GF Piping Systems

+GF+

Technical Catalogue 2015

PRIMOFIT

Compression Fittings and Repair Systems



PRIMOFIT - Features

- PRIMOFIT compression fittings are pre-assembled, dismantling is not required
- Minimum pipe preparation
- End-load resistant (push and pull-out), a fixing of the pipe is not required
- Made out of malleable cast iron, with hot dip galvanised or black finish
- Quick assembly - low costs
- No special tools necessary
- Angular deflection of the pipe possible - up to 3° for each PRIMOFIT compression fitting joint. By using a PRIMOFIT coupling (two compression joints) a deflection of max. 6° is possible.
- PRIMOFIT compression joint can be loosened
- Small and compact fitting
- Design of fitting bodies and nuts allow the use of shrink sleeves
- Electric conductive, can be used for cathodic corrosion protection and potential equalisation

PRIMOFIT Application Gas





Product range see page 7, 13, 17,19, 21, 27, 31, 33

PRIMOFIT Application Water







Product range see page 7, 17, 23, 25, 27, 31, 33, 35

PRIMOFIT Application Heating



Note: Also transitions to Butt weld tubes available.



Product range see page 13 and 17

PRIMOFIT Application Compressed Air



Product range see page 7, 13, 35, 37

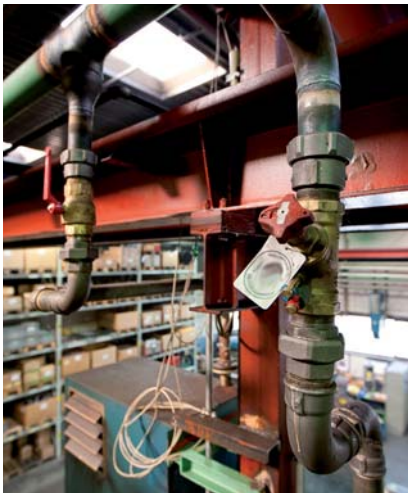
PRIMOFIT as transition for different pipe materials:

steel pipe, Butt weld tube (“Siederohr”), lead pipe, PE-pipe and PE-Xa-pipe



Product range see page 17, 23, 25, 27, 31, 33

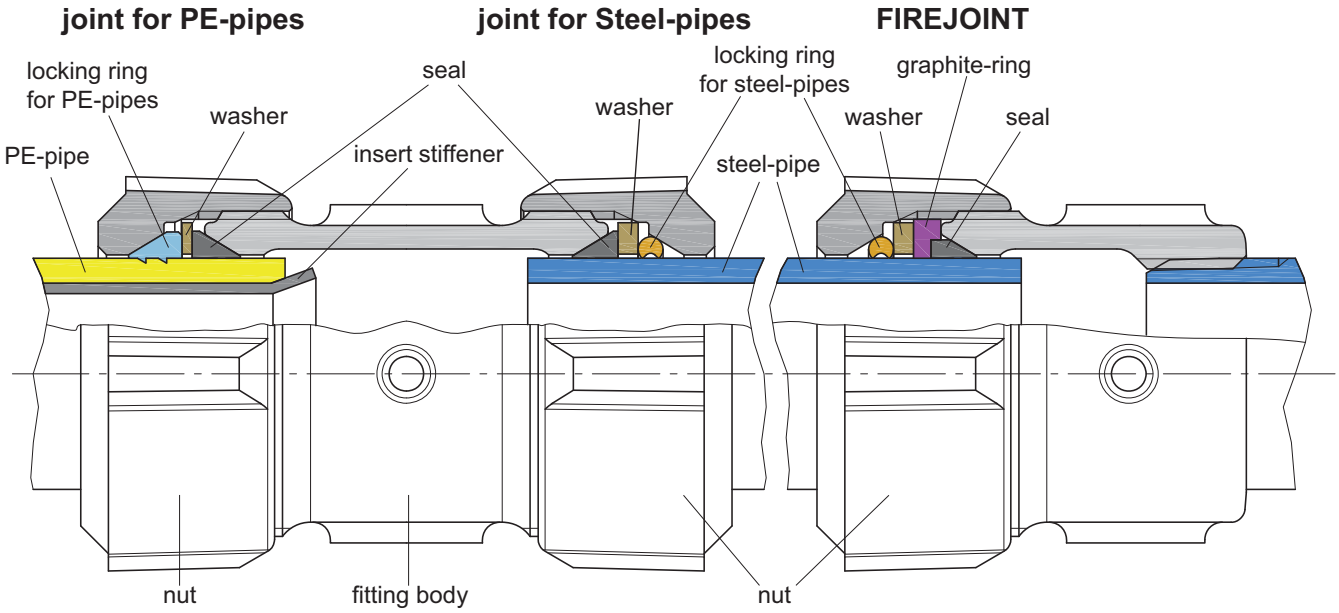
PRIMOFIT fits everywhere – the perfect solution for building technology, utilities and industry







The PRIMOFIT System



Application chart

	Sealing material	Medium	max. Pressure [bar]	max. Temp. [°C]	Colour Code *
Steel Pipe	NBR	Gas	10	-20 to +60	
		Water	16	80	
		Drinking Water	16	35	●
		Compressed Air	16	80	
		Oil	16	80	
	EPDM **	Water	16	40	●
	FPM	Fuels	10	40	
		Heating Water / Steam	10	105/150 ***	●
		Compressed Air	16	105/150 ***	
	NBR+Graphite	Gas	5	-20 to +60	●
PE/PE-Xa Pipe	NBR	Gas	5 / 7 / 8 ****	40	
		Water	16	40	●
		Drinking Water	16	35	
	EPDM **	Water	16	40	●
	FPM	Fuels	10	40	●

* The colour code of the label on the plastic bag and of the fitting instruction is related to the rubber seal material.
** EPDM only as Spare Pack available, please note that they are discontinued items and available as long as our stock will last.
*** Georg Fischer has introduced a new FPM material, which can be used up to 150°C. Until the replacement (stock clearings) of the current FPM material the corresponding operating temperature given on the fitting instruction, has to be considered.
**** DVGW/SVGW ... 5 bar, GIS/PL3 (UK) ... 7 bar, GASTEC ... 8 bar

Overview - compression fitting dimension, pipe diameters for equal compression fitting bodies and diameter of the minimum bore

	Nominal diameter DN Fittings dimension		10 ⅜	15 ½	20 ¾	25 1	32 1 ¼	40 1 ½	50 2	65 2 ½	80 3	100 4
Nominal outer diameter	Steel pipe	mm	17,2	21,3	26,9	33,7	42,4	48,3	60,3	76,1	88,9	114,3
	Tolerance range	*mm*	*16,7 - 17,5*	*21,0 - 21,8*	*26,5 - 27,3*	*33,3 - 34,2*	*42,0 - 42,9*	*47,9 - 48,8*	*59,7 - 60,8*	*75,3 - 76,6*	*88,0 - 89,5*	*113,1 - 115,0*
	Butt weld tubes *	mm	-	20,0 ±0,5	25,0 ±0,5	31,8 ±0,5	38,0 ±0,5	44,5 ±0,5	51,0 ±0,5 57,0 ±0,5 63,5 ±0,6	70,0 ±0,7	-	-
	Tolerance range											
	PE pipe	mm	-	20	25	32	40	50	63	-	-	-
	Tolerance range	*mm*		*20,0 - 20,3*	*25,0 - 20,3*	*32,0 - 32,3*	*40,0 - 40,4*	*50,0 - 50,4*	*63,0 - 63,4*			
	Lead pipe	mm	-	18,3 - 21,9	23,9 - 27,4	27,3 - 30,9 30,9 - 34,4	36,5 - 37,6 39,6 - 43,1	45,8 - 46,9 47,5 - 50,7	53,1 - 55,4 56,5 - 57,5 60,4 - 63,8	-	-	-
	Minimum bore**	mm	7,9	11,6	16,6	22,7	30,9	36,3	46,8	61,5	72,2	95,3
	Thread size	inch	⅜	½	¾	1	1 ¼	1 ½	2	2 ½	3	4

* only Spare Packs available;
for Butt weld tubes 63.5mm an individual compression fitting is needed. It cannot be combined with the standard 2" compression fitting!
** complies to the minimum clear bore of the male adaptor. At all other fitting types the inside diameter of the pipe will be the minimum clear bore.

