

PLEASE READ THESE INSTRUCTIONS BEFORE FASTENING THE CROSS-BRACINGS

- I Take the cross-bracing in both hands and defold the legs to a 90°-angle.

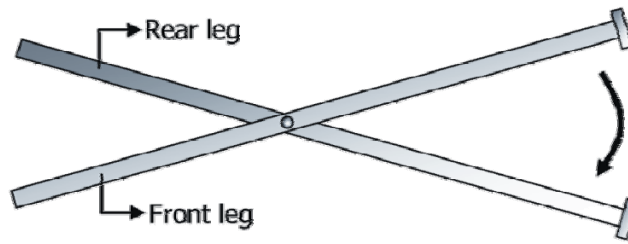


Fig. 1

- II Fit a short separate footpart in the front leg and a long separate footpart in the rear leg.

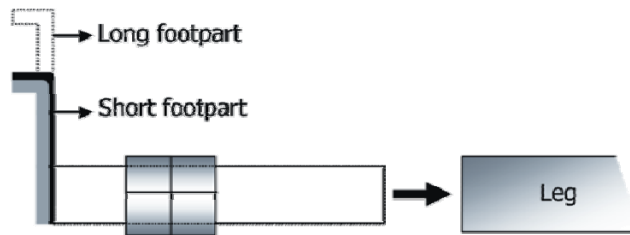


Fig. 2

- III Place the cross-bracing in the pipe-end as shown in Figure (3). When fastened, both legs need to be equal in length to maintain the roundness of the pipe. For improving the roundness, the cross-bracing is best placed vertically. We strongly recommend the use of a torque wrench (available at Dhatec) for fastening the cross-bracing. Determine the correct force for fastening by measuring both legs after fastening. They should measure a little over the internal diameter of the pipe (depending on the wall thickness, the diameter and the material)



Fig. 3

- IV **REMARK: Adjusting the correct force of the torque wrench is very important !**
Make sure the force is not too high: In this case both legs will measure too much over the internal pipe diameter. The pipe-end is forced in a conical form which will cause the cross-bracing to be pressed outwards and fall out. Verify if the cross-bracing has been pressed outwards at least 24 hours after fitting.
Make sure the force is not too low: In this case both legs will measure less or the same as the internal pipe diameter. The cross-bracing must be fitted secure enough to withstand handling and transport vibrations.

The person who fits or transports the cross-bracing remains responsible for the safe use of this product