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PEX pipe connectors, heating and sanitary

HELA pex pipe connectors are strong, reliable and easy to use in every applications where pex pipes are in generally used.

Among potable water and heating applications they are suitable for bore holes and different kind of irrigation systems as well. Due to their corrosion resistant DZR-brass material they are suitable for more aggressive conditions than couplings made out of regular brass. For most operating conditions DZR brass is good enough material but in some applications higher resistance of corrosion is needed. For those applications we

can offer couplings made out of stainless steel AISI 316.

All connectors are clearly marked with nominal diameter, pipe's wall thickness and pressure class (PN6 or PN10) in attend to avoid assembling faults. 15–32mm are compression type connectors with fixed insert and split ring. 25–160mm are bolt type connectors with strong fixed insert and clamping sleeve.

Assembling of bolt type connector is very easy because of handy opening screw and it does

Application:	Pex pipe connectors according to ISO 15875-5
Pressure rating:	PN6 and PN10 (unless mentioned otherwise)
Materials:	CC752S / CW602N / CW617N (CEN/TS 13388)
Clamping bolts:	AISI316, O-rings: EPDM TIMO 3/70
Threads:	ISO228-1 (SFS-EN 1254-4) / ISO7-1
Dezincification resistance:	SFS-EN ISO 6509
Stress corrosion:	ISO 6957/2
Tensile strength:	EN712, EN ISO 15875-5:4.4
Pressure strength:	EN921, EN ISO 15875-5: 4.2
Negative pressure test:	EN12294, EN ISO 15875-5:4.7
Pressure variation test:	EN12295, EN ISO 15875-5:4.6
Temperature variation test:	EN12293, EN ISO 15875-5:4.5

8010 Pex double connector



PN6 / heating / class15 / SDR 11.0

HELA ref.		Dimensions	Qty/box
480 102 523		25 x 2.3	40
480 103 230	1932341	32 x 2.9	30
480 104 037	1932342	40 x 3.7	25
480 105 046	1932343	50 x 4.6	20
480 106 358	1932344	63 x 5.8	10
480 107 568	1932345	75 x 6.8	7
480 109 082	1932346	90 x 8.2	3

not require special tools or hydraulic equipment. All connectors 15–160mm has conical ISO7 threads as standard. Other threads like NPT can be done by request.

Among DZR-brass connectors we also manufacture 25–160mm welding connectors with steel inserts for district heating and other special applications.

HELA ref.		Dimensions	Qty/box
480 101 10100	1932347	110 x 10.0	1
480 101 25114	1932348	125 x 11.4	1
480 101 60146	1932350	160 x 14.6	1

PN10 / sanitary / class24 / SDR 7.4

HELA ref.		Dimensions	Qty/box
480 102 535		25 x 3.5	40
480 103 244	1932351	32 x 4.4	30
480 104 055	1932352	40 x 5.5	25
480 105 069	1932353	50 x 6.9	20
480 106 387	1932354	63 x 8.7	10
480 107 5103	1932355	75 x 10.3	7
480 109 0123	1932356	90 x 12.3	3
480 101 10151	1932357	110 x 15.1	1
480 101 25171	1932358	125 x 17.1	1
480 101 60219	1932360	160 x 21.9	1

8015 Pex connectors 15–32mm



PN6 / heating / class15 / SDR 11.0

HELA ref.		Dimensions	Qty/box
48015181520	1932201	½" x 18 - 2.0	150
48015202020	1932203	¾" x 20 - 2.0	100
48015252023	1932204	¾" x 25 - 2.3	90
48015252523	1932205	1" x 25 - 2.3	90
48015282530	1932207	1" x 28 - 3.0	70
48015322530	1932208	1" x 32 - 3.0	50
48015323230	1932200	1¼" x 32 - 3.0	50

PN10 / sanitary / class24 / SDR 7.4

HELA ref.		Dimensions	Qty/box
48015182025	1932218	¾" x 18 - 2.5	100
48015182525	1932219	1" x 18 - 2.5	100
48015222030	1932222	¾" x 22 - 3.0	100
48015222530	1932223	1" x 22 - 3.0	100
48015252035	1932226	¾" x 25 - 3.5	90
48015282540	1932231	1" x 28 - 4.0	50
48015322544	1932233	1" x 32 - 4.4	50
48015323244	1932234	1¼" x 32 - 4.4	50

