

# General Product Information

## Product and Production

PRIMOFIT compression fitting bodies and nuts according to EN 10284 and prEN10344 are made out of white heart malleable cast iron type EN-GJMW-400-5 according to EN 1562 and comply with the design symbol A.

Design - Symbol	Type of material acc. EN 1562
A	EN-GJMW-400-5 EN-GJMB-350-10
B	EN-GJMW-350-4 EN-GJMB-300-6

PRIMOFIT compression fittings are supplied in black or hot dip galvanised finish, covered with a preservation for temporary prevention from rust. Hot dip galvanizing is done in accordance with EN 10284 and prEN 10344.

To cover a wide range of applications different rubber seal materials are supplied: NBR, NBR+graphite, EPDM and FPM. To distinguish from other seals FPM seals are coloured green instead of black.

Jointing threads – designated with R and Rp – on adaptor fittings and tees are according to EN 10226-1.

All PRIMOFIT compression fittings are single packed in plastic bags including the fitting instruction. The colour code of the label on the plastic bag and of the fitting instruction is related to the rubber seal material.

Seal material	Colour code
NBR	yellow
EPDM	blue
FPM	green
NBR+graphite (FIREJOINT)	red

Georg Fischer runs a quality management system according to EN ISO 9001, an environmental management system according to EN ISO 14001 and a health and safety management system according to OHSAS 18001. All certificates are available on request.

## Pressure Equipment Directive (PED) 97/23/EC

PRIMOFIT compression fittings are not pressure equipment in terms of the directive, therefore a CE-marking in accordance to the directive is not foreseen.

PRIMOFIT compression fittings are components of pressure equipment which fulfil the requirements of EN 10284 resp. prEN 10344 and the Pressure Equipment Directive – within the operating limits specified in EN 10284 resp. prEN 10344. The material fulfils the requirements of the Pressure Equipment Directive by compliance with A1 to EN 1562 (incl. annex E and ZA).

PRIMOFIT compression fittings may be used only for fluids which are compatible with the material malleable cast iron in either hot dip galvanised or black finish, respectively the sealing rubber. On request Georg Fischer issues a works certificate 2.2, together with a manufacturer declaration.

## Certificates

For major applications, especially in gas and drinking water applications several national certificates are available. For the actual list of certificates please refer to our homepage [www.fittings.at](http://www.fittings.at).

## Reuse of PRIMOFIT compression fittings

For reuse of the PRIMOFIT compression fitting, seal, washer and locking ring has to be replaced. For this purpose spare packs are available seperately.

Fitting body and nut can be reused if no mechanical damages, wear or corrosion is visible.

## Jointing steel pipes (product range “steel x steel”)

This assortment of compression fittings according to prEN 10344, depending on application is suitable to joint black or galvanized steel pipes according to EN 10255 and EN 10220-series 1 with measurements according to ISO 65. For some dimensions of but weld tubes (“Siederohr”) spare packs are available, these measurements are not covered by the above mentioned pipe series.

PRIMOFIT FIREJOINT is a special product which offers resistance against fire impact from outside according to German DVGW and according to British Gas test procedures.

For the application gas inside a building PRIMOFIT FIREJOINT has to be used.

To distinguish the FIREJOINT from other PRIMOFIT compression fittings, the FIREJOINT nut has a golden colour!

## Jointing PE and PE-Xa pipes (product range “steel x PE” and “PE x PE”)

Transition fittings jointing steel to PE pipes as well as compression fittings to joint PE with PE pipes are available. Compression fittings according to EN 10284 for connection of polyethylene pipes according to EN 1555-2 (gas) and EN 12201-2 (water) with material PE 100, PE 80 or cross-linked polyethylene pipe PE-Xa according to EN ISO 15875-2, for details see table on page 43.

To choose the correct compression fitting, please pay attention to the wall thickness given in the tables (choose correct SDR-series).

All compression fittings of this assortment are suitable for PE 80 (PE-MD), PE 100 (PE-HD) as well as for PE-Xa. An insert stiffener is included for each PE / PE-Xa connection and has to be used.

## Jointing Lead pipes

Compression fittings according to prEN 10344 for connection of pressurized lead pipes with measurements according to the table given on page 42.

According to the “council directive 98/83/EC of 3 November 1998 on the quality of water intended for human consumption” all existing lead pipes has to be replaced from drinking water systems within a transition period. PRIMOFIT compression fittings should be used only for repair of existing lead pipes and enable a temporary service until the final replacement of the lead pipe.