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Abbreviations

Steel	for connecting of steel pipes
PE/PE-Xa	for connecting of PE/PE-Xa pipes
Lead	for connecting of lead pipes
Dim. PE	dimension polyethylene pipe
Dim. St	dimension steel pipe
Dim. Pb	dimension lead pipe
Dim. Rp	dimension parallel female thread acc. to EN 10226-1 and/or ISO 7-1
Dim. R	dimension taper male thread acc. to EN 10226-1 and/or ISO 7-1
Code	Georg Fischer item code
GP	quantity per carton
Weight	piece weight in kg
NBR	nitrile butadiene rubber
EPDM	ethylene propylene diene monomer rubber
FPM	fluorinated propylene monomer rubber (fluoro elastomer)
PE-Xa	cross-linked polyethylene pipe
POM	polyoxymethylene
SDR	standard dimension ratio (pipe diameter / wall thickness ratio)
S	pipe series
D	biggest fitting diameter
L	overall length (face-to-face dimension)
x	insertion depth of the pipe

Comments to the product range section

Technical data and remarks are given at the beginning of each product range section.
Please consider working conditions.

The technical data given in this publication are for general information purpose only.
They imply no warranty of whatever kind. Subject to modifications.
Please consult our general terms and conditions of supply.

General Product Information

Product and Production

PRIMOFIT compression fitting bodies and nuts according to EN 10284 and prEN10344 are made out of white heart malleable cast iron type EN-GJMW-400-5 according to EN 1562 and comply with the Design Symbol A.

Design Symbol	Type of material acc. EN 1562 permitted acc. to EN 10284 / prEN10344
A	EN-GJMW-400-5 EN-GJMB-350-10
B	EN-GJMW-350-4 EN-GJMB-300-6

PRIMOFIT compression fittings are supplied in black or hot dip galvanised finish, covered with a preservation for temporary prevention from rust. Hot dip galvanizing is done in accordance with EN 10284 and prEN 10344.

Jointing threads – designated with R and Rp – on adaptor fittings and tees are according to EN 10226-1 respectively ISO 7-1.

To cover a wide range of applications different rubber seal materials are supplied: NBR, NBR+graphite, EPDM and FPM. To distinguish from other seals FPM seals are coloured green instead of black.

All PRIMOFIT compression fittings are single packed in plastic bags including the fitting instruction.
The colour code of the label on the plastic bag and of the fitting instruction is related to the rubber seal material.

Seal material	**Colour code**
NBR	yellow
EPDM	blue
FPM	green
NBR+graphite (FIREJOINT)	red

Pressure Equipment Directive (PED) 2014/68/EU

PRIMOFIT compression fittings are no pressure equipment in terms of the directive, therefore a CE-marking in accordance to the directive is not foreseen.
PRIMOFIT compression fittings are components of pressure equipment which fulfil the requirements of EN 10284 resp. prEN 10344 and the Pressure Equipment Directive – within the operating limits specified in EN 10284 resp. prEN 10344.
PRIMOFIT compression fittings may be used only for fluids which are compatible with the material malleable cast iron in either hot dip galvanised or black finish, respectively the sealing rubber. On request Georg Fischer issues a works certificate 2.2, together with a manufacturer declaration.

Certificates

Georg Fischer runs a quality management system according to EN ISO 9001, an environmental management system according to EN ISO 14001 and a health and safety management system according to OHSAS 18001.
All certificates are available on request

www.fittings.at/contactform

For major applications, especially in gas and drinking water applications several national certificates are available.
For the actual list of certificates please refer to our homepage

www.fittings.at/approvals

Reuse of PRIMOFIT compression fittings

For reuse of the PRIMOFIT compression fitting, seal, washer and locking ring has to be replaced. For this purpose spare packs are available separately.
Fitting body and nut can be reused if no mechanical damages, wear or corrosion is visible.

Jointing steel pipes (Product Range "Steel x Steel")

This assortment of compression fittings according to prEN 10344, depending on application is suitable to joint black or galvanized steel pipes according to EN 10255 and EN 10220-series 1 with measurements according to ISO 65.
For some dimensions of Butt weld tubes (“Siederohr”), series 2 and 3 spare packs are available.

PRIMOFIT FIREJOINT is a special product which offers resistance against fire impact from outside according to German DVGW and according to British Gas test procedures.
For the application gas inside a building PRIMOFIT FIREJOINT has to be used.
To distinguish the FIREJOINT from other PRIMOFIT compression fittings, the FIREJOINT nut has a golden colour!

Jointing PE and PE-Xa pipes (Product Range "Steel x PE/PE-Xa" and "PE/PE-Xa x PE/PE-Xa")

Transition fittings jointing steel to PE pipes as well as compression fittings to joint PE with PE pipes are available.
Compression fittings according to EN 10284 for connection of polyethylene pipes according to EN 1555-2 (gas) and EN 12201-2 (water) with material PE 100, PE 80 or cross-linked polyethylene pipe PE-Xa according to EN ISO 15875-2, for details see table on page 43.
To choose the correct compression fitting, please pay attention to the wall thickness given in the tables (choose correct SDR-series).
All compression fittings of this assortment are suitable for PE 80 (PE-MD), PE 100 (PE-HD) as well as for PE-Xa.
An insert stiffener is included for each PE / PE-Xa connection and has to be used.

Jointing Lead pipes

Compression fittings according to prEN 10344 for connection of pressurised lead pipes with measurements according to the table given on page 42.
According to the “council directive 98/83/EC on the quality of water intended for human consumption” all existing lead pipes have to be replaced from drinking water systems.
PRIMOFIT compression fittings should be used only for repair of existing lead pipes and enable a temporary service until the final replacement of the lead pipe.
Depending on type of installation lead pipes could be in different conditions, therefore following recommendations have to be considered for jointing lead pipes:

- the surface of the lead pipe in the area of insertion has to be free of damages or dirt
- the outer diameter of the lead pipe has to be within the diameter range mentioned on the label of the bag respectively in the table with the lead pipe dimensions
- the ovality of the lead pipe may not exceed 1mm (= the difference between minimum and maximum outer diameter)
- the insertion depth and the number of turns to tighten the nut are mentioned in the attached coloured fitting instruction. For lead pipes use the values of the appropriate PE-pipe sizes (e.g. lead pipe 30mm use values for PE-pipe 32mm)
- after installation a pressure test according to national standards has to be done to check for leakage. The test pressure has to be at least 1,5 times nominal pressure (1,5xPN) or 10 bar (whichever is the higher value) .

