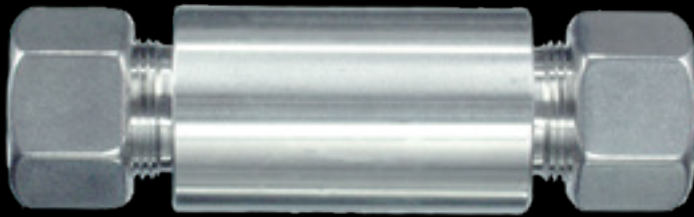




Pegasus
hydraulics

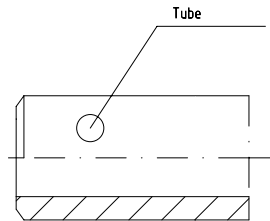
Weld fittings



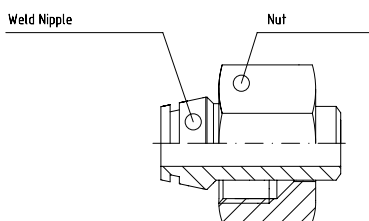
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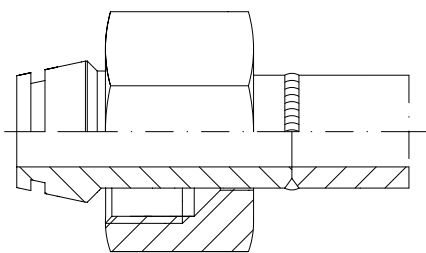
	Product Groups	Page
	Assembly instructions	10.02
	Bulkhead coupling	10.03
	Weld stub	10.04
	Weld stub elbow	10.05
	Weld coupling	10.06
	Weld nipple	10.07
	Reducing weld nipple	10.08
	Swept 90° weld nipple	10.09



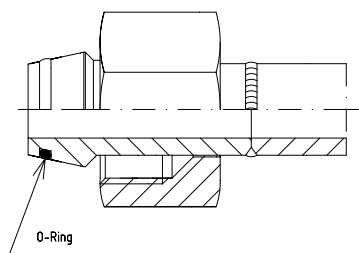
1. Cut the tube square and chamfer the end in preparation for welding. DIN 2559 is the standard for such preparation.



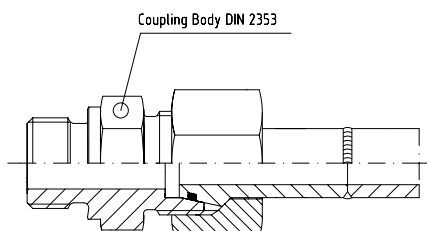
2. Remove the weld nipple O-ring and slip the nut over it, as shown.



3. Weld the tube and weld nipple together in accordance with normal welding practice.



4. Replace the weld nipple O-ring and ensure it is not twisted. Lubricate the weld nipple, the cone and the threads, don't grease.



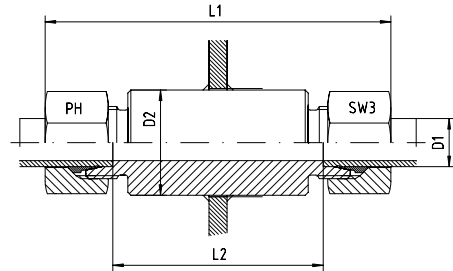
5. Offer the assembly to the fitting body and hand-tighten the nut. Then, with a spanner, turn the nut about 1/4 to 1/3 of a turn to tighten it. The weld nipple / tube assembly must be free of radial tension.

