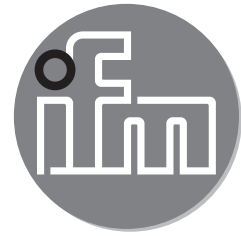


ifm electronic



Installation Instructions

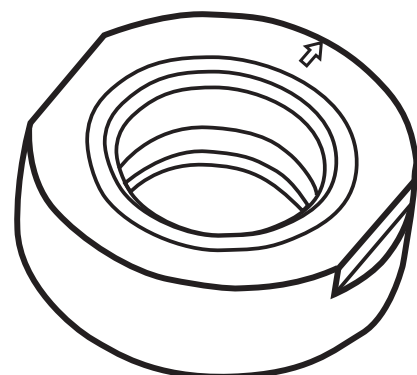
Welding adapter  
with Aseptoflex thread

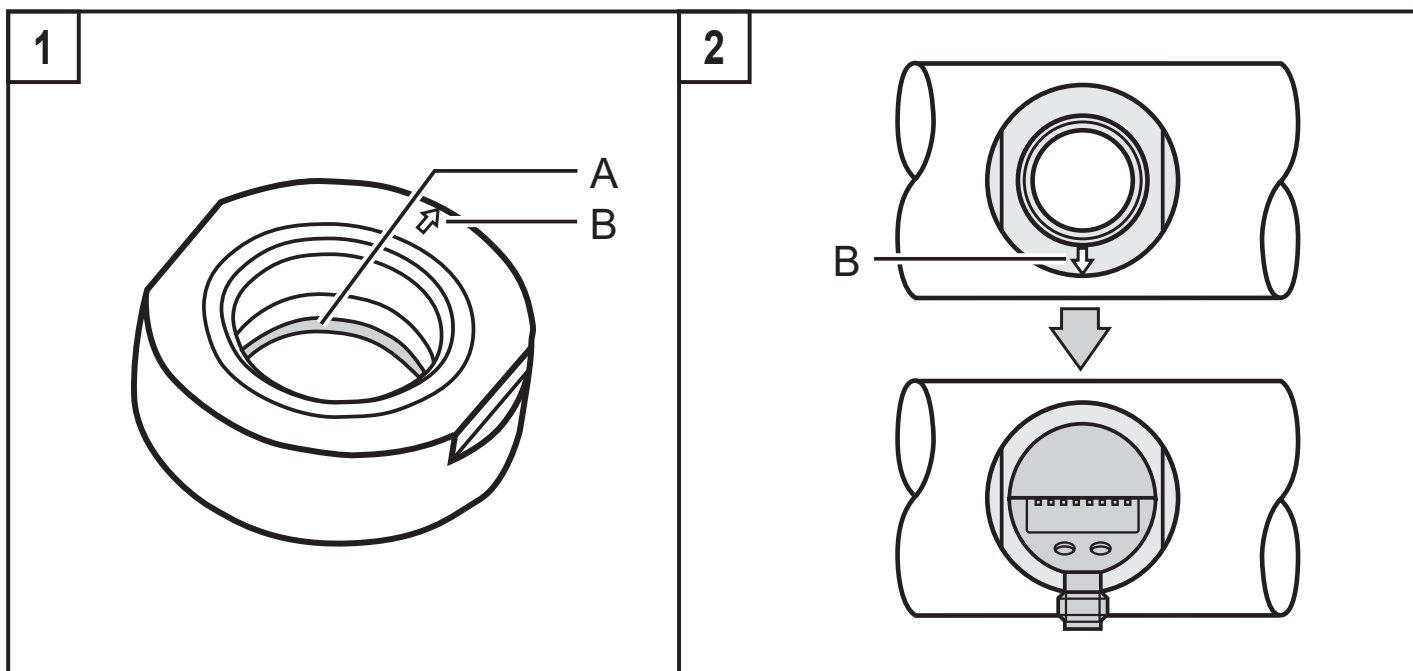
**E30052**

**UK**

05/2011

706010/00





A: Groove for the O-ring; the adapter is installed using 2 O-rings of different materials: Viton (fitted), EPDM-O-Ring (enclosed).

B: Marking for alignment.

| Order no. | Type                        | Material                 | Permissible overload pressure* |
|-----------|-----------------------------|--------------------------|--------------------------------|
| E30052    | Aseptoflex thread - Ø 50 mm | stainless steel (316S12) | 50 bar                         |