Depending on type of installation lead pipes could be in different conditions, therefore following recommendations has to be considered for jointing lead pipes:

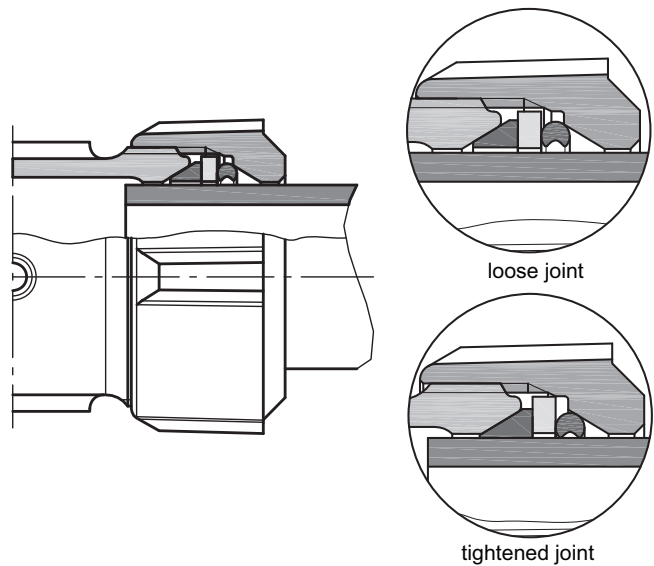
- the surface of the lead-pipe in the area of insertion has to be free of damages or dirt (preferably smooth surface without grooves and free of sand, soil etc.)
- the outer diameter of the lead-pipe has to be within the diameter range mentioned on the label of the bag
- the ovality of the lead-pipe may not exceed 1mm (= the difference between minimum and maximum outer diameter)
- after installation a pressure test according to national standards has to be done to check for leakage. The test pressure has to be at least 1,5 times nominal pressure (1,5xPN) or 10 bar (whichever is the higher value)
- the insertion depth and the number of turns to tighten the nut are mentioned in the attached coloured fitting instruction. For leadpipes use the values of the appropriate PE-pipe sizes (e.g. lead-pipe 30mm use values for PE-pipe 32mm)

# Joining technique - compression

## Joining steel pipes

In pre-assembled condition of PRIMOFIT compression fittings, the inner diameter of the internal components seal, washer and locking ring are bigger than the maximum outer diameter of the pipe. Therefore pipe insertion without dismantling is granted.

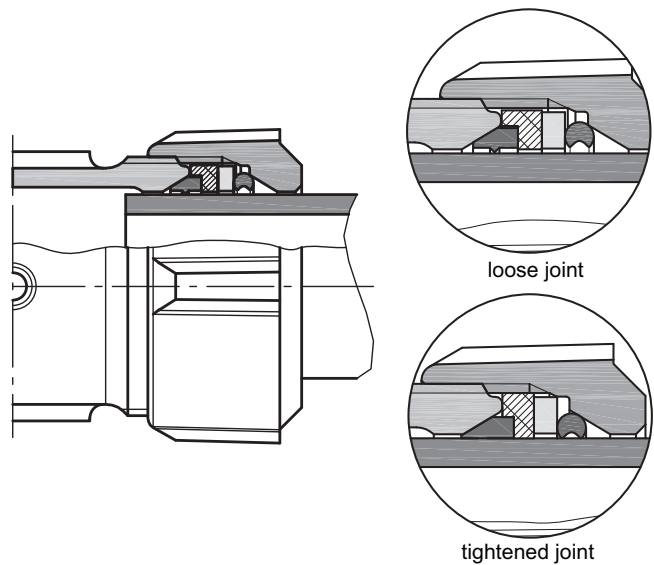
Tightening the nut has two functions: As a first step to press the seal into the space between conical surface of the fitting body and the outer surface of the pipe. As a second step to force the locking ring to enable end-load resistance.



## PRIMOFIT FIREJOINT for joining steel pipes (Application gas inside a building, fire resistant)

The system of the PRIMOFIT FIREJOINT fittings is similar to Primofit compression fittings for joining steel pipes but includes an additional graphite ring. These fittings are designed for gas application inside a building to fulfil testing requirements in terms of temperature resistance in case of fire.

The additional graphite ring ensures end-load resistance and leaktightness in case of fire. To ensure leaktightness under normal working conditions a NBR seal is placed onto the graphite ring.



## Joining PE, PE-Xa and Lead pipes

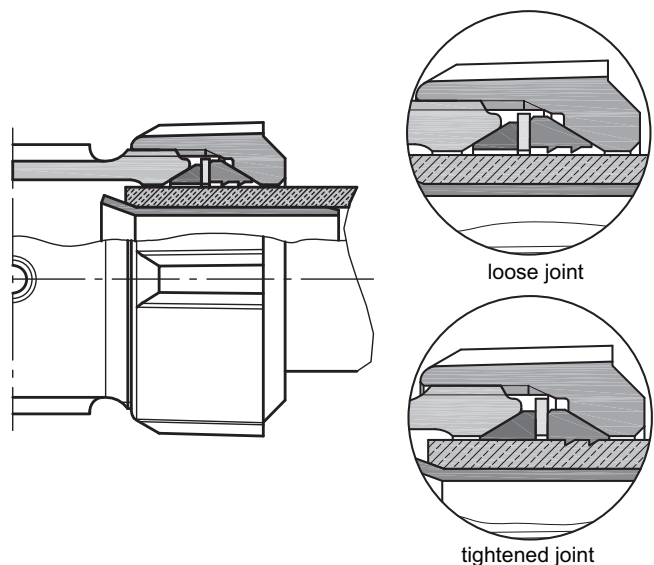
The system is similar to the PRIMOFIT compression fittings joining steel pipes. The major difference is to use an insert stiffener which is designed to fit into the inner diameter of the pipe. Insert stiffeners support the PE/PE-Xa pipe against radial forces.