Use of PRIMOFIT Compression Fittings below ground

If PRIMOFIT Compression fittings are used below ground, they have to be permanently protected against corrosion. The corrosion protection needs to meet the requirements of EN 12068 (“Cathodic protection - External organic coatings for the corrosion protection of buried or immersed steel pipelines used in conjunction with cathodic protection - Tapes and shrinkable materials”), as well as national standards and general regulations or laying guidelines.
Additionally construction specifications of energy supplier or engineering offices need to be considered.

The used corrosion protection products should be approved according to the above mentioned standard.

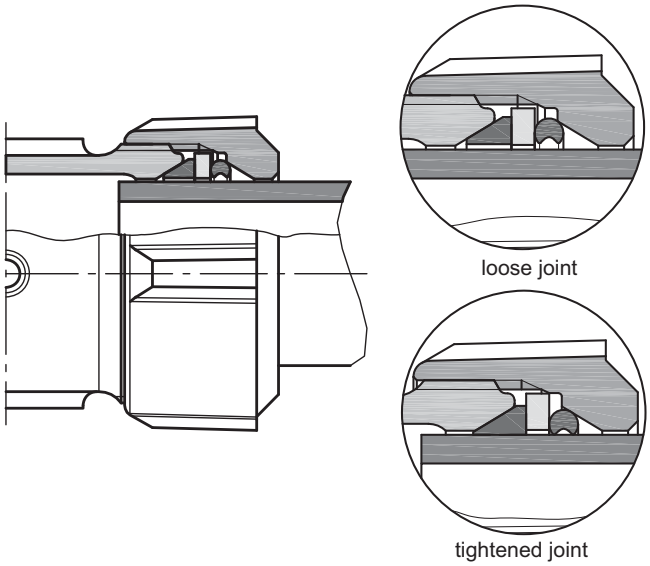
Use of PRIMOFIT Compression Fittings in masonry (flush-mounted)

If PRIMOFIT Compression fittings are used in masonry, they have to be permanently protected against corrosion. The corrosion protection needs to meet the requirements of national standard and general regulations or laying guidelines.
Additionally construction specifications of energy supplier or engineering offices need to be considered.

Jointing Technique - Compression

Jointing Steel pipes

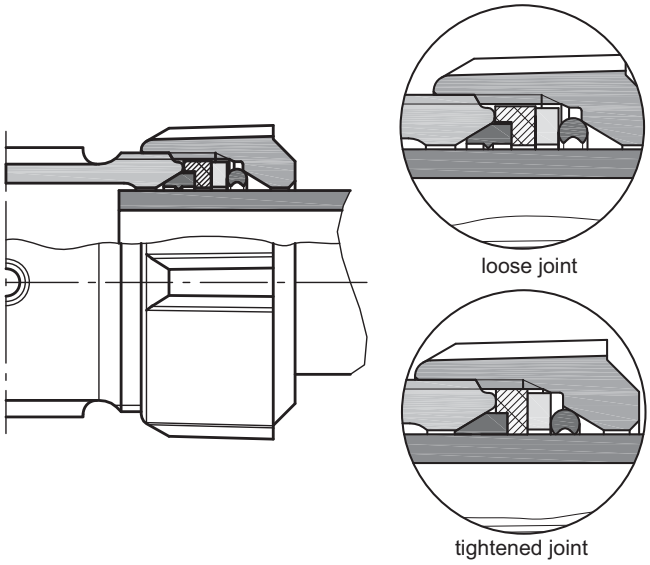
In pre-assembled condition of PRIMOFIT compression fittings, the inner diameter of the internal components seal, washer and locking ring are bigger than the maximum outer diameter of the pipe. Therefore pipe insertion without dismantling is granted.
Tightening the nut has two functions: As a first step to press the seal into the space between conical surface of the fitting body and the outer surface of the pipe. As a second step to force the locking ring to enable end-load resistance.



PRIMOFIT FIREJOINT for jointing Steel pipes

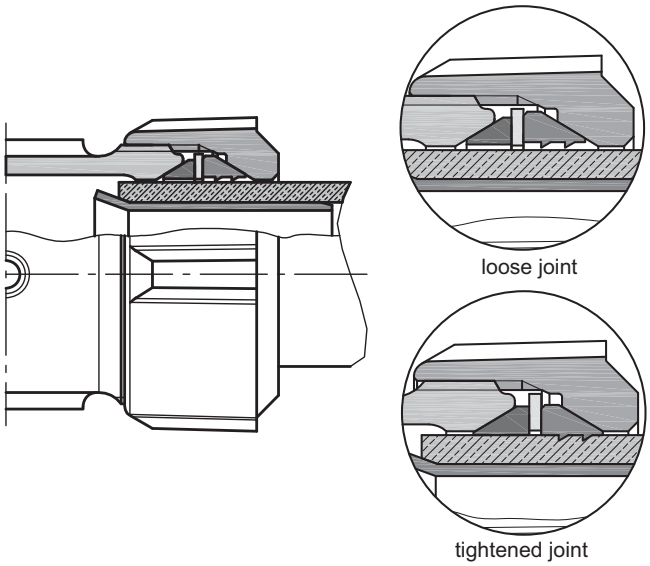
(Application gas inside a building, fire resistant)

The system of the PRIMOFIT FIREJOINT fittings is similar to Primofit compression fittings for jointing steel pipes but includes an additional graphite ring. These fittings are designed for gas application inside a building to fulfil testing requirements in terms of temperature resistance in case of fire.
The additional graphite ring ensures end-load resistance and leaktightness in case of fire.
To ensure leaktightness under normal working conditions a NBR seal is placed onto the graphite ring.



Jointing PE, PE-Xa and Lead pipes

The system is similar to the PRIMOFIT compression fittings jointing steel pipes. The major difference is to use an insert stiffener which is designed to fit into the inner diameter of the pipe. Insert stiffeners support the PE/PE-Xa pipe against radial forces.
Seal, washer and locking ring are designed to fit to the mechanical properties and to the outer diameter of the pipes.
Please note the special shape of the locking ring for PE/PE-Xa pipes and lead pipes.
The connection allows a certain flexibility and misalignment in tightened condition.
Note: Jointing lead pipes is similar to jointing PE/PE-Xa pipes but without using an insert stiffener.



Applications

Working conditions

PRIMOFIT is an end-load resistant compression fitting. Each compression joint allows a misalignment up to 3° between pipe and compression fitting.
Due to the modular concept of PRIMOFIT the compression fittings can be easily converted for other applications and other pipe materials by using a spare pack (change seal, washer and locking ring).

For the different applications please refer to the individual appropriate international, European or national application standards or to regulations of the local utility company. These may also restrict below operation limits.
To choose the right seal material (NBR, EPDM, FPM or NBR+graphite) and the appropriate surface (black or galvanised) is essential for the specific application. The selection can be done by using the table below.