\* for the connection sensor - adapter

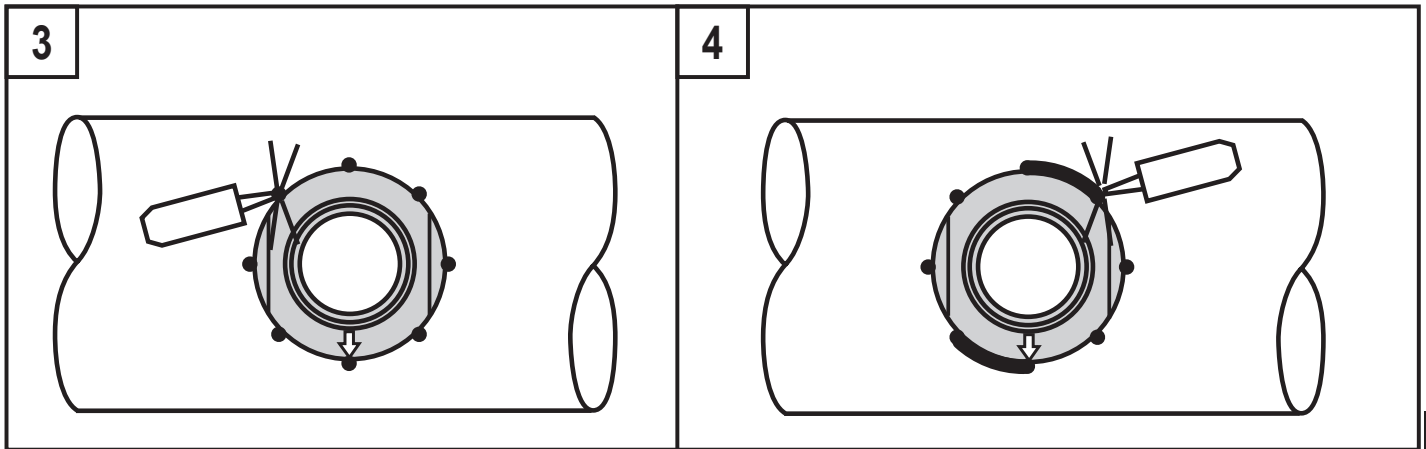


- The welding operation must be carried out by authorised personnel.
- It must be carried out carefully and according to state-of-the-art technology.
- During welding and the following cooling phase, neither sensor nor O-ring must be in place.
- The surfaces must be free from soiling of any kind.
- Welding tools must be suitable for the adapter and wall material.

## 1 Preparations

- ▶ Bore a hole in the pipe or housing wall with the outside diameter of the adapter (max. oversize: 0.2 mm).
- ▶ If possible, screw a cover plug into the adapter (order no E30064).

## 2 Welding operation



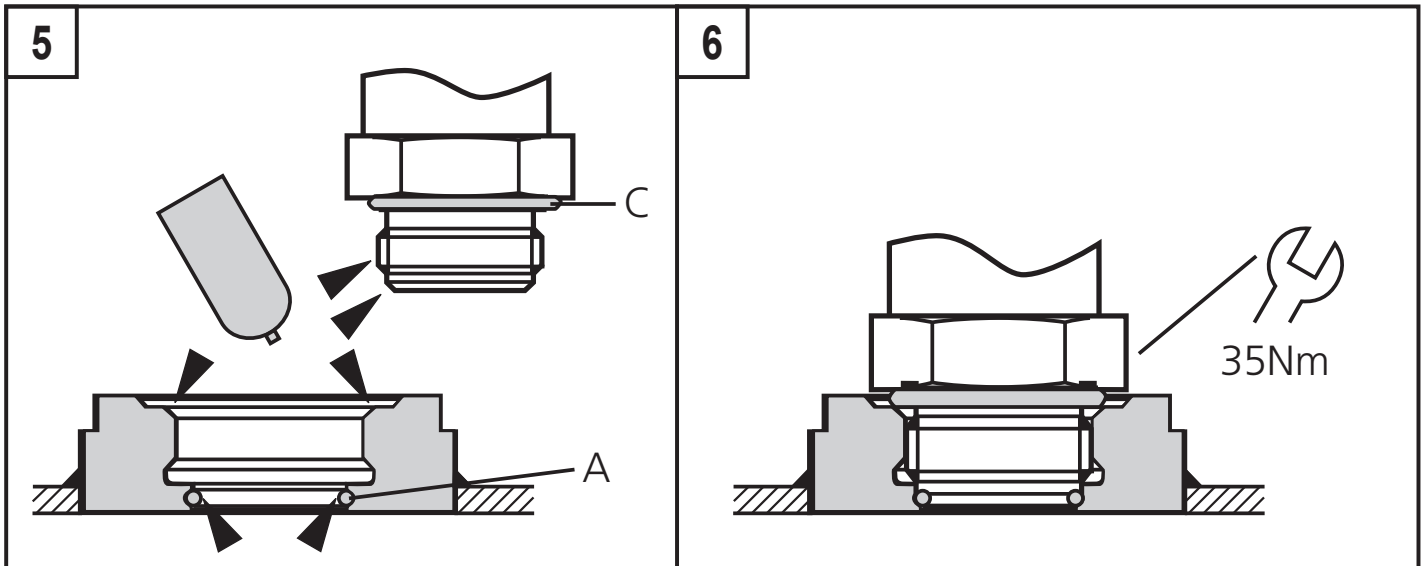
The power of the welding device must be adapted to the thickness of the wall.

- ▶ Adapter alignment: Turn the marking to the position provided for the connector / display of the screwed sensor (see figure 2).
- ▶ Fix the adapter at several points with sufficient holding force, apply the fixing points at equal distance opposite each other (see figure 3).
- ▶ Apply the welding seams between the fixing points opposite each other (see figure 4). Ensure sufficient intervals between the individual sections (cooling phases to avoid glowing through / warping of the adapter due to overheating).

## 3 After welding

- ▶ Let the adapter cool down.
- ▶ Clean the thread from welding residues.

## 4 Installation of the sensor



- ▶ Place one of the supplied O-rings in the groove of the adapter (A; Viton or EPDM O-ring, depending on the fluid). It must snap flush into the groove over its whole circumference. (see fig. 1).  
O-rings are also available as accessories:
  - Order no. E30053 (5 pcs. Viton O-rings).
  - Order no. E30054 (5 pcs. EPDM O-rings).
- ▶ Grease the following parts with suitable paste (see fig. 5):
  - Thread and sealing area of the sensor,
  - sealing areas and O-ring of the adapter.The paste must be suitable and approved for the application and compatible with the elastomers used.
- ▶ Make sure that the O-rings (A and C) are correctly positioned (O-ring C is supplied with the sensor).
- ▶ Screw the sensor into the adapter. Avoid damage to the sealing areas (see fig. 6).  
**CAUTION:** If the sensor can only be screwed into the thread with great resistance, apply no force.  
If it is not possible to rectify the thread, remove the adapter and weld in a new one.
- ▶ Tighten the sensor with a torque wrench.  
Tightening torque: 35 Nm.