Seal, washer and locking ring are designed to fit to the mechanical properties and to the outer diameter of the plastic pipes.

Please note the special shape of the locking ring for PE and PE-Xa pipes.

The connection allows a certain flexibility and misalignment in tightened condition.

Note: Joining lead pipes is similar to joining PE pipes but without using an insert stiffener.
















# Applications

## Working conditions

PRIMOFIT is an end-load resistant compression fitting. Each compression joint allows a misalignment up to 3° between pipe and compression fitting. Due to the modular concept of PRIMOFIT the compression fittings can be easily converted for other applications and other pipe materials by using a spare pack (change seal, washer and locking ring).

For the different applications please refer to the individual appropriate international, European or national application standards or to regulations of the local utility company. These may also restrict below operation limits. To choose the right seal material (NBR, EPDM, FPM or NBR+graphite) and the appropriate surface (black or galvanized) is essential for the specific application. The selection can be done by using the table below.

	Seal	Medium	max. working pressure [bar]	max. working temperature [°C]	Surface <sup>1)</sup>
Steel Pipe	NBR	 Gas <sup>2)</sup>	10	70	black or galvanized
		 Water <sup>3)</sup>	16	80 <sup>4)</sup>	galvanized
		 Compressed Air	16	80	black or galvanized
		 Oil	16	80	black or galvanized
	EPDM	 Water <sup>3)</sup>	16	40	galvanized
	FPM	 Fuels <sup>5)</sup>	10	40	black or galvanized
 Heating Water <sup>6)7)</sup>		10	105	black	
 Compressed Air		16	105	black or galvanized	
	NBR+graphite <sup>8)</sup>	 Gas <sup>2)</sup>	5	70	black or galvanized
PE Pipe <sup>9)</sup>	NBR	 Gas <sup>2)</sup>	5 / 7 / 8 <sup>10)</sup>	40	black or galvanized
		 Water <sup>3)</sup>	16	40	galvanized
	EPDM	 Water <sup>3)</sup>	16	40	galvanized
	FPM	 Fuels <sup>5)</sup>	10	40	black or galvanized

For lead pipes compression fittings can be used at max. 10 bar/60°C for the medium water (surface galvanized).

NBR ... nitrile butadiene rubber, EPDM ... ethylene propylene diene monomer rubber,  
FPM ... fluorinated propylene monomer rubber (fluoro elastomer)

- ad 1 Surface:** for selection national application standards and regulations of local utility companies have to be considered – especially if both versions (black and galvanized) are available.
- ad 2 Gas:** natural gas and liquid gas (LPG) (for jointing PE pipes not approved in all countries).
- ad 3 Drinking water:** for planning and installation of drinking water piping the standard EN 806-2 has to be considered. Details to avoid corrosion of galvanized iron materials are given in EN 12502-3.
- ad 4 Drinking water:** for the purpose of corrosion prevention the working temperature in continuous operation should not exceed 60°C for hot dip galvanized iron materials (fittings and pipes).
- ad 5 Fuels:** diesel, leaded petrol and unleaded petrol.
- ad 6 Heating water:** heating water also includes water-based liquids in ventilation and air conditioning systems. When using antifreeze fluids containing glycol fittings with black surface and FPM seal are recommended.
- ad 7 Heating water with NBR:** if the maximum operating temperature does not exceed 80°C also NBR seals can be used.
- ad 8 Gas installations:** for the application gas inside a building the product PRIMOFIT FIREJOINT has to be used (fire resistant compression fitting according to German DVGW and British Gas testing procedures).
- ad 9 PE pipes:** working conditions (temperature and pressure) have to be based on pressure/temperature diagram of PE pipes. The maximum working pressure depends on the PE-pipe specification (SDR-series), for details see table on page 43.
- ad 10 Gas approvals for PE-pipes:** DVGW/SVGW ... 5 bar, GIS/PL3 ... 7 bar, GASTEC ... 8 bar  
**Gas approvals for PE-Xa-pipes:** DVGW ... 5 bar

# Pipe Specification

The pipe to be joined, have to comply to the following tables.