	Seal	Medium	max. working pressure [bar]	max. working temperature [°C]	Surface[1]
Steel Pipe	NBR	Gas[2]	10	70	black or galvanised
		Water	16	80	galvanised
		Drinking Water[3]	16	35	galvanised
		Compressed Air	16	80	black or galvanised
		Oil	16	80	black or galvanised
	EPDM	Water	16	40	galvanised
	FPM	Fuels[4]	10	40	black or galvanised
		Heating Water/Steam[5][6]	10	105/150[7]	balck
		Compressed Air	16	105/150[7]	black or galvanised
	NBR+graphite[8]	Gas[2]	5	70	black or galvanised
PE Pipe[9]	NBR	Gas[2]	5 / 7 / 8[10]	40	black or galvanised
		Water	16	40	galvanised
		Drinking Water[3]	16	35	galvanised
	EPDM	Water	16	40	galvanised
	FPM	Fuels[5]	10	40	black or galvanised

For Lead pipes compression fittings can be used at max. 10 bar/60°C for the medium water (surface galvanised).

ad 1 **Surface:** for selection national application standards and regulations of local utility companies have to be considered – especially if both versions (black and galvanised) are available.

ad 2 **Gas:** natural gas and liquid gas (LPG) (for jointing PE/PE-Xa pipes not approved in all countries).

ad 3 **Drinking water:** For planning and installation of drinking water piping the standard EN 806-2 has to be considered. Details to avoid corrosion of galvanised iron materials are given in EN 12502-3.
With regard to hygienic aspects of drinking water materials there are no harmonized European Regulations available at the moment. Regulations for this aspect are therefore subject to national regulations, which have to be considered for planning and installation of PRIMOFIT fittings.
The Georg Fischer recommendation (according to DIN 50930-6 and ÖNORM B 5014-3) is to use PRIMOFIT compression fittings, made of hot dip galvanised malleable cast iron for:
Drinking water with an acidity of $K_{B8,2} \leq 0{,}2$ mmol/l, a coefficient $S_1 < 1$ up and up to a water temperature of 35 °C.

In case of repair or amendment of an existing drinking water installation to a limited extent, parameters deviating from the above are allowed if positive experience during the previous operation is existing and a positive hygienic analyses of the drinking water can be provided. As a general rule in this context a water temperature of 60°C should not be exceeded. Georg Fischer offers advice in such cases.

ad 4 **Fuels:** diesel, leaded petrol and unleaded petrol.

ad 5 **Heating water:** heating water also includes water-based liquids in ventilation and air conditioning systems.
When using antifreeze fluids containing glycol fittings with black surface and FPM seal are recommended.

ad 6 **Heating water with FPM:** if the maximum operating temperature does not exceed 80°C also NBR seals can be used.

ad 7 **FPM up to 150°C:** Georg Fischer has introduced a new FPM material, which can be used up to 150°C.
Until the replacement (stock clearings) of the current FPM material the corresponding operating temperature given on the fitting instruction, has to be considered.

ad 8 **Gas installations:** for the application gas inside a building the product PRIMOFIT FIREJOINT has to be used (fire resistant compression fitting according to German DVGW and British Gas testing procedures).

ad 9 **PE/PE-Xa pipes:** working conditions (temperature and pressure) have to be based on pressure/temperature diagram of PE/PE-Xa pipes. The maximum working pressure depends on the PE/PE-Xa-pipe specification (SDR-series), for details see table on page 43.

ad 10 **Gas approvals for PE/PE-Xa-pipes:** DVGW/SVGW ... 5 bar, GIS/PL3 ... 7 bar, GASTEC ... 8 bar

Pipe Specification

The pipes to be jointed, have to comply to the following tables.

Overview - compression fitting dimension, pipe diameters for equal compression fitting bodies and diameter of the minimum bore

	Nominal diameter DN Fittings dimension		10 ⅜	15 ½	20 ¾	25 1	32 1 ¼	40 1 ½	50 2	65 2 ½	80 3	100 4
Nominal outer diameter	Steel pipe	mm	17,2	21,3	26,9	33,7	42,4	48,3	60,3	76,1	88,9	114,3
	Tolerance range	*mm*	*16,7 - 17,5*	*21,0 - 21,8*	*26,5 - 27,3*	*33,3 - 34,2*	*42,0 - 42,9*	*47,9 - 48,8*	*59,7 - 60,8*	*75,3 - 76,6*	*88,0 - 89,5*	*113,1 - 115,0*
	Butt weld tubes * *Tolerance range*	mm	-	20,0 ±*0,5*	25,0 ±*0,5*	31,8 ±*0,5*	38,0 ±*0,5*	44,5 ±*0,5*	51,0 ±*0,5* 57,0 ±*0,5* 63,5 ±*0,6*	70,0 ±*0,7*	-	-
	PE pipe *Tolerance range*	mm *mm*	-	20 *20,0 - 20,3*	25 *25,0 - 20,3*	32 *32,0 - 32,3*	40 *40,0 - 40,4*	50 *50,0 - 50,4*	63 *63,0 - 63,4*	-	-	-
	Lead pipe	mm	-	18,3 - 21,9	23,9 - 27,4	27,3 - 30,9 30,9 - 34,4	36,5 - 37,6 39,6 - 43,1	45,8 - 46,9 47,5 - 50,7	53,1 - 55,4 56,5 - 57,5 60,4 - 63,8	-	-	-
	Minimum bore**	mm	7,9	11,6	16,6	22,7	30,9	36,3	46,8	61,5	72,2	95,3
	Thread size	inch	⅜	½	¾	1	1 ¼	1 ½	2	2 ½	3	4

* only Spare Packs available;
for Butt weld tubes 63.5mm an individual compression fitting is needed. It cannot be combined with the standard 2" compression fitting!

** complies to the minimum clear bore of the male adaptor.
At all other fitting types the inside diameter of the pipe will be the minimum clear bore.

Steel pipes: Threaded pipes according to EN 10255 (former DIN 2440, DIN 2441, BS 1387), Butt weld tubes according to EN 10220-S1 (former DIN 2448/2458-S1, BS 3600)

