

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 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.

APPLICATION	Pex pipe connectors according to ISO 15875-5
PRESSURE RATING	PN6 and PN10 (unless mentioned otherwise)
MATERIALS	CC770S / CW625N / CW5111L / CW617N (CEN/TS 13388)
CLAMPING BOLTS	AISI316
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

25-63 PM10-fittings also have a German DVGW-approval.



8010 // PEX double connector

PN6 / HEATING/CLASS15 / SDR 11,0

HELA ref.		Dimensions	Qty/box
480102523	1932018	25 x 2,3	50
480103230	1932341	32 x 2,9	30
480104037	1932342	40 x 3,7	25
480105046	1932343	50 x 4,6	20
480106358	1932344	63 x 5,8	10
480107568	1932345	75 x 6,8	7
480109082	1932346	90 x 8,2	3
48010110100	1932347	110 x 10,0	1
48010125114	1932348	125 x 11,4	1
48010140127	1932019	140x12.7	1
48010160146	1932350	160 x 14,6	1

PN10 / SANITARY/CLASS24 / SDR 7,4

HELA ref.		Dimensions	Qty/box
480102535	1932021	25 x 3,5	30
480102840	1932022	28 x 4,0	30
480103244	1932351	32 x 4,4	30
480104055	1932352	40 x 5,5	25
480105069	1932353	50 x 6,9	20
480106387	1932354	63 x 8,7	10
4801075103	1932355	75 x 10,3	7
4801090123	1932356	90 x 12,3	3
48010110151	1932357	110 x 15,1	1
48010125171	1932358	125 x 17,1	1
48010140192	1932023	140 x 19,2	1
48010160219	1932360	160 x 21,9	1



8015 // PEX-connector 15–32 mm

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-connector 32–160 mm

PN6 / HEATING/CLASS15 / SDR 11,0

HELA ref.		Dimensions	Qty/box
48015202020P	1932318	3/4" x 20 x 2,0	90
48015252023P	1932319	3/4" x 25 x 2,3	90
48015322530P	1932340	1" x 32 - 3,0	50
48015403237	1932209	1 1/4" x 40 - 3,7	30
48015503246	1932210	1 1/4" x 50 - 4,6	25
48015504046	1932314	1 1/2" x 50 - 4,6	25
48015635058	1932211	2" x 63 - 5,8	15
48015755068	1932315	2" x 75 - 6,8	10
48015756568	1932212	2 1/2" x 75 - 6,8	10
48015908082	1932213	3" x 90 - 8,2	6
480151103100	1932316	3" x 110 - 10,0	3
480151104100	1932214	4" x 110 - 10,0	3
480151254114	1932361	4" x 125 - 11,4	1
480151255114	1932362	5" x 125 - 11,4	1
480151405127	1932320	5" x 140 - 12,7	1
480151605146	1932363	5" x 160 - 14,6	1
480151606146	1932364	6" x 160 - 14,6	1

PN10 / SANITARY/CLASS24 / SDR 7,4

HELA ref.		Dimensions	Qty/box
48015222030P	1932321	3/4" x 22 - 3,0	50
48015252035P	1932322	3/4" x 25 - 3,5	50
48015282540P	1932323	1" x 28 - 4,0	50
48015322544P	1932238	1" x 32 - 4,4	50
48015403255	1932241	1 1/4" x 40 - 5,5	30
48015503269	1932247	1 1/4" x 50 - 6,9	25
48015504069	1932248	1 1/2" x 50 - 6,9	25
48015635087	1932263	2" x 63 - 8,7	15
480157550103	1932274	2" x 75 - 10,3	10
480157565103	1932275	2 1/2" x 75 - 10,3	10
480159080123	1932283	3" x 90 - 12,3	6
480151103151	1932317	3" x 110 - 15,1	3
480151104151	1932294	4" x 110 - 15,1	3
480151254171	1932365	4" x 125 - 17,1	1
480151255171	1932366	5" x 125 - 17,1	1
480151405192	1932324	5" x 140 - 19,2	1
480151605211	1932367	5" x 160 - 21,1	1
480151606219	1932368	6" x 160 - 21,9	1



8030 // T-connector female

PN6 / HEATING/CLASS15 / SDR 11,0

HELA ref.		Dimensions	Qty/box
48030402537	1933280	1" x 1" x 40 - 3,7	25
48030502546	1933281	1 1/4" x 1" x 50 - 4,6	20
48030503246	1933282	1 1/4" x 1 1/4" x 50 - 4,6	20
48030632558	1933283	1 1/2" x 1" x 63 - 5,8	15
48030633258	1933284	1 1/2" x 1 1/4" x 63 - 5,8	15

PN10 / SANITARY/CLASS24 / SDR 7,4

HELA ref.		Dimensions	Qty/box
48030402555	1933285	1" x 1" x 40 - 5,5	25
48030502569	1933286	1 1/4" x 1" x 50 - 6,9	20
48030503269	1933287	1 1/4" x 1 1/4" x 50 - 6,9	20
48030632587	1933288	1 1/2" x 1" x 63 - 8,7	15
48030633287	1933289	1 1/2" x 1 1/4" x 63 - 8,7	15