## Overview - coupling dimension, pipe diameters for egal compression fitting bodies and diameter of the minimum bore

Nominal diameter DN Fittings dimension		10 3/8	15 1/2	20 3/4	25 1	32 1 1/4	40 1 1/2	50 2	65 2 1/2	80 3
Nominal outer diameter	Steel pipe mm	17,2	21,3	26,9	33,7	42,4	48,3	60,3	76,1	88,9
	Tolerance range mm	16,7 - 17,5	21,0 - 21,8	26,5 - 27,3	33,3 - 34,2	42,0 - 42,9	47,9 - 48,8	59,7 - 60,8	75,3 - 76,6	88,0 - 89,5
	Butt weld tubes * mm	-	-	-	-	38,0	44,5	57,0	70,0	-
	Tolerance range mm	-	-	-	-	37,5 - 38,5	44,0 - 45,0	56,4 - 57,6	69,3 - 70,7	-
	PE pipe mm	-	20	25	32	40	50	63	-	-
	Tolerance range mm	-	20,0 - 20,3	25,0 - 25,3	32,0 - 32,3	40,0 - 40,4	50,0 - 50,5	63,0 - 63,6	-	-
	Lead pipe mm	-	18,3 - 21,9	23,9 - 27,4	27,3 - 30,9 30,9 - 34,4	36,5 - 37,6 39,6 - 43,1	45,8 - 46,9 47,5 - 50,7	53,1 - 55,4 56,5 - 57,5 60,4 - 63,8	-	-
	Minimum bore** mm	7,5	11,1	17,8	24,0	31,4	37,1	46,5	61,3	72,8
	Thread size inch	3/8	1/2	3/4	1	1 1/4	1 1/2	2	2 1/2	3

\* only spare pack available

\*\* complies to the minimum clear bore of the male adapter.

At all other fitting types the inside diameter of the pipe will be the minimum clear bore.

## Steel pipes: Threaded pipes according to EN 10255 (former DIN 2440, DIN 2441, BS 1387), Butt weld tubes according to EN 10220-S1 (former DIN 2448/2458-S1, BS 3600)

Thread size Nominal diameter DN		3/8 10	1/2 15	3/4 20	1 25	1 1/4 32	1 1/2 40	2 50	2 1/2 65	3 80
<b>Threaded pipes EN 10255</b>										
Nominal outside diameter	mm	17,2	21,3	26,9	33,7	42,4	48,3	60,3	76,1	88,9
Surface area of the pipe	ca. m <sup>2</sup> /m	0,054	0,067	0,085	0,106	0,133	0,152	0,189	0,239	0,279
<b>Light tubes L2</b>										
Wall thickness	ca. mm	1,8	2,0	2,3	2,6	2,6	2,9	2,9	3,2	3,2
Inside diameter	ca. mm	13,6	17,3	22,3	28,5	37,2	42,5	54,5	69,7	82,5
Clear opening	ca. cm <sup>2</sup>	1,45	2,35	3,91	6,38	10,87	14,19	23,33	38,16	53,46
Capacity	ca. l/m	0,145	0,235	0,391	0,638	1,087	1,419	2,333	3,816	5,346
Pipe mass, plain end black pipe	ca. kg/m	0,670	0,947	1,38	1,98	2,54	3,23	4,08	5,71	6,72
<b>Medium tubes M</b>										
Wall thickness	ca. mm	2,3	2,6	2,6	3,2	3,2	3,2	3,6	3,6	4,0
Inside diameter	ca. mm	12,6	16,1	21,7	27,3	36,0	41,9	53,1	68,9	80,9
Clear opening	ca. cm <sup>2</sup>	1,25	2,04	3,70	5,85	10,18	13,79	22,15	37,28	51,40
Capacity	ca. l/m	0,125	0,204	0,370	0,585	1,018	1,379	2,215	3,728	5,140
Pipe mass, plain end black pipe	ca. kg/m	0,839	1,21	1,56	2,41	3,10	3,56	5,03	6,42	8,36
<b>Heavy tubes H</b>										
Wall thickness	ca. mm	2,9	3,2	3,2	4,0	4,0	4,0	4,5	4,5	5,0
Inside diameter	ca. mm	11,4	14,9	20,5	25,7	34,4	40,3	51,3	67,1	78,9
Clear opening	ca. cm <sup>2</sup>	1,02	1,74	3,30	5,19	9,29	12,76	20,67	35,36	48,89
Capacity	ca. l/m	0,102	0,174	0,330	0,519	0,929	1,276	2,067	3,536	4,889
Pipe mass, plain end black pipe	ca. kg/m	1,02	1,44	1,87	2,93	3,79	4,37	6,19	7,93	10,3
<b>Butt weld tubes EN 10220-S1 *</b>										
Outside diameter	mm	17,2	21,3	26,9	33,7	42,4	48,3	60,3	76,1	88,9
Wall thickness	ca. mm	1,8	2,0	2,3	2,6	2,6	2,6	2,9	2,9	3,2
Inside diameter	ca. mm	13,6	17,3	22,3	28,5	37,2	43,1	54,5	70,3	82,5
Clear opening	ca. cm <sup>2</sup>	1,45	2,35	3,91	6,38	10,87	14,59	23,33	38,82	53,46
Capacity	ca. l/m	0,145	0,235	0,391	0,683	1,087	1,459	2,333	3,882	5,346
Pipe mass, plain end black pipe	ca. kg/m	0,684	0,952	1,40	1,99	2,55	2,93	4,11	5,24	6,76

\* Supplementary to serie 1, there are Spare packs for butt weld tubes („Siederrohr“) with diameter 38, 44.5, 57 and 70mm available.