Bulkhead coupling

BOOK INDEX

SECTION INDEX

to ISO 8434-1 / DIN 2353



Series	Pressure PN	Tube O.D.		Approx. Dimensions			Part code
		D1	D2	L1	L2	SW3	
L	500	6	18	85	56	14	ESV-L-06
L	500	8	20	85	56	17	ESV-L-08
L	500	10	22	87	58	19	ESV-L-10
L	400	12	25	87	58	22	ESV-L-12
L	400	15	28	100	70	27	ESV-L-15
L	400	18	32	101	69	32	ESV-L-18
L	250	22	36	105	73	36	ESV-L-22
L	250	28	40	106	73	41	ESV-L-28
L	250	35	50	114	71	50	ESV-L-35
L	250	42	60	115	70	60	ESV-L-42

Series	Pressure	Tube O.D.		Approx. Dimensions			Part code
S	800	6	20	89	60	17	ESV-S-06
S	800	8	22	89	60	19	ESV-S-08
S	800	10	25	91	59	22	ESV-S-10
S	630	12	28	91	59	24	ESV-S-12
S	630	14	30	107	72	27	ESV-S-14
S	630	16	35	107	71	30	ESV-S-16
S	420	20	38	114	71	36	ESV-S-20
S	420	25	45	120	72	46	ESV-S-25
S	420	30	50	126	73	50	ESV-S-30
S	420	38	60	133	72	60	ESV-S-38

Fittings can be supplied with nuts with silver-plated threads to help to prevent galling, or can be supplied body only - no nut or cutting ring.

If you require silver-plated nuts, use suffix -SC. If you require body only, use suffix -OMD.

Eg. ESV-L-12-SC, or ESV-L-12-OMD.

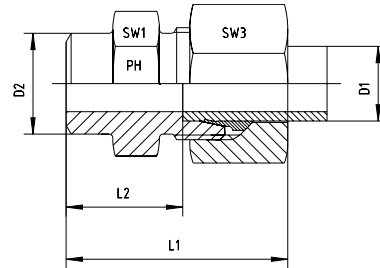
10

Weld stub

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SECTION INDEX

to ISO 8434-1 / DIN 2353



Series	Pressure PN	Tube O.D.		Approx. Dimensions				Part code
		D1	D2	L1	L2	SW1	SW3	
L	500	6	10	29	14.0	12	14	ASV-L-06
L	500	8	12	31	16.0	14	17	ASV-L-08
L	500	10	14	33	18.0	17	19	ASV-L-10
L	400	12	16	33	18.0	19	27	ASV-L-12
L	400	15	19	37	22.0	22	27	ASV-L-15
L	400	18	22	40	23.5	27	32	ASV-L-18
L	250	22	27	45	28.5	32	36	ASV-L-22
L	250	28	32	47	30.5	41	41	ASV-L-28
L	250	35	40	54	32.5	46	50	ASV-L-35
L	250	42	46	58	35.0	55	60	ASV-L-42

Series	Pressure PN	Tube O.D.		Approx. Dimensions				Part code
		D1	D2	L1	L2	SW1	SW3	
S	800	6	11	34	19.0	14	17	ASV-S-06
S	800	8	13	36	21.0	17	19	ASV-S-08
S	800	10	15	39	22.5	19	22	ASV-S-10
S	630	12	17	41	24.5	22	24	ASV-S-12
S	630	14	19	45	27.0	24	27	ASV-S-14
S	630	16	21	45	26.5	27	30	ASV-S-16
S	420	20	26	51	29.5	32	36	ASV-S-20
S	420	25	31	56	32.0	41	46	ASV-S-25
S	420	30	36	62	35.5	46	50	ASV-S-30
S	420	38	44	69	38.0	55	60	ASV-S-38

Fittings can be supplied with nuts with silver-plated threads to help to prevent galling, or can be supplied body only - no nut or cutting ring.

If you require silver-plated nuts, use suffix -SC. If you require body only, use suffix -OMD.

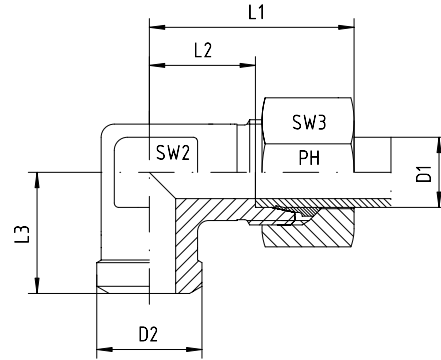
Eg. ASV-L-12-SC, or ASV-L-12-OMD.