8032 // Elbow female

PN10 / SANITARY/CLASS24 / SDR 7,4

HELA ref.		Dimensions	Qty/box
48032203244	1935100	3/4" x 32 - 4,4	30
48032253244	1935101	1" x 32 - 4,4	30



8036 // Elbow male

PN6 / HEATING/CLASS15 / SDR 11,0

HELTA ref.		Dimensions	Qty/box
48036202530	1935103	3/4 x 25 - 3,0	30

PN10 / SANITARY/CLASS24 / SDR 7,4

HELTA ref.		Dimensions	Qty/box
48036253244	1935102	1" x 32 - 4,4	30



8047 // Reducing T-connector

PN10 / SANITARY/CLASS24 / SDR 7,4

HELTA ref.		Dimensions	Qty/box
480472532	1933275	25x3,5 - 3/4" - 32x4,4	30
480473240	1933276	32x4,4 - 3/4" - 40x5,5	25
480474050	1933277	40x5,5 - 1" - 50x6,9	20



8045 // T-connector

PN6 / HEATING/CLASS15 / SDR 11,0

HELTA ref.		Dimensions	Qty/box
48045402537	1933231	40 x 1" x 40 - 3,7	20
48045502546	1933247	50 x 1" x 50 - 4,6	15
48045503246	1933248	50 x 1¼" x 50 - 4,6	15
48045632558	1933262	63 x 1" x 63 - 5,8	10
48045633258	1933263	63 x 1¼" x 63 - 5,8	10

PN10 / SANITARY/CLASS24 / SDR 7,4

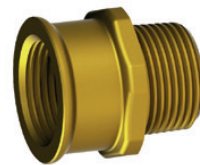
HELTA ref.		Dimensions	Qty/box
48045633287	1933274	63 x 1¼" x 63 - 8,7	10
48045402555	1933270	40 x 1" x 40 - 5,5	20
48045502569	1933271	50 x 1" x 50 - 6,9	15
48045503269	1933272	50 x 1¼" x 50 - 6,9	15
48045632587	1933273	63 x 1" x 63 - 8,7	10



8055 // Welding connector

PN6 / HEATING/CLASS15 / SDR 11,0

HELTA ref.		Dimensions	Qty/box
480552523	1938308	25 x 2,3 - 27/24	50
480553230	1938309	32 x 3,0 - 33/27	50
480554037	1938310	40 x 3,7 - 42/35	30
480555046	1938311	50 x 4,6 - 45/37	25
480556358	1938312	63 x 5,8 - 57/49	15
480557569	1938313	75 x 6,8 - 76/66	10
480559082	1938314	90 x 8,2 - 89/79	6
48055110100	1938315	110 x 10,0 - 110/100	3
48055125114	1938316	125 x 11,4 - 114/104	1
48055140127	1938317	140 x 12,7 - 139/123	1
48055160146	1938318	160 x 14,6 - 159/135	1



8090 // Anchoring connector

HELTA ref.		Dimensions	Qty/box
4809020	1938300	3/4" f/m	160
4809025	1938301	1" f/m	80
4809032	1938302	1¼" f/m	60
4809040	1938303	1½" f/m	52
4809050	1938304	2" f/m	32
4809065	1938305	2½" f/m	16
4809080	1938306	3" f/m	16
4809095	1938307	4" f/m	8

ASSEMBLY INSTRUCTIONS

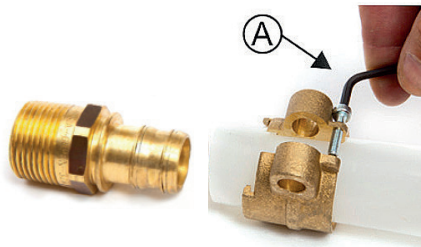
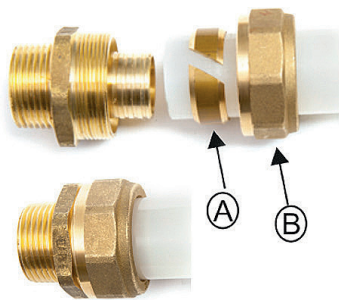
PEX pipe connectors, heating and sanitary

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.

15–160 mm connectors

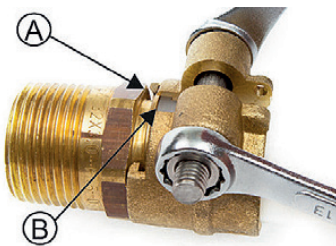


Bolt type connector

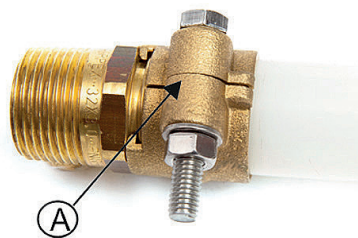
- 1 Cut the pipe straight across and bevel the inner edge.
- 2 Remove the tightening bolt, spread the clamping sleeve with an allen wrench (A) and place it into the pipe as shown.
- 3 Lubricate the connector insert with a non-mineral-based lubricant.

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.



- 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.
- 9 The system must always be rinsed and pressure tested according to HELA pressure testing procedure or other accepted testing method.



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 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.