## Maximum working pressures of PE-pipes and PE-Xa pipes

Pressure range	EN 12201-2 (water)		EN 1555-2 (gas)		DIN 8074*		EN ISO 15875-2**
	PE 80	PE 100	PE 80	PE 100	PE 80	PE 100	PE-Xa
SDR 7,4/S 3,2	20	25	-	-	16	25	-
SDR 11/S 5	12,5	16	4	5	10	16	12,5
SDR 17/S 8	8	10	-	-	6,2	10	-
SDR 17,6/S 8,3	-	-	1	-	6,0	9,6	-

\* C=1,6 , 50 years ,  $T_B=20^{\circ}\text{C}$

\*\* C=1,5 , 100 years,  $T_B=50^{\circ}\text{C}$

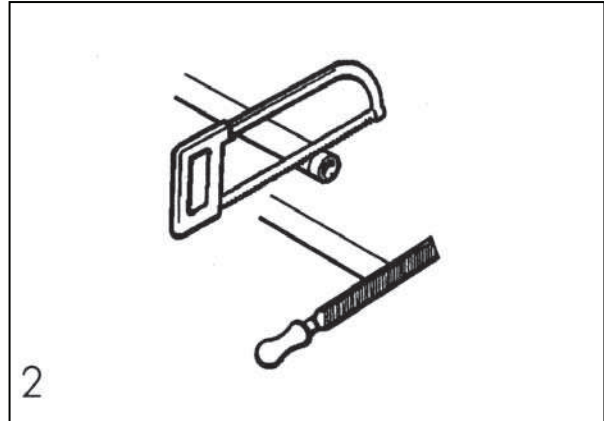
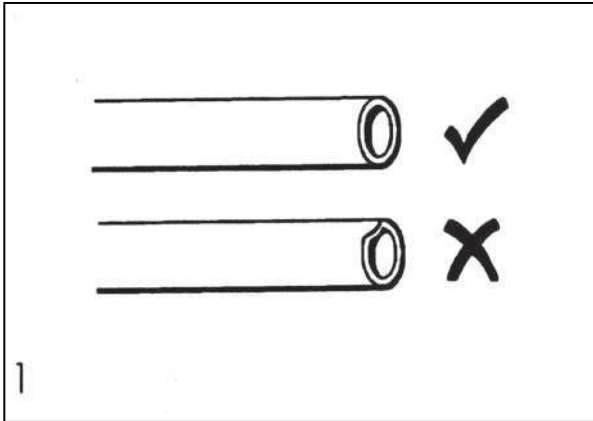
## Common PE-pipe and PE-Xa pipe series according to EN 1555-2, EN 12201-2, DIN 8074 and EN ISO 15875-2