8015 Pex connectors 25–160mm



PN6 / heating / class15 / SDR 11.0

HELA ref.		Dimensions	Qty/box
48015 252023P		¾" x 25 - 2.3	50
48015 322530P	1932340	1" x 32 - 3.0	50
48015 403237	1932209	1¼" x 40 - 3.7	30
48015 503246	1932210	1½" x 50 - 4.6	25
48015 504046	1932314	1½" x 50 - 4.6	25
48015 635058	1932211	2" x 63 - 5.8	15
48015 755068	1932315	2" x 75 - 6.8	10
48015 756568	1932212	2½" x 75 - 6.8	10
48015 908082	1932213	3" x 90 - 8.2	6
48015 1103100	1932316	3" x 110 - 10.0	3
48015 1104100	1932214	4" x 110 - 10.0	3
48015 1254114		4" x 125 - 11.4	1
48015 1255114		5" x 125 - 11.4	1
48015 1605146		5" x 160 - 14.6	
48015 1606146		6" x 160 - 14.6	1

PN10 / sanitary / class24 / SDR 7.4

HELA ref.		Dimensions	Qty/box
48015 252035P		¾" x 25 - 3.5	50
48015 322544P	1932238	1" x 32 - 4.4	50
48015 403255	1932241	1¼" x 40 - 5.5	30
48015 503269	1932247	1½" x 50 - 6.9	25
48015 504069	1932248	1½" x 50 - 6.9	25
48015 635087	1932263	2" x 63 - 8.7	15
48015 7550103	1932274	2" x 75 - 10.3	10
48015 7565103	1932275	2½" x 75 - 10.3	10
48015 9080123	1932283	3" x 90 - 12.3	6
48015 1103151	1932317	3" x 110 - 15.1	3
48015 1104151	1932294	4" x 110 - 15.1	3
48015 1254171		4" x 125 - 17.1	1
48015 1255171		5" x 125 - 17.1	1
48015 1605211		5" x 160 - 21.1	1
48015 1606219		6" x 160 - 21.9	1

8030 T-connector



PN6 / heating / class15 / SDR 11.0

HELA ref.		Dimensions	Qty/box
48030 402537	1933280	1" x 1" x 40 - 3.7	25
48030 502546	1933281	1¼" x 1" x 50 - 4.6	20
48030 503246	1933282	1¼" x 1¼" x 50 - 4.6	20
48030 632558	1933283	1½" x 1" x 63 - 5.8	15
48030 633258	1933284	1½" x 1¼" x 63 - 5.8	15

PN10 / sanitary / class24 / SDR 7.4

HELA ref.		Dimensions	Qty/box
48030 402555	1933285	1" x 1" x 40 - 5.5	25
48030 502569	1933286	1¼" x 1" x 50 - 6.9	20
48030 503269	1933287	1¼" x 1¼" x 50 - 6.9	20
48030 632587	1933288	1½" x 1" x 63 - 8.7	15
48030 633287	1933289	1½" x 1¼" x 63 - 8.7	15

8032 Elbow female



PN6 / heating / class15 / SDR 11.0

HELA ref.		Dimensions	Qty/box
48032 322044		¾" x 32 - 4.4	30
48032 322544		1" x 32 - 4.4	30

8036 Elbow male



PN6 / heating / class15 / SDR 11.0

HELA ref.		Dimensions	Qty/box
48036 322544		1" x 32 - 4.4	30

8045 T-connector

			
PN6 / heating / class15 / SDR 11.0			
HELA ref.		Dimensions	Qty/box
48045 402537	1933231	40 x 1" x 40 - 3.7	20
48045 502546	1933247	50 x 1" x 50 - 4.6	15
48045 503246	1933248	50 x 1 1/4" x 50 - 4.6	15
48045 632558	1933262	63 x 1" x 63 - 5.8	10
48045 633258	1933263	63 x 1 1/4" x 63 - 5.8	10
PN10 / sanitary / class24 / SDR 7.4			
HELA ref.		Dimensions	Qty/box
48045 633287	1933274	63 x 1 1/4" x 63 - 8.7	10
48045 402555	1933270	40 x 1" x 40 - 5.5	20
48045 502569	1933271	50 x 1" x 50 - 6.9	15
48045 503269	1933272	50 x 1 1/4" x 50 - 6.9	15
48045 632587	1933273	63 x 1" x 63 - 8.7	10