Thread size Nominal diameter DN		⅜ 10	½ 15	¾ 20	1 25	1 ¼ 32	1 ½ 40	2 50	2 ½ 65	3 80	4 100
Threaded pipes EN 10255											
Nominal outside diameter	mm	17,2	21,3	26,9	33,7	42,4	48,3	60,3	76,1	88,9	114,3
Surface area of the pipe	ca. m^2/m	0,054	0,067	0,085	0,106	0,133	0,152	0,189	0,239	0,279	0,359
Light tubes L2											
Wall thickness	ca. mm	1,8	2,0	2,3	2,6	2,6	2,9	2,9	3,2	3,2	3,6
Inside diameter	ca. mm	13,6	17,3	22,3	28,5	37,2	42,5	54,5	69,7	82,5	107,1
Clear opening	ca. cm^2	1,45	2,35	3,91	6,38	10,87	14,19	23,33	38,16	53,46	90,09
Capacity	ca. l/m	0,145	0,235	0,391	0,638	1,087	1,419	2,333	3,816	5,346	9,009
Pipe mass, plain end black pipe	ca. kg/m	0,670	0,947	1,38	1,98	2,54	3,23	4,08	5,71	6,72	9,75
Medium tubes M											
Wall thickness	ca. mm	2,3	2,6	2,6	3,2	3,2	3,2	3,6	3,6	4,0	4,5
Inside diameter	ca. mm	12,6	16,1	21,7	27,3	36,0	41,9	53,1	68,9	80,9	105,3
Clear opening	ca. cm^2	1,25	2,04	3,70	5,85	10,18	13,79	22,15	37,28	51,40	87,09
Capacity	ca. l/m	0,125	0,204	0,370	0,585	1,018	1,379	2,215	3,728	5,140	8,709
Pipe mass, plain end black pipe	ca. kg/m	0,839	1,21	1,56	2,41	3,10	3,56	5,03	6,42	8,36	12,2
Heavy tubes H											
Wall thickness	ca. mm	2,9	3,2	3,2	4,0	4,0	4,0	4,5	4,5	5,0	5,4
Inside diameter	ca. mm	11,4	14,9	20,5	25,7	34,4	40,3	51,3	67,1	78,9	103,5
Clear opening	ca. cm^2	1,02	1,74	3,30	5,19	9,29	12,76	20,67	35,36	48,89	84,13
Capacity	ca. l/m	0,102	0,174	0,330	0,519	0,929	1,276	2,067	3,536	4,889	8,413
Pipe mass, plain end black pipe	ca. kg/m	1,02	1,44	1,87	2,93	3,79	4,37	6,19	7,93	10,3	14,5
Butt weld tubes EN 10220-S1 *											
Outside diameter	mm	17,2	21,3	26,9	33,7	42,4	48,3	60,3	76,1	88,9	114,3
Wall thickness	ca. mm	1,8	2,0	2,3	2,6	2,6	2,6	2,9	2,9	3,2	3,6
Inside diameter	ca. mm	13,6	17,3	22,3	28,5	37,2	43,1	54,5	70,3	82,5	107,1
Clear opening	ca. cm^2	1,45	2,35	3,91	6,38	10,87	14,59	23,33	38,82	53,46	90,09
Capacity	ca. l/m	0,145	0,235	0,391	0,683	1,087	1,459	2,333	3,882	5,346	9,009
Pipe mass, plain end black pipe	ca. kg/m	0,684	0,952	1,40	1,99	2,55	2,93	4,11	5,24	6,76	9,83

* Supplementory to serie 1, there are Spare Packs for Butt weld tubes with diameter 20, 25, 31.8, 38, 44.5, 57 and 70mm available.

Maximum working pressures of PE-pipes and PE-Xa pipes

Pressure range, bar	EN 12201-2 (water)		EN 1555-2 (gas)		DIN 8074*		EN ISO 15875-2**
Pipe specification	PE 80	PE 100	PE 80	PE 100	PE 80	PE 100	PE-Xa
SDR 7,4/S 3,2	20	25	-	-	16	25	-
SDR 11/S 5	12,5	16	4	5	10	16	12,5
SDR 17/S 8	8	10	-	-	6,2	10	-
SDR 17,6/S 8,3	-	-	1	-	6,0	9,6	-

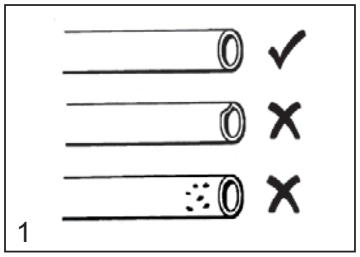
* C=1,6 , 50 years , T_B=20°C
** C=1,5 , 100 years, T_B=50°C

Common PE-pipe and PE-Xa pipe series according to EN 1555-2, EN 12201-2, DIN 8074 and EN ISO 15875-2

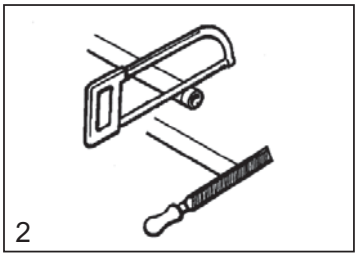
Nominal outside diameter, Da		20	25	32	40	50	63
SDR 7,4/S 3,2 acc. EN 12201-2 (water)							
Wall thickness	ca. mm	3,0	3,5	4,4	5,5	6,9	8,6
Inside diameter	ca. mm	14,0	18,0	23,2	29,0	36,2	45,8
Clear opening	ca. cm^2	1,54	2,54	4,23	6,61	10,29	16,47
Capacity	ca. l/m	0,154	0,254	0,423	0,661	1,029	1,647
Pipe mass	ca. kg/m	0,160	0,238	0,383	0,596	0,930	1,464
SDR 7,4/S 3,2 acc. DIN 8074							
Wall thickness	ca. mm	2,8	3,5	4,4	5,5	6,9	8,6
Inside diameter	ca. mm	14,4	18,0	23,2	29,0	36,2	45,8
Clear opening	ca. cm^2	1,63	2,54	4,23	6,61	10,29	16,47
Capacity	ca. l/m	0,163	0,254	0,423	0,661	1,029	1,647
Pipe mass	ca. kg/m	0,154	0,238	0,383	0,596	0,930	1,464
SDR 11/S 5 acc. EN 1555-2 (gas)							
Wall thickness	ca. mm	3,0	3,0*	3,0*	3,7	4,6	5,8
Inside diameter	ca. mm	14,0	19,0	26,0	32,6	40,8	51,4
Clear opening	ca. cm^2	1,54	2,84	5,31	8,35	13,07	20,75
Capacity	ca. l/m	0,154	0,284	0,531	0,835	1,307	2,075
Pipe mass	ca. kg/m	0,160	0,208	0,275	0,425	0,660	1,043
SDR 11/S 5 acc. EN 12201-2 (water)							
Wall thickness	ca. mm	2,0	2,3	3,0	3,7	4,6	5,8
Inside diameter	ca. mm	16,0	20,4	26,0	32,6	40,8	51,4
Clear opening	ca. cm^2	2,01	3,27	5,31	8,35	13,07	20,75
Capacity	ca. l/m	0,201	0,327	0,531	0,835	1,307	2,075
Pipe mass	ca. kg/m	0,115	0,168	0,275	0,425	0,660	1,043
SDR 11/S 5 acc. DIN 8074/EN ISO 15875-2							
Wall thickness	ca. mm	1,9	2,3	2,9	3,7	4,6	5,8
Inside diameter	ca. mm	16,2	20,4	26,2	32,6	40,8	51,4
Clear opening	ca. cm^2	2,06	3,27	5,39	8,35	13,07	20,75
Capacity	ca. l/m	0,206	0,327	0,539	0,835	1,307	2,075
Pipe mass	ca. kg/m	0,112	0,171	0,272	0,425	0,660	1,043
SDR 17/S 8 acc. EN 12201-2 (water)							
Wall thickness	ca. mm	-	-	2,0	2,4	3,0	3,8
Inside diameter	ca. mm	-	-	28,0	35,2	44,0	55,4
Clear opening	ca. cm^2	-	-	6,16	9,73	15,21	24,11
Capacity	ca. l/m	-	-	0,616	0,973	1,521	2,411
Pipe mass	ca. kg/m	-	-	0,192	0,290	0,447	0,713
SDR 17/S 8 acc. DIN 8074							
Wall thickness	ca. mm	-	1,8	1,9	2,4	3,0	3,8
Inside diameter	ca. mm	-	21,4	28,2	35,2	44,0	55,4
Clear opening	ca. cm^2	-	3,60	6,25	9,73	15,21	24,11
Capacity	ca. l/m	-	0,360	0,625	0,973	1,521	2,411
Pipe mass	ca. kg/m	-	0,137	0,187	0,290	0,447	0,713
SDR 17,6/S 8,3 acc. EN 1555-2 (gas)							
Wall thickness	ca. mm	2,3	2,3	2,3	2,3	2,9	3,6
Inside diameter	ca. mm	15,4	20,4	27,4	35,4	44,2	55,8
Clear opening	ca. cm^2	1,86	3,27	5,90	9,84	15,34	24,45
Capacity	ca. l/m	0,186	0,327	0,590	0,984	1,534	2,445
Pipe mass	ca. kg/m	0,131	0,168	0,220	0,280	0,434	0,680
SDR 17,6/S 8,3 acc. EN 12201-2 (water)							
Wall thickness	ca. mm	-	-	2,0	2,3	2,9	3,6
Inside diameter	ca. mm	-	-	28,0	35,4	44,2	55,8
Clear opening	ca. cm^2	-	-	6,16	9,84	15,34	24,45
Capacity	ca. l/m	-	-	0,616	0,984	1,534	2,445
Pipe mass	ca. kg/m	-	-	0,192	0,280	0,434	0,680
SDR 17,6/S 8,3 acc. DIN 8074							
Wall thickness	ca. mm	-	-	1,8	2,3	2,9	3,6
Inside diameter	ca. mm	-	-	28,4	35,4	44,2	55,8
Clear opening	ca. cm^2	-	-	6,33	9,84	15,34	24,45
Capacity	ca. l/m	-	-	0,633	0,984	1,534	2,445
Pipe mass	ca. kg/m	-	-	0,179	0,280	0,434	0,680