Nominal outside diameter, Da		20	25	32	40	50	63
<b>SDR 7,4/S 3,2 acc. EN 12201-2 (water)</b>							
Wall thickness	ca. mm	3,0	3,5	4,4	5,5	6,9	8,6
Inside diameter	ca. mm	14,0	18,0	23,2	29,0	36,2	45,8
Clear opening	ca. cm <sup>2</sup>	1,54	2,54	4,23	6,61	10,29	16,47
Capacity	ca. l/m	0,154	0,254	0,423	0,661	1,029	1,647
Pipe mass	ca. kg/m	0,160	0,238	0,383	0,596	0,930	1,464
<b>SDR 7,4/S 3,2 acc. DIN 8074</b>							
Wall thickness	ca. mm	2,8	3,5	4,4	5,5	6,9	8,6
Inside diameter	ca. mm	14,4	18,0	23,2	29,0	36,2	45,8
Clear opening	ca. cm <sup>2</sup>	1,63	2,54	4,23	6,61	10,29	16,47
Capacity	ca. l/m	0,163	0,254	0,423	0,661	1,029	1,647
Pipe mass	ca. kg/m	0,154	0,238	0,383	0,596	0,930	1,464
<b>SDR 11/S 5 acc. EN 1555-2 (gas)</b>							
Wall thickness	ca. mm	3,0	3,0*	3,0*	3,7	4,6	5,8
Inside diameter	ca. mm	14,0	19,0	26,0	32,6	40,8	51,4
Clear opening	ca. cm <sup>2</sup>	1,54	2,84	5,31	8,35	13,07	20,75
Capacity	ca. l/m	0,154	0,284	0,531	0,835	1,307	2,075
Pipe mass	ca. kg/m	0,160	0,208	0,275	0,425	0,660	1,043
<b>SDR 11/S 5 acc. EN 12201-2 (water)</b>							
Wall thickness	ca. mm	2,0	2,3	3,0	3,7	4,6	5,8
Inside diameter	ca. mm	16,0	20,4	26,0	32,6	40,8	51,4
Clear opening	ca. cm <sup>2</sup>	2,01	3,27	5,31	8,35	13,07	20,75
Capacity	ca. l/m	0,201	0,327	0,531	0,835	1,307	2,075
Pipe mass	ca. kg/m	0,115	0,168	0,275	0,425	0,660	1,043
<b>SDR 11/S 5 acc. DIN 8074/EN ISO 15875-2</b>							
Wall thickness	ca. mm	1,9	2,3	2,9	3,7	4,6	5,8
Inside diameter	ca. mm	16,2	20,4	26,2	32,6	40,8	51,4
Clear opening	ca. cm <sup>2</sup>	2,06	3,27	5,39	8,35	13,07	20,75
Capacity	ca. l/m	0,206	0,327	0,539	0,835	1,307	2,075
Pipe mass	ca. kg/m	0,112	0,171	0,272	0,425	0,660	1,043
<b>SDR 17/S 8 acc. EN 12201-2 (water)</b>							
Wall thickness	ca. mm	-	-	2,0	2,4	3,0	3,8
Inside diameter	ca. mm	-	-	28,0	35,2	44,0	55,4
Clear opening	ca. cm <sup>2</sup>	-	-	6,16	9,73	15,21	24,11
Capacity	ca. l/m	-	-	0,616	0,973	1,521	2,411
Pipe mass	ca. kg/m	-	-	0,192	0,290	0,447	0,713
<b>SDR 17/S 8 acc. DIN 8074</b>							
Wall thickness	ca. mm	-	1,8	1,9	2,4	3,0	3,8
Inside diameter	ca. mm	-	21,4	28,2	35,2	44,0	55,4
Clear opening	ca. cm <sup>2</sup>	-	3,60	6,25	9,73	15,21	24,11
Capacity	ca. l/m	-	0,360	0,625	0,973	1,521	2,411
Pipe mass	ca. kg/m	-	0,137	0,187	0,290	0,447	0,713
<b>SDR 17,6/S 8,3 acc. EN 1555-2 (gas)</b>							
Wall thickness	ca. mm	2,3	2,3	2,3	2,3	2,9	3,6
Inside diameter	ca. mm	15,4	20,4	27,4	35,4	44,2	55,8
Clear opening	ca. cm <sup>2</sup>	1,86	3,27	5,90	9,84	15,34	24,45
Capacity	ca. l/m	0,186	0,327	0,590	0,984	1,534	2,445
Pipe mass	ca. kg/m	0,131	0,168	0,220	0,280	0,434	0,680
<b>SDR 17,6/S 8,3 acc. EN 12201-2 (water)</b>							
Wall thickness	ca. mm	-	-	2,0	2,3	2,9	3,6
Inside diameter	ca. mm	-	-	28,0	35,4	44,2	55,8
Clear opening	ca. cm <sup>2</sup>	-	-	6,16	9,84	15,34	24,45
Capacity	ca. l/m	-	-	0,616	0,984	1,534	2,445
Pipe mass	ca. kg/m	-	-	0,192	0,280	0,434	0,680
<b>SDR 17,6/S 8,3 acc. DIN 8074</b>							
Wall thickness	ca. mm	-	-	1,8	2,3	2,9	3,6
Inside diameter	ca. mm	-	-	28,4	35,4	44,2	55,8
Clear opening	ca. cm <sup>2</sup>	-	-	6,33	9,84	15,34	24,45
Capacity	ca. l/m	-	-	0,633	0,984	1,534	2,445
Pipe mass	ca. kg/m	-	-	0,179	0,280	0,434	0,680

\* For nominal outside diameter (Da) 25 and 32 s=2,0mm allows for existing pipe installations <0,1 bar.



# PRIMOFIT Fitting Instruction



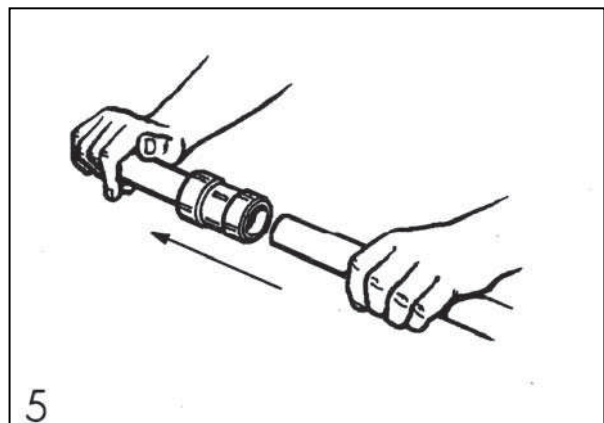
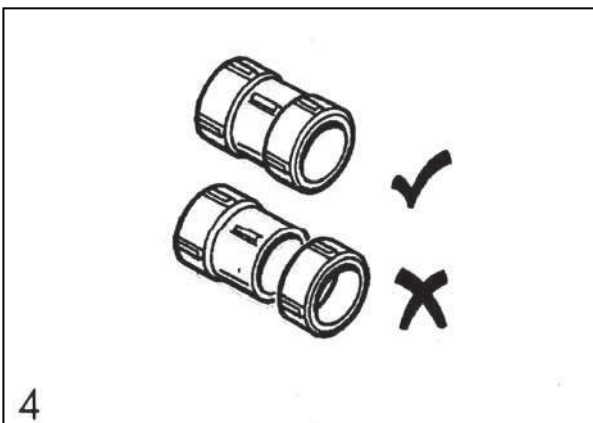
**Steel**

