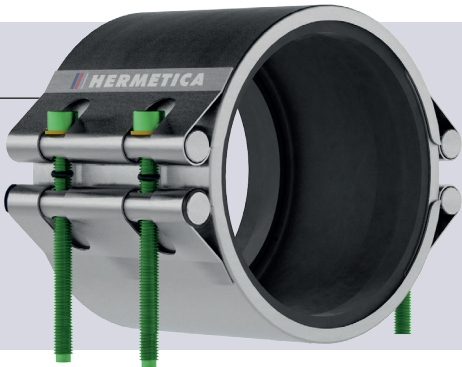


/ HERMETICA SERIES 10

WIDTH 135 mm  
 2 Closures  
 Can be opened completely  
**Hinge closure:** 2 screws 100 mm long  
**Opening closure:** 2 screws 130 mm long  
**PILOTO and Hold-ON Technology.**



1 / NECESSARY MATERIALS



2 / MEASURES

TOLERANCES SERIES 10 | BEHAVIOR WHEN INSTALLED

Ø OUTSIDE DIAMETER	PRESSURE	OFFSET	DIFFERENCE IN DIAMETER	DISTANCE BETWEEN PIPES	Ø PERFORATION SIZE	OVALITY	BENDING
88 - 650 mm	10 / 16 bar	3 mm	3 mm	10 mm	50 mm	2-5 %	2°

Check the condition of the pipe to be repaired to select the appropriate clamp.

Check:



- Outer diameter of pipe.
- Installation pressure.
- Perforation size.
- Bending.
- Offset.
- Difference in diameter.
- Special conditions (temperature, vacuum, aggressive fluids, aggressive media...)

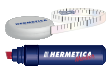
3 / PREPARATION OF THE PIPE SURFACE

**3.1. Clean the pipe's surface** where the HERMETICA will be installed.



Polish the pipe with the scraper trying to make the surface as clean and regular as possible.

**3.2. Mark the position of the clamp** on the pipe by centering the clamp over the repair area and leaving half the width of the clamp on each side.

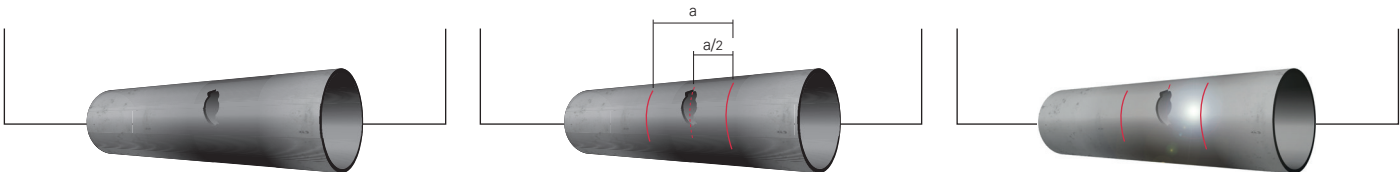


$a$  = Width of the clamp. Using the marker, indicate the center of the area to be repaired and the final position of the clamp.

**3.3. Lubricate the pipe** where the clamp will be installed: Use water and soap or vaseline suitable for food use.



Lubricate the pipe surface.

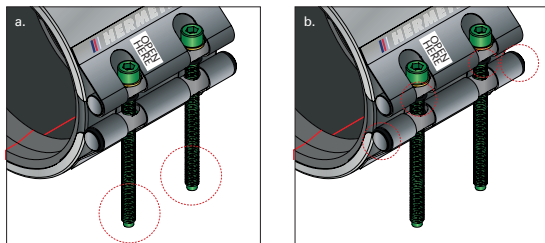


## 4 / CLAMP INSTALLATION

### 4.1. Opening of the HERMETICA

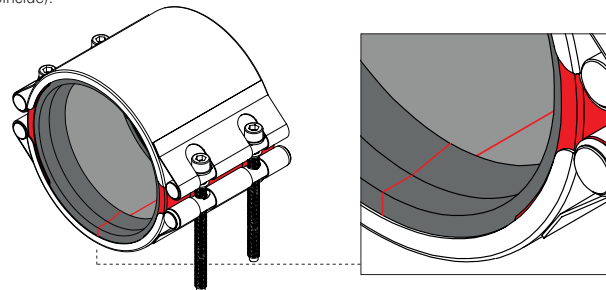
The opening closure is identified by:

- a. Sticker "Open Here." Screws 30% longer with PILOTO Technology.
- b. Equipped with Hold-ON Technology on both shafts and screws.



### 4.2. EPDM gasket placement

The faces of the EPDM gasket must be placed head to head on any flat area of the casing, avoiding its position on the reinforcement sheet (do not make the areas marked in red coincide).



### 4.3. Positioning the casing

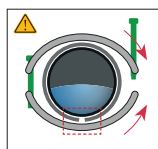
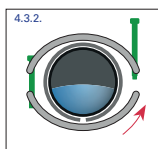
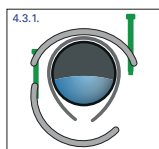
4.3.1. Position the upper casing body over the EPDM gasket.

4.3.2. Approach the lower casing body to start closing the HERMETICA.

**CAUTION:** The EPDM gasket should be placed inside the casing. The faces of the gasket must face perfectly.



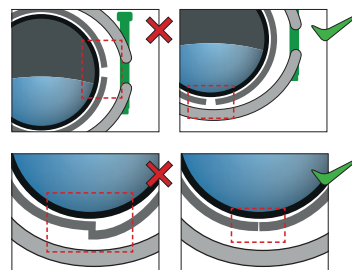
- a. Avoid misalignment between the faces.
- b. Avoid overlapping of the faces.
- c. No adhesives are required.
- d. Do not cut the EPDM gasket.



### 4.4. Approach and tighten the screws

4.4.1. Start the approximation of the central screw using a wrench. (Being 30% longer and equipped with the PILOTO Technology facilitates its assembly).

4.4.2. Final check of the EPDM gasket, make sure it is in correct position.

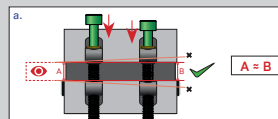


**CAUTION:**

Tighten both closures with the central screws:

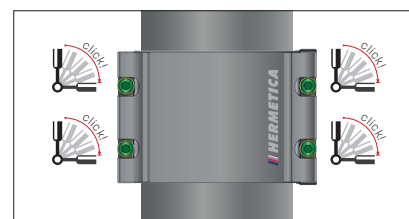
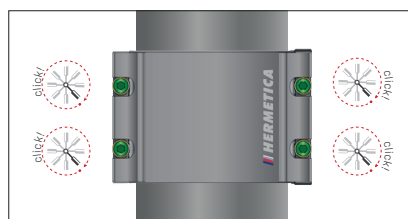
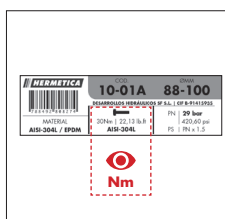


- a. Avoid creating angularity during the approach of the closure.
- b. Check progressively that the distance between the shafts on both sides is similar.
- c. Progressively tighten the side screws on both locks.



### 4.5. Final Adjustment with Torque Wrench

4.5.1. Use the torque wrench when there is a 20/25 mm gap between the shafts. The clamp label details the torque to be applied on N-m and Lb-inch.



4.5.2. Tighten the screws of one of the locks until the torque indicated by the key is reached. Tighten the opposite screws reaching the indicated torque.

4.5.3. Repeat step 4.5.2. as many times as necessary to achieve the tightening torque of all screws in a quarter turn of the wrench.