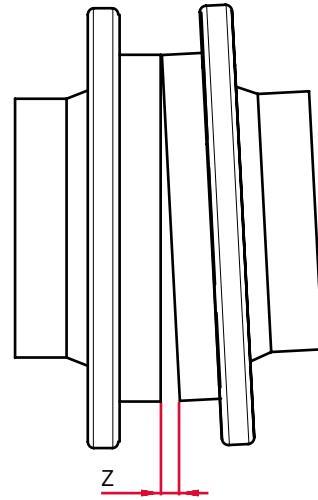


# Tightening PE collars

The measurements refer to the maximum obliquity between collar and fixed flange when assembled.

The measurements are calculated for short pipe ends at temperatures above 20 °C. The duration must be increased at lower temperature. For long lengths that are not securely fastened, the obliquity may be greater.



Pipe diameter D	Maximum obliquity/bend Z	Minimum duration of tightening in seconds S	Recommended interval between every ¼ turn when ratcheting T
40	3	8	5
50	3	10	5
63	3	13	5
75	3	15	5
90	4	19	5
110	5	23	5
125	5	26	5
140	6	29	5
160	7	33	6
180	8	37	6
200	9	41	6
225	10	46	6
250	11	52	6
280	12	58	6
315	14	65	6
355	15	73	6
400	17	82	7
450	20	93	7
500	22	103	7
560	24	115	7
630	27	130	7
710	31	146	7
800	35	165	8
900	39	185	8
1000	44	206	8
1200	52	247	9