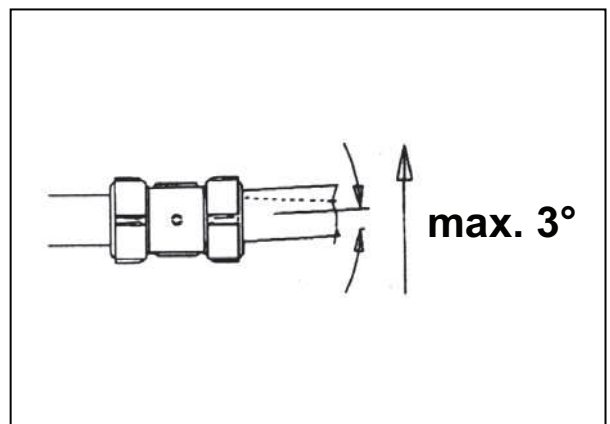
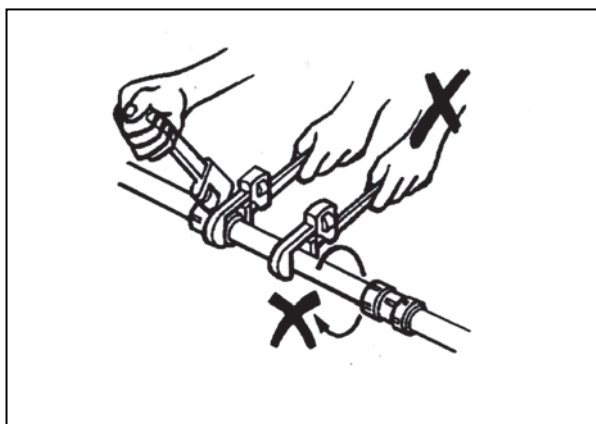
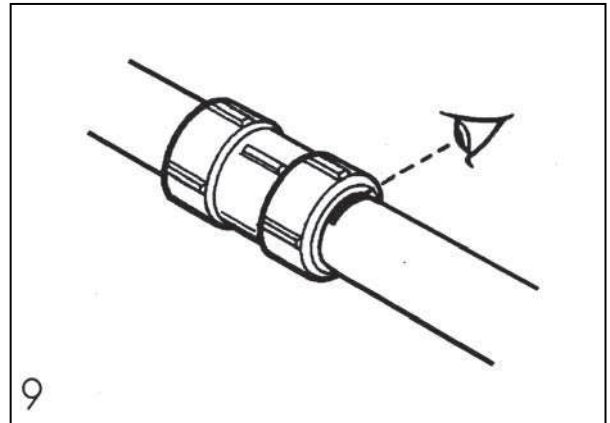
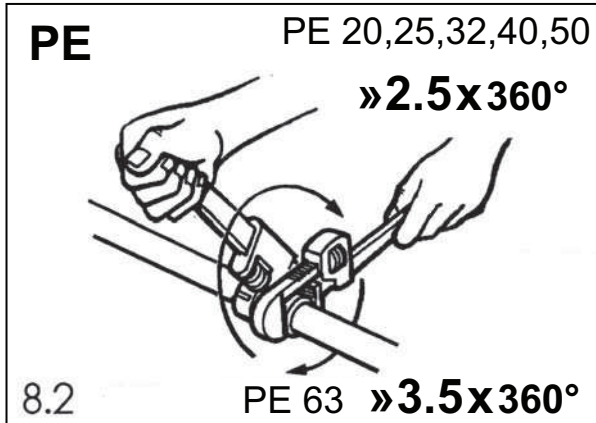
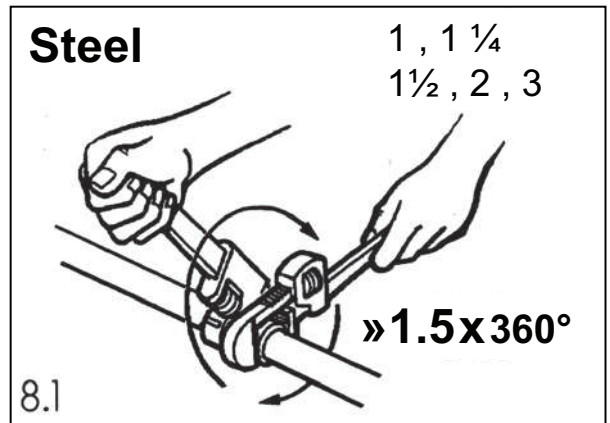
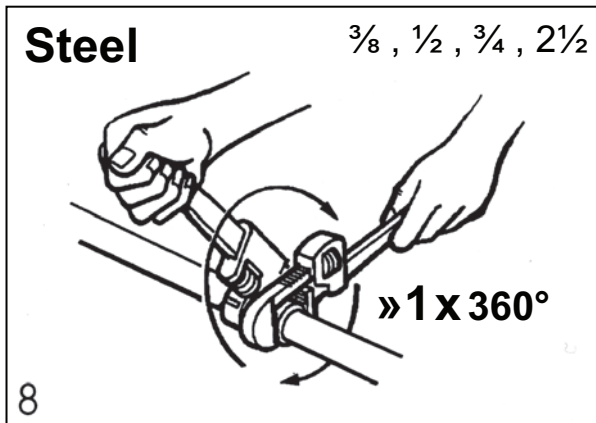
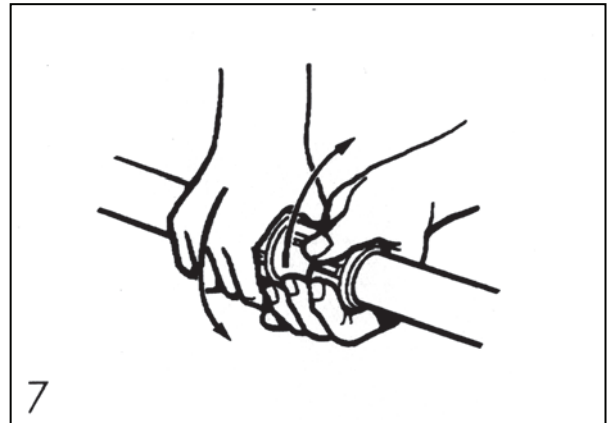
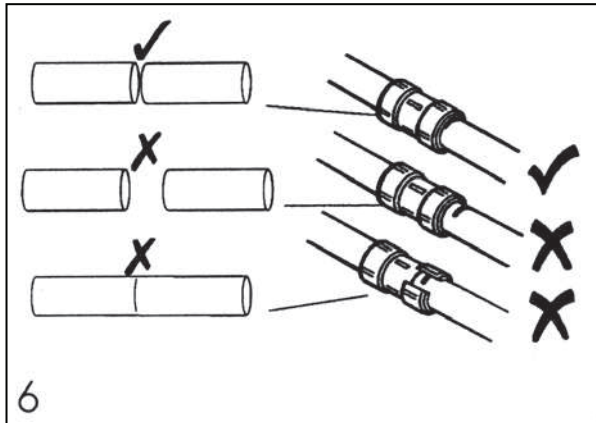
A	B
$\frac{3}{8}$	32mm $\pm$ 2
$\frac{1}{2}$	32mm $\pm$ 2
$\frac{3}{4}$	32mm $\pm$ 2
1	32mm $\pm$ 2
$1\frac{1}{4}$	33mm $\pm$ 3
$1\frac{1}{2}$	35mm $\pm$ 3
2	39mm $\pm$ 3
$2\frac{1}{2}$	70mm $\pm$ 5
3	70mm $\pm$ 5

**PE**

A	B	B1	B2
20	32mm $\pm$ 1	45mm	68mm
25	32mm $\pm$ 1	56mm	76mm
32	32mm $\pm$ 1	56mm	67mm
40	35mm $\pm$ 3	-	-
50	39mm $\pm$ 4	-	-
63	43mm $\pm$ 4	-	-

B1 = British Gas Sleeved Nut only  
B2 = GRP Sleeved Nut only





Important: Please mark the insertion depth to make sure that the pipe ends do not contact each other or the fitting body.

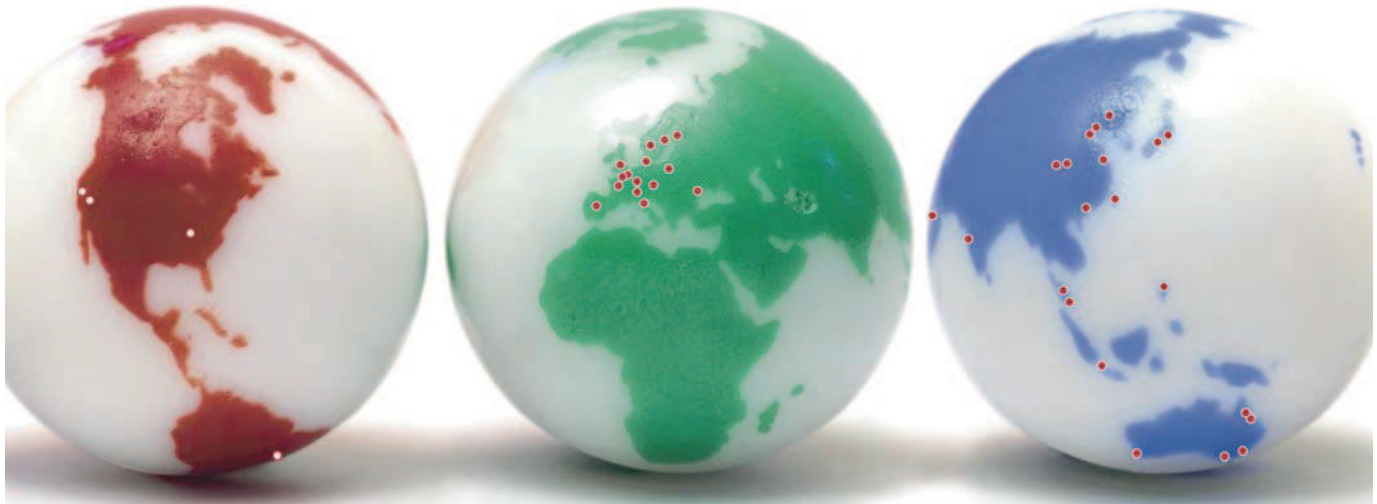


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