8055 Welding connector

 			
PN6 / heating / class15 / SDR 11.0			
HELA ref.		Dimensions	Qty/box
48055 2523		25 x 2.3 - 27/24	50
48055 3230		32 x 3.0 - 33/27	50
48055 4037		40 x 3.7 - 42/35	30
48055 5046		50 x 4.6 - 45/37	25
48055 6358		63 x 5.8 - 57/49	15
48055 7569		75 x 6.8 - 76/66	10
48055 9082		90 x 8.2 - 89/79	6
48055 110100		110 x 10.0 - 110/100	3
48055 125114		125 x 11.4 - 114/104	1
48055 140127		140 x 12.7 - 139/123	1
48055 160146		160 x 14.6 - 159/135	1

8047 Reducing T-connector

			
HELA ref.		Dimensions	Qty/box
PN10 / sanitary / class24 / SDR 7.4			
48047 2532		25x3.5 - 3/4" - 32x4.4	30
48047 3240		32x4.4 - 3/4" - 40x5.5	25
48047 4050		40x5.5 - 1" - 50x6.9	20

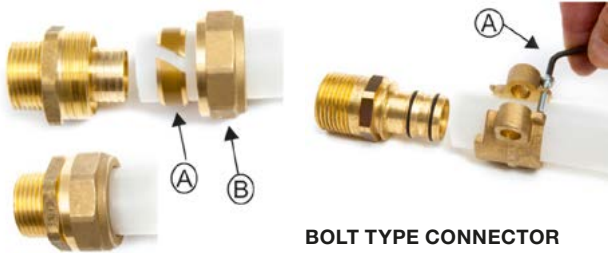
Assembly instructions: PEX pipe connectors, heating and sanitary

HELA PEX pipe connectors are suitable for sanitary, heating, irrigation, boreholes and snow melting systems. The installation procedure must always comply with local authorities' rules and regulations as well as any additional instructions and guidelines by the provider of the pipe system and/or other systems related.

Purpose of use and applicability

The connectors can be used in all PEX pipes as long as their outer diameter and wall thickness are suitable for the connectors. In general, the connectors are suitable for all applications and in all circumstances where PEX pipes can be used. In addition to water, the connectors are suitable for glycol-water in snow melting systems. Suitability should always be confirmed when liquids other than water or glycol-water are used.

Assembly instructions 15–160mm connectors



NUT TYPE CONNECTOR

- 1) Cut the pipe straight across.
- 2) Place the clamping ring (A) onto the pipe.
- 3) Push the pipe into the connector, tighten the nut (B) manually at first and then with a spanner for approximately 2.5 turns until you feel resistance.



BOLT TYPE CONNECTOR

- 1) Cut the pipe straight across and bevel the inner edge.
- 2) Remove the tightening bolt, spread the clamping sleeve with an allen wrench (A) and place it into the pipe as shown.
- 3) Lubricate the connector insert and the O-rings with a non-mineral-based lubricant.

- 4) Push the pipe to the bottom of the connector.
- 5) Place the clamping sleeve so that the tabs (A) align with the groove on the body.
- 6) Start tightening. Tighten periodically and allow the pipe to modify.
- 7) Ensure that the pipe stays in the bottom (B) at all times.

- 8) Tighten the bolt until the clamping sleeve halves (A) are flush with each other. When tightening connectors of 63mm or larger it is advisable to take breaks and allow the pipe to modify. Depending on the circumstances, large connectors may require breaks of 30 minutes or longer. The tightening bolt is lubricated at the factory but especially for larger (over 63mm) connectors, additional lubrication may be necessary. Do not use mineral-based lubricants as they will damage the EPDM O-rings.
- 9) The system must always be rinsed and pressure tested according to HELA pressure testing procedure or other accepted testing method.

Technical specifications



HELA connectors are safe choices for all applications. The external threads of HELA PEX connectors are ISO7-1 compliant tapered threads. The thread is compatible with the internal threads that comply with the ISO228 (cylindrical pipe thread) and ISO7 threads. NPT-threaded connectors are also available by order. HELA Operation and Safety Instructions as well as the assembly instructions contain more information on threads, their compatibility and sealing.

In addition to connectors made from special brass, we manufacture weldable steel frame PEX connectors and AISI 316 connectors in size categories 25–225mm.

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Pressure strength:	EN921, EN ISO 15875-5: 4.2
Negative pressure test:	EN12294, EN ISO 15875-5:4.7
Pressure variation test:	EN12295, EN ISO 15875-5:4.6
Temperature variation test:	EN12293, EN ISO 15875-5:4.5