Weld stub elbow

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SECTION INDEX

to ISO 8434-1 / DIN 2353



Series	Pressure PN	Tube O.D.		Approx. Dimensions					Part code
		D1	D2	L1	L2	L3	SW2	SW3	
L	500	6	10	27	12.0	19	12	14	WAS-L-06
L	500	8	12	29	14.0	23	12	17	WAS-L-08
L	500	10	14	30	15.0	24	14	19	WAS-L-10
L	400	12	16	32	17.0	25	17	22	WAS-L-12
L	400	15	19	36	21.0	30	19	27	WAS-L-15
L	400	18	22	40	23.5	33	24	32	WAS-L-18
L	250	22	27	44	27.5	37	27	36	WAS-L-22
L	250	28	32	47	30.5	42	36	41	WAS-L-28
L	250	35	40	56	34.5	49	41	50	WAS-L-35
L	250	42	46	63	40.0	57	50	60	WAS-L-42

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Series	Pressure PN	Tube O.D.		Approx. Dimensions					Part code
		D1	D2	L1	L2	L3	SW2	SW3	
S	800	6	11	31	16.0	23	12	17	WAS-S-06
S	800	8	13	32	17.0	24	14	19	WAS-S-08
S	800	10	15	34	17.5	25	17	22	WAS-S-10
S	630	12	17	38	21.5	29	17	24	WAS-S-12
S	630	14	19	40	22.0	30	19	27	WAS-S-14
S	630	16	21	43	24.5	33	24	30	WAS-S-16
S	420	20	26	48	26.5	37	27	36	WAS-S-20
S	420	25	31	54	30.0	42	36	46	WAS-S-25
S	420	30	36	62	35.5	49	41	50	WAS-S-30
S	420	38	44	72	41.0	57	50	60	WAS-S-38

Fittings can be supplied with nuts with silver-plated threads to help to prevent galling, or can be supplied body only - no nut or cutting ring.

If you require silver-plated nuts, use suffix -SC. If you require body only, use suffix -OMD.

Eg. WAS-L-12-SC, or WAS-L-12-OMD.