* For nominal outside diameter (Da) 25 and 32 s=2,0mm allowed for existing pipe installations <0,1 bar.

PRIMOFIT Fitting Instruction

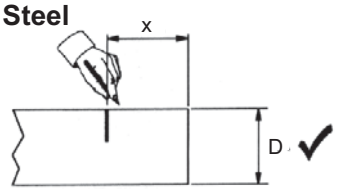


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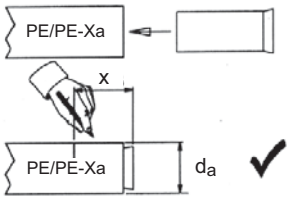
Steel



D	Ø [mm]	x
⅜	17,2	32mm ± 2
½	21,3	32mm ± 2
¾	26,9	32mm ± 2
1	33,7	32mm ± 2
1¼	42,4	33mm ± 3
1½	48,3	35mm ± 3
2	60,3	39mm ± 3
2½	76,1	70mm ± 5
3	88,9	70mm ± 5

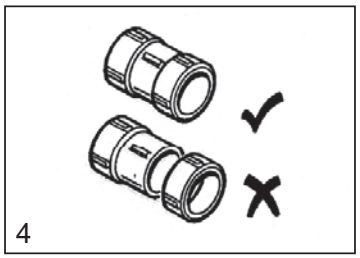
3

PE/PE-Xa

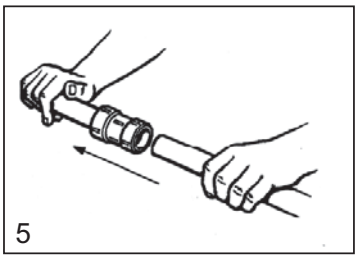


d_a	x
20	32mm ± 1
25	32mm ± 1
32	32mm ± 1
40	35mm ± 3
50	39mm ± 4
63	43mm ± 4

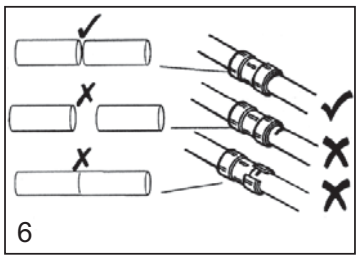
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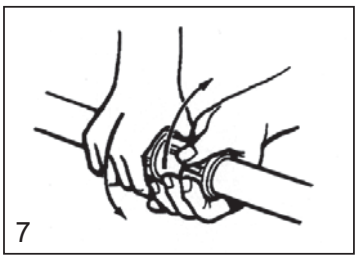
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5



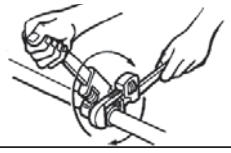
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7

Steel

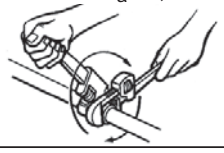
- **» 1 x 360°** ⅜, ½, ¾
- **» 1½ x 360°** 1, 1¼, 1½, 2, 3
- **» 2 x 360°** 2½



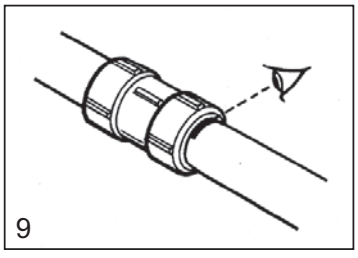
8

PE/PE-Xa

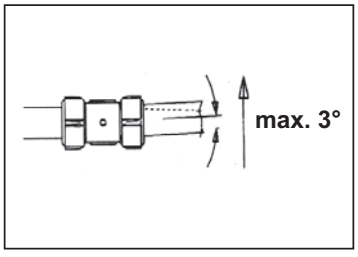
- **» 1½ x 360°** d_a 20
- **» 2½ x 360°** d_a 25, 32, 40
- **» 2¾ x 360°** d_a 50, 63



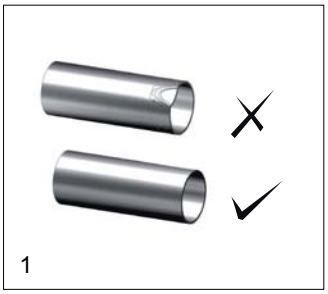
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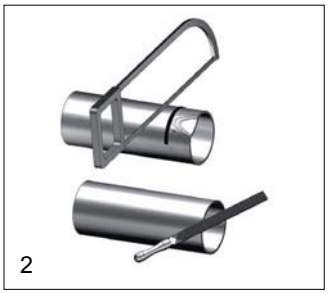


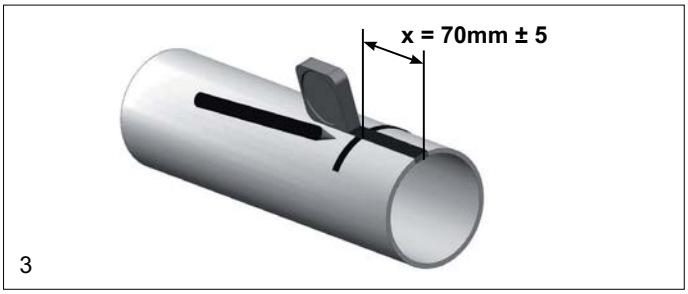
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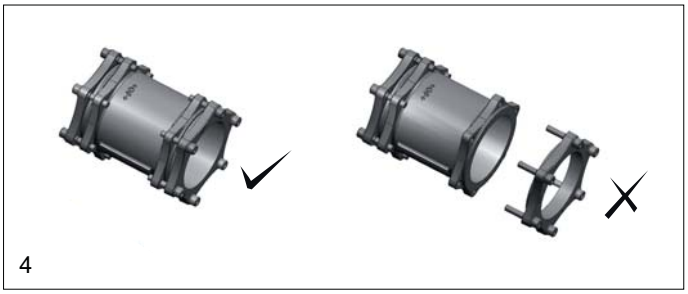
PRIMOFIT Fitting Instruction 4 inch

