

Snap joint

5.2.4. Snap joint



Illustration 5.31

For making pull-tight connections, snap (expansion) sockets are available. These sockets are plug-in sockets with an extra snap ring which provides, in combination with a groove in the pipe, a pull-tight connection.

Joining process:

Cut pipe square and remove burr

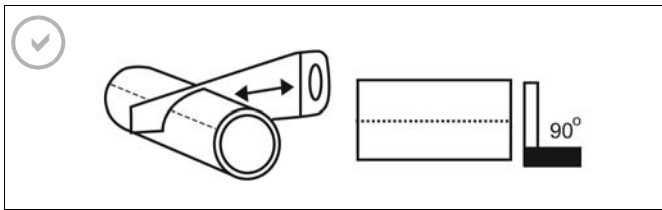
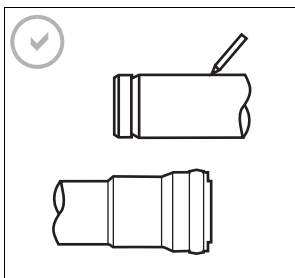


Illustration 5.32

Mark insertion depth

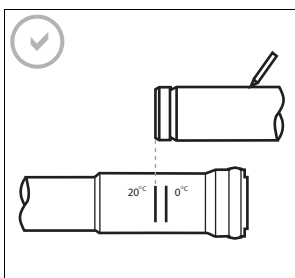


Snap socket:

The pipe needs to be inserted in the snap socket using the full insertion depth.

A snap socket is not to be used to accommodate the expansion and contraction of a pipe system.

Illustration 5.33



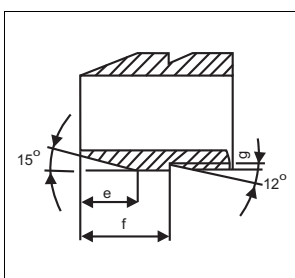
Snap-expansion socket:

A snap-expansion socket is used to accommodate the expansion and contraction in a pipe system.

The insertion depth is marked on the socket for both ambient temperatures of 0°C and 20°C. For detailed information see also paragraph 7.2.

Illustration 5.34

Chamfer pipe end and make snap groove



The pipe end needs to be chamfered under an angle of 15°. The groove needs to be cut under an angle of 12°. The correct dimensions can be found in table 5.5. To get an even cut and chamfer it is recommended to use an Akatherm groove cutter.

Illustration 5.35

d_1	e	f	g
40	5	15	1
50	5	15	1
56	5	15	1
63	5	15	1
75	5	15	1
90	6	15	1
110	8	15	1
125	9	15	1
160	11	15	1
200	11	30	2
250	15	30	2
315	18	50	3

Table 5.5 Dimensions chamfer and groove

Make joint

Lubricate the pipe end and insert the pipe up to the marked insertion depth. A distinguished click can be heard when the snap ring is inserted in the groove.

Remark:

When the groove is not made, the Akatherm snap and snap-expansion sockets are detachable like a not pull-tight joint.