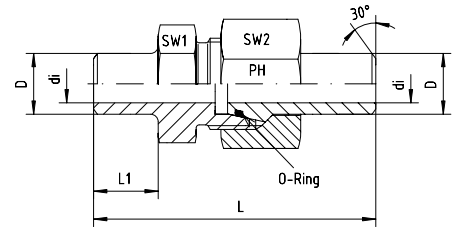
Weld coupling

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SECTION INDEX

to ISO 8434-1 / DIN 2353

Supplied with NBR O-ring,
Viton on request



Series	Pressure PN	Tube O. D.	Approx. Dimensions						O-ring	Part code
			L	L1	D	di	SW1	SW3		
S	528	6 x 1.5	52.5	10.0	6	3	14	17	4.0 x 1.5	ASV-K-6x1.5
S	414	8 x 1.5	52.5	10.0	8	5	17	19	6.0 x 1.5	ASV-K-8x1.5
S	528	8 x 2	52.5	10.0	8	4	17	19	6.0 x 1.5	ASV-K-8x2
S	249	10 x 1	58.0	10.0	10	8	19	22	8.0 x 1.5	ASV-K-10x1
S	358	10 x 1.5	58.0	10.0	10	7	19	22	8.0 x 1.5	ASV-K-10x1.5
S	460	10 x 2	58.0	10.0	10	6	19	22	8.0 x 1.5	ASV-K-10x2
S	305	12 x 1.5	63.0	15.0	12	9	22	24	10.0 x 1.5	ASV-K-12x1.5
S	393	12 x 2	63.0	15.0	12	8	22	24	10.0 x 1.5	ASV-K-12x2
S	476	12 x 2.5	63.0	15.0	12	7	22	24	10.0 x 1.5	ASV-K-12x2.5
S	343	14 x 2	73.0	15.0	14	10	24	27	10.0 x 2.0	ASV-K-14x2
S	487	14 x 3	73.0	15.0	14	8	24	27	10.0 x 2.0	ASV-K-14x3
S	305	16 x 2	73.5	16.5	16	12	27	30	13.0 x 2.0	ASV-K-16x2
S	372	16 x 2.5	73.5	16.5	16	11	27	30	13.0 x 2.0	ASV-K-16x2.5
S	400	16 x 3	73.5	16.5	16	10	27	30	13.0 x 2.0	ASV-K-16x3
S	249	20 x 2	83.5	19.0	20	16	32	36	16.0 x 2.0	ASV-K-20x2
S	305	20 x 2.5	83.5	19.0	20	15	32	36	16.3 x 2.4	ASV-K-20x2.5
S	358	20 x 3	83.5	19.0	20	14	32	36	16.3 x 2.4	ASV-K-20x3
S	400	20 x 4	83.5	19.0	20	12	32	36	16.3 x 2.4	ASV-K-20x4
S	294	25 x 3	92.5	19.5	25	19	41	46	21.3 x 2.4	ASV-K-25x3
S	379	25 x 4	92.5	19.5	25	17	41	46	21.3 x 2.4	ASV-K-25x4
S	400	25 x 5	92.5	19.5	25	15	41	46	21.3 x 2.4	ASV-K-25x5
S	249	30 x 3	101.5	23.0	30	24	46	50	25.3 x 2.4	ASV-K-30x3
S	323	30 x 4	101.5	23.0	30	22	46	50	25.3 x 2.4	ASV-K-30x4
S	393	30 x 5	101.5	23.0	30	20	46	50	25.3 x 2.4	ASV-K-30x5
S	400	30 x 6	101.5	23.0	30	18	46	50	25.3 x 2.4	ASV-K-30x6
S	261	38 x 4	108.0	22.0	38	30	55	60	34.0 x 2.5	ASV-K-38x4
S	315	38 x 5	108.0	22.0	38	28	55	60	34.0 x 2.5	ASV-K-38x5
S	315	38 x 6	108.0	22.0	38	26	55	60	34.0 x 2.5	ASV-K-38x6
S	315	38 x 7	108.0	22.0	38	24	55	60	34.0 x 2.5	ASV-K-38x7
S	250	50 x 5	118.0	23.0	50	40	70	80	46.0 x 3.0	ASV-K-50x5
S	310	50 x 6	118.0	23.0	50	38	70	80	46.0 x 3.0	ASV-K-50x6
S	350	50 x 7	118.0	23.0	50	36	70	80	46.0 x 3.0	ASV-K-50x7

Series	Pressure PN	Tube O. D.	Approx. Dimensions						O-ring	Part code
			L	L1	D	di	SW1	SW3		
L	323	15 x 2	54.5	15.0	15	11	22	27	12.0 x 2.0	ASV-K-15x2
L	315	18 x 2	57.5	16.0	18	14	27	32	15.0 x 2.0	ASV-K-18x2
L	280	22 x 2.5	74.0	19.0	22	17	32	36	19.0 x 2.0	ASV-K-22x2.5
L	265	28 x 3	78.0	19.0	28	22	41	41	25.0 x 2.0	ASV-K-28x3
L	231	35 x 3	87.5	22.0	35	29	46	50	32.0 x 2.5	ASV-K-35x3
L	182	42 x 3	87.0	22.0	42	36	55	60	38.0 x 2.5	ASV-K-42x3

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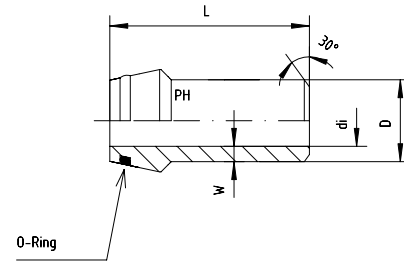
Weld nipple