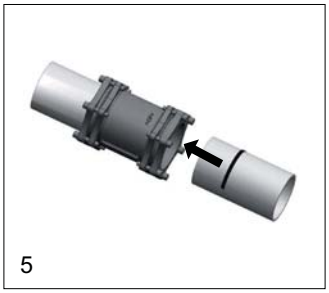

1

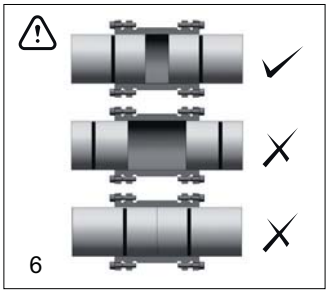

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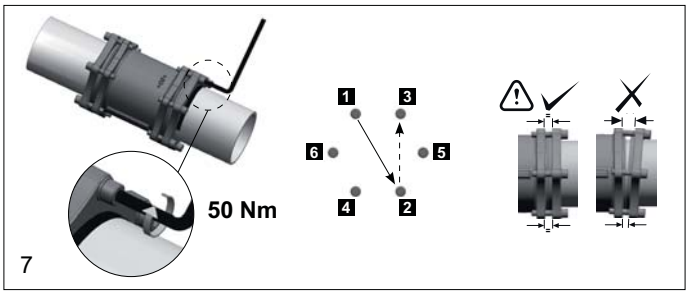


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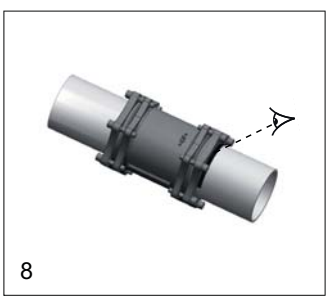

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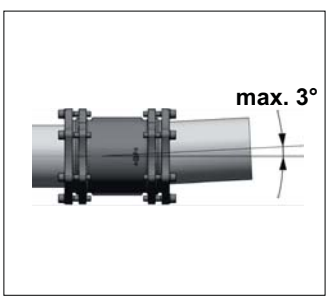

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8



General terms and conditions of Georg Fischer Fittings GmbH, Traisen

according to 08/2015

1 Scope

1.1 These general conditions of sale apply to all deliveries of Georg Fischer Fittings-GmbH, A-3160 Traisen ("Georg Fischer") to the Buyer.
They shall also apply to all future transactions even if reference is not made explicitly to these general conditions of sale.

1.1 Provisions which deviate from or supplement these conditions of sale, in particular the Buyer's general conditions of purchase or verbal agreements, are not accepted by Georg Fischer, unless this has been confirmed in writing by Georg Fischer. These general conditions of sale even apply if Georg Fischer unconditionally makes the delivery in knowledge of Buyer's conflicting terms and conditions.

1.3 All forms of dispatch which enable proof of transmission in the form of a text, such as e.g. telefax, e-mail, etc. shall be deemed to be on a par with communi-cations in written form.

2 Offers

Georg Fischer's offers are not binding, unless agreed otherwise in writing. An order shall only be deemed accepted by Georg Fischer if confirmed in writing and if the order confirmation was received by Buyer.

3 Scope of Delivery

3.1 Georg Fischer reserves the right to introduce modifications to its range of products.

3.2 The order confirmation shall govern the scope and execution of the contract.

3.3 If the column „SP" of the current addition of the Sales Catalogue "Program and Index values" shows a specific quantity, such quantity reflects the minimum order quantity.

4 Data and Documentation

4.1 Technical documentation such as drawings, descriptions, illustrations, any indications of measurements, properties or weight and reference to norms shall serve the purpose of providing information only and do not contain any guarantees with respect to properties.
If and when it appears timely in view of technical progress Georg Fischer reserves the right to make appropriate modifications.

4.2 All technical documentation remains the intellectual property of Georg Fischer and may only be used for the purposes agreed upon or for the purposes indicated by Georg Fischer.

5 Confidentiality, Data Protection

5.1 Each party shall treat as confidential all non-public commercial or technical information pertaining to the other party of which it gains knowledge in the course of its business relationship with the other party. Such information shall neither be disclosed to third parties nor used for other purposes than those for which the information has been supplied.

5.2 Within the context of the contractual relationship with the Buyer the processing of personal data may be required. The Buyer hereby grants his approval in this respect and accepts that Georg Fischer may also disclose such data to third parties (e.g. sub-contractors) in Austria and abroad for the purpose of handling and maintaining business relations.

6 Regulations at the Place of Destination, Export Controls

6.1 The Buyer must draw the attention of Georg Fischer to local provisions of law or other regulations which refer to the execution of delivery and compliance with safety regulations and approval procedures.

6.2 In case of re-exports, the Buyer shall be responsible for compliance with pertinent export control regulations.

7 Price

7.1 Unless agreed otherwise, the prices shall be deemed quoted ex works according to Incoterms 2010 of the ICC(or latest edition), incl. standard packaging. All additional charges such as costs for freight, insurance, export, transit, import or other permits as well as legalisations ("Ancillary Costs") shall be borne by the Buyer. Likewise the Buyer shall bear the costs of all taxes, levies, charges and customs duties.

7.2 Upon request Buyer shall be provided with the Ancillary Costs accruing for the respective products, with the order confirmation at the latest.

8 Terms of Payment

8.1 Payments are to be made by the Buyer at the place in which the Georg Fischer company that issues
the invoice is located without any deductions such as cash discount, expenses, taxes and fees, in accordance with terms of payment agreed upon. Invoices are payable within 14 days net, unless otherwise agreed.

8.2 The Buyer shall only have a right of set-off and a right of retention with respect to claims which are either undisputed or have been established as being binding in law. In particular payments are also to be made if unessential parts of the delivery are still outstanding, provided that the use of the delivery is not rendered impossible as a result.

9 Reservation of Title

9.1 The delivered products shall remain the property of Georg Fischer until the Buyer has settled all claims which accrue to Georg Fischer against the Buyer at the time of the delivery.

9.2 Should the Buyer in the ordinary course of business resell any products to which title is reserved, the Buyer hereby internally assigns to Georg Fischer those rights which accrue to the Buyer against his customers arising out of the sale of products including all collateral rights, securities and reservations of title until Buyer has paid all of Georg Fischer's receivables, irrespective of whether the products were resold without or after processing. If the Buyer is in default with his payment obligations, he has to inform Georg Fischer about the assignment of claims and the applicable debtors, to provide all information necessary to collect the debt, hand over the relevant documentation and notify the debtors of the assignment. Until revoked by Georg Fischer, this assignment shall not preclude the Buyer's right to collect the assigned receivables.

9.3 If the value of the goods subject to the afore-mentioned retention of title - together with collateral securities provided to Georg Fischer - exceeds Georg Fischer's claims against the Buyer by more than 20%, Georg Fischer shall re-assign the rights mentioned under Section 9.2 to the Buyer at his request.

9.4 With the processing, combination and mixing of the products with other goods Georg Fischer acquires the co-ownership in the new good in proportion of the value of the Georg Fischer products in which title is reserved (final invoice amount incl. VAT) to the other processed, combined or mixed goods.

9.5 Should Buyer be in breach of contract, in particular payment default, Georg Fischer shall be entitled to take back the goods in which title is reserved after having issued a reminder and the Buyer is obliged to surrender such products.

10 Delivery

10.1 Delivery dates indicated by Georg Fischer are not binding, unless explicitly stated otherwise in the order confirmation explicitly. Any binding term of delivery begins as soon as the contract has been entered into, all official formalities such as permits for import and payment have been obtained and all essential technical issues have been settled. It shall be considered as met when the delivery is ready for dispatch.

10.2 The obligation to deliver is subject to the following conditions, i.e. the term of delivery will be extended or the delivery date will be postponed by a reasonable period of time:
a) if Georg Fischer does not receive in time the information necessary for the execution of the order or if subsequent changes causing delays are made by the Buyer;
b) if Georg Fischer is prevented from performing the delivery by an occurrence of force majeure. Force majeure shall equally be deemed to consist of unforeseeable circumstances for which Georg Fischer is not to be held responsible which make it unreasonably difficult or impossible for Georg Fischer to make the delivery, such as delays in deliveries or defective deliveries from the designated suppliers, industrial action, official measures, a shortage of raw materials or energy, significant disruptions of operations, for example by destruction of the plant as a whole or of important departments or as a result of the breakdown of essential facilities, serious transport hold-ups, e.g. as a result of road blockades. If these circumstances prevail for over six (6) months, both parties shall have the right to withdraw from the contract. The Buyer shall not be entitled to claim compensation for damages;
c) if the Buyer is in default in performance of its contractual obligations, in particular if it does not comply with the terms of payment or does not pro-vide the securities agreed upon in a timely manner.

10.3 If Georg Fischer is to be held responsible for exceeding the agreed term of delivery (including a reasonable extension thereof), Georg Fischer shall not be deemed in default until the Buyer has granted to Georg Fischer in writing a reasonable extension thereof of not less than one (1) month which equally is not met. Thereafter the Buyer shall be entitled to the remedies provided by law. Subject to limitations of Section 16, any claim the Buyer may have to compensation for damages for delay shall, however, be limited to a maximum of 10% of the price of the delayed delivery.

10.4 Partial deliveries shall be allowed. Georg Fischer may issue partial invoices for partial deliveries.

10.5 If the Buyer does not take in time delivery of goods which have been notified as been ready for dispatch, Georg Fischer shall be entitled to store the goods at the expense and at the risk of the Buyer and to invoice the goods as having been delivered. If the Buyer fails to effect payment, Georg Fischer shall in particular be entitled to dispose otherwise of the goods.

10.6 In the event that the Buyer cancels an order and Georg Fischer does not insist on performance of the contract, Georg Fischer shall be entitled to a penalty amounting to 10% of the contract price (forfeited penalty), as well as to damages in excess of this amount for which proof is submitted. The Buyer shall be entitled to provide evidence that Georg Fischer actually has suffered no damage or that its damage is considerably lower than the penalty forfeited.

11 Packaging

If the products are packaged in a way which is above and beyond the standard packaging, the extra packaging in question will be charged additionally.

12 Passing of Risk

12.1 The risk passes to the Buyer as soon as they have left Georg Fischer's works (EX WORKS, Incoterms 2010 ICC, or latest version), even if delivery is at Georg Fischer's the expense, under similar clauses or including installation or when carriage is organised and managed by Georg Fischer.

12.2 If delivery is delayed for reasons for which Georg Fischer is not to be held responsible, the risk shall pass to the Buyer upon notification that the goods are ready for dispatch.

13 Shipment and Insurance

13.1 Unless agreed otherwise, the Buyer shall bear the cost of carriage.

13.2 Insurance against damages of any kind whatsoever shall be the Buyer's responsibility. Even when insurance is arranged by Georg Fischer, it shall be deemed to have been taken out by order and for the account of the Buyer.

13.3 Any special requests regarding carriage and insurance shall be communicated to Georg Fischer in due time. Otherwise carriage shall be arranged by Georg Fischer at Georg Fischer's discretion – without, however, assuming responsibility – by the fastest and most cost-efficient method possible.
If it is individually agreed, that Georg Fischer bears the shipping costs, transport arrangements shall be made by Georg Fischer. If the Buyer issues special instructions in this connection, any additional costs will be charged to the Buyer.

13.4 In the event of damage to or loss of products during carriage, the Buyer shall mark the delivery documents accordingly and immediately have the damage ascertained by the carrier.
Not readily ascertainable damages incurred during carriage shall be notified to the carrier within six (6) workdays after receipt of the products.

14 Inspection and Acceptance of Delivery

14.1 The products are tested by Georg Fischer during manufacture to the usual extent. If the Buyer wishes more extensive testing, such tests must be agreed upon in writing and are to be paid by the Buyer.

14.2 The Buyer undertakes to comply with its statutory obligations of inspection and notice obligations. Defects in respect of weight, number of items or the external appearance and workmanship of the products must be reported by the latest five (5) workdays after receipt thereof. The Buyer must give
written notice of other defects immediately after discovery, in any case, however, within the agreed period of warranty. Notice of defects must be made in writing.

14.3 Defective parts must in any case be kept until claims under warranty or claims to compensation for damage have been finally clarified and must be made available to Georg Fischer upon request.

14.4 If so requested, Georg Fischer is to be given the opportunity to appraise the defect and/or the damage – either by itself or by third party experts - prior to commencement of repair work.

15 Liability for Defects

15.1 Upon receipt of a written request of the Buyer, Georg Fischer undertakes (at its own choice) to repair or replace as soon as possible and free of charge all products which it can be proven have become defective or unusable due to poor materials, faulty design, faulty workmanship, faulty operating or installation instructions.
In order to protect employees from toxic or radioactive substances which may have been transported through defective parts returned to Georg Fischer's sales organisation, said parts must be accompanied by a Material Safety Dis-closure Form. The form may be obtained from Georg Fischer's local sales company or via www.piping.georgfischer.com.
Parts which are replaced become the property of Georg Fischer, unless Georg Fischer waives such claim.

15.2 For products which are manufactured according to the Buyer's specifications, drawings or models, Georg Fischer's warranty is limited to proper materials and workmanship.

15.3 The Buyer is entitled to require rescission of the contract or a reduction of the contract price, if
- it is impossible to carry out a repair or make a subsequent delivery;
- Georg Fischer does not succeed in carrying out the repair or making a subsequent delivery within a reasonable period of time or
- Georg Fischer refuses to carry out the repair or make a subsequent delivery or is negligent in causing a delay in this respect.

15.4 For products or essential components manufactured by third party, Georg Fischer's warranty is limited to the warranty provided by said third party.

15.5 The warranty shall not apply to defects and damage in cases of insignificant deviations from the agreed quality or resulting from natural wear and tear, inadequate storage or maintenance, non-compliance with operating and assembly instructions, overloading, unsuitable operational supplements, defective construction work, unsuitable building ground, inappropriate repairs or alterations by the Buyer or third parties, use of non-original spare parts and other reasons for which Georg Fischer is not to be held responsible.

15.6 