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SECTION INDEX

for 24° compression fittings to
W DIN 3861

Supplied with NBR O-ring,
Viton on request



Series	Pressure PN	D x W	Approx. Dimensions		O-ring	Part code
			di	L		
L + S	528	6 x 1.5	3	31.0	4.0 x 1.5	SKV-6x1.5
L + S	414	8 x 1.5	5	31.0	6.0 x 1.5	SKV-8x1.5
L + S	528	8 x 2	4	31.0	6.0 x 1.5	SKV-8x2
L + S	249	10 x 1	8	32.5	8.0 x 1.5	SKV-10x1
L + S	358	10 x 1.5	7	32.5	8.0 x 1.5	SKV-10x1.5
L + S	460	10 x 2	6	32.5	8.0 x 1.5	SKV-10x2
L + S	305	12 x 1.5	9	32.5	10.0 x 1.5	SKV-12x1.5
L + S	393	12 x 2	8	32.5	10.0 x 1.5	SKV-12x2
L + S	476	12 x 2.5	7	32.5	10.0 x 1.5	SKV-12x2.5
L + S	476	12 x 3	6	32.5	10.0 x 1.5	SKV-12x3
S	343	14 x 2	10	40.0	10.0 x 2.0	SKV-14x2
S	415	14 x 2.5	9	40.0	10.0 x 2.0	SKV-14x2.5
S	487	14 x 3	8	40.0	10.0 x 2.0	SKV-14x3
L	270	15 x 1.5	12	36.0	12.0 x 2.0	SKV-15x1.5
L	323	15 x 2	11	36.0	12.0 x 2.0	SKV-15x2
L	393	15 x 2.5	10	36.0	12.0 x 2.0	SKV-15x2.5
S	305	16 x 2	12	38.5	13.0 x 2.0	SKV-16x2
S	372	16 x 2.5	11	38.5	13.0 x 2.0	SKV-16x2.5
S	435	16 x 3	10	38.5	13.0 x 2.0	SKV-16x3
L	225	18 x 1.5	15	37.0	16.0 x 1.5	SKV-18x1.5
L	300	18 x 2	14	37.0	15.0 x 2.0	SKV-18x2
L	335	18 x 2.5	13	37.0	15.0 x 2.0	SKV-18x2.5
S	249	20 x 2	16	44.5	16.0 x 2.0	SKV-20x2
S	305	20 x 2.5	15	44.5	16.3 x 2.4	SKV-20x2.5
S	358	20 x 3	14	44.5	16.3 x 2.4	SKV-20x3
S	460	20 x 4	12	44.5	16.3 x 2.4	SKV-20x4
L	245	22 x 2	18	38.5	19.0 x 2.0	SKV-22x2
L	280	22 x 2.5	17	38.5	19.0 x 2.0	SKV-22x2.5
L	328	22 x 3	16	38.5	19.0 x 2.0	SKV-22x3
S	294	25 x 3	19	49.5	21.3 x 2.4	SKV-25x3
S	337	25 x 3.5	18	49.5	21.3 x 2.4	SKV-25x3.5
S	379	25 x 4	17	49.5	21.3 x 2.4	SKV-25x4
S	460	25 x 5	15	49.5	21.3 x 2.4	SKV-25x5
L	193	28 x 2	24	41.5	25.0 x 2.0	SKV-28x2
L	224	28 x 2.5	23	41.5	25.0 x 2.0	SKV-28x2.5
L	265	28 x 3	22	41.5	25.0 x 2.0	SKV-28x3
S	249	30 x 3	27	52.0	25.3 x 2.4	SKV-30x3
S	323	30 x 4	22	52.0	25.3 x 2.4	SKV-30x4
S	393	30 x 5	20	52.0	25.3 x 2.4	SKV-30x5
S	460	30 x 6	18	52.0	25.3 x 2.4	SKV-30x6
L	154	35 x 2	31	47.0	32.0 x 2.5	SKV-35x2
L	193	35 x 2.5	30	47.0	32.0 x 2.5	SKV-35x2.5
L	231	35 x 3	29	47.0	32.0 x 2.5	SKV-35x3
L	249	35 x 3.5	28	47.0	32.0 x 2.5	SKV-35x3.5
S	261	38 x 4	30	56.5	34.0 x 2.5	SKV-38x4
S	319	38 x 5	28	56.5	34.0 x 2.5	SKV-38x5
S	375	38 x 6	26	56.5	34.0 x 2.5	SKV-38x6
S	429	38 x 7	24	56.5	39.0 x 1.5	SKV-38x7
L	129	42 x 2	38	47.0	39.0 x 1.5	SKV-42x2
L	150	42 x 2.5	37	47.0	38.0 x 2.5	SKV-42x2.5
L	182	42 x 3	36	47.0	38.0 x 2.5	SKV-42x3
L	238	42 x 4	34	47.0	38.0 x 2.5	SKV-42x4
S	250	50 x 5	40	61.0	46.0 x 3.0	SKV-50x5
S	310	50 x 6	38	61.0	46.0 x 3.0	SKV-50x6
S	350	50 x 7	36	61.0	46.0 x 3.0	SKV-50x7

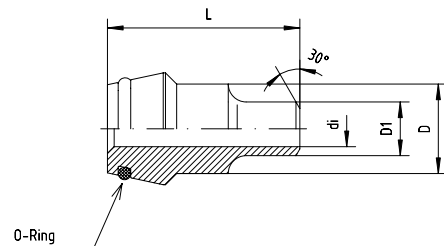
Reducing weld nipple

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SECTION INDEX

for 24° compression fittings
to W DIN 3861

Supplied with NBR O-ring,
Viton on request



Series	Pressure PN	Approx. Dimensions				O-ring	Part code
		D	D1	di	L		
S	380	8	6	4	30	6.0 x 1.5	SKV-R-8/6x1
S	528	8	6	3	30	6.0 x 1.5	SKV-R-8/6x1.5
S	414	10	8	5	32	8.0 x 1.5	SKV-R-10/8x1.5
S	528	10	8	4	32	8.0 x 1.5	SKV-R-10/8x2
S	528	10	6	3	32	8.0 x 1.5	SKV-R-10/6x1.5
S	358	12	10	7	32	10.0 x 1.5	SKV-R-12/10x1.5
S	460	12	10	6	32	10.0 x 1.5	SKV-R-12/10x2
S	414	12	8	5	32	10.0 x 1.5	SKV-R-12/8x1.5
S	380	12	6	4	32	10.0 x 1.5	SKV-R-12/6x1
S	528	12	6	3	32	10.0 x 1.5	SKV-R-12/6x1.5
S	393	16	12	8	39	13.0 x 2.0	SKV-R-16/12x2
S	460	16	10	6	39	13.0 x 2.0	SKV-R-16/10x2
S	414	16	8	5	39	13.0 x 2.0	SKV-R-16/8x1.5
S	435	20	16	10	43	16.3 x 2.4	SKV-R-20/16x3
S	372	20	16	11	43	16.3 x 2.4	SKV-R-20/16x2.5
S	305	20	16	12	43	16.3 x 2.4	SKV-R-20/16x2
S	393	20	12	8	43	16.3 x 2.4	SKV-R-20/12x2
S	358	20	10	7	43	16.3 x 2.4	SKV-R-20/10x1.5
S	414	20	8	5	43	16.3 x 2.4	SKV-R-20/8x1.5
S	358	25	20	14	50	21.3 x 2.4	SKV-R-25/20x3
S	305	25	20	15	50	21.3 x 2.4	SKV-R-25/20x2.5
S	249	25	20	16	50	21.3 x 2.4	SKV-R-25/20x2
S	435	25	16	10	50	21.3 x 2.4	SKV-R-25/16x3
S	372	25	16	11	50	21.3 x 2.4	SKV-R-25/16x2.5
S	305	25	16	12	50	21.3 x 2.4	SKV-R-25/16x2
S	393	25	12	8	50	21.3 x 2.4	SKV-R-25/12x2
S	460	25	10	6	50	21.3 x 2.4	SKV-R-25/10x2
S	294	30	25	19	52	25.3 x 2.4	SKV-R-30/25x3
S	358	30	20	14	52	25.3 x 2.4	SKV-R-30/20x3
S	435	30	16	10	52	25.3 x 2.4	SKV-R-30/16x3
S	393	30	12	8	52	25.3 x 2.4	SKV-R-30/12x2
S	323	38	30	22	58	34.0 x 2.5	SKV-R-38/30x4
S	249	38	30	24	58	34.0 x 2.5	SKV-R-38/30x3
S	379	38	25	17	58	34.0 x 2.5	SKV-R-38/25x4
S	294	38	25	19	58	34.0 x 2.5	SKV-R-38/25x3
S	358	38	20	14	58	34.0 x 2.5	SKV-R-38/20x3
S	305	38	20	15	58	34.0 x 2.5	SKV-R-38/20x2.5
S	435	38	16	10	58	34.0 x 2.5	SKV-R-38/16x3
S	305	38	16	12	58	34.0 x 2.5	SKV-R-38/16x2
S	393	38	12	8	58	34.0 x 2.5	SKV-R-38/12x2

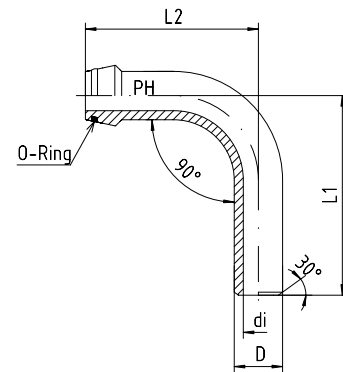
Swept 90° weld nipple

BOOK INDEX

SECTION INDEX

for 24° compression fittings
to W DIN 3861

Supplied with NBR O-ring,
Viton on request



Series	Pressure PN	Tube	Approx. Dimensions				O-ring	Part code
			D	di	L1	L2		
S	460	10 x 2	10	6	49	51	8.0 x 1.5	SKV-RB-10x2
S	393	12 x 2	12	8	50	51	10.0 x 1.5	SKV-RB-12x2
S	476	12 x 2.5	12	7	50	51	10.0 x 1.5	SKV-RB-12x2.5
S	305	16 x 2	16	12	72	67	13.0 x 2.0	SKV-RB-16x2
S	372	16 x 2.5	16	11	72	67	13.0 x 2.0	SKV-RB-16x2.5
S	435	16 x 3	16	10	72	67	13.0 x 2.0	SKV-RB-16x3
S	249	20 x 2	20	16	89	86	16.3 x 2.4	SKV-RB-20x2
S	305	20 x 2.5	20	15	89	86	16.3 x 2.4	SKV-RB-20x2.5
S	358	20 x 3	20	14	89	86	16.3 x 2.4	SKV-RB-20x3
L	328	22 x 3	22	16	79	85	19.0 x 2.0	SKV-RB-22x3
S	294	25 x 3	25	19	93	89	21.3 x 2.4	SKV-RB-25x3
S	379	25 x 4	25	17	93	89	21.3 x 2.4	SKV-RB-25x4
S	460	25 x 5	25	15	93	89	21.3 x 2.4	SKV-RB-25x5
S	323	30 x 4	30	22	112	105	25.3 x 2.4	SKV-RB-30x4
S	393	30 x 5	30	20	112	105	25.3 x 2.4	SKV-RB-30x5
S	460	30 x 6	30	18	112	105	25.3 x 2.4	SKV-RB-30x6
S	261	38 x 4	38	30	145	137	34.0 x 2.5	SKV-RB-38x4
S	319	38 x 5	38	28	145	137	34.0 x 2.5	SKV-RB-38x5
S	375	38 x 6	38	26	145	137	34.0 x 2.5	SKV-RB-38x6
S	429	38 x 7	38	24	145	137	34.0 x 2.5	SKV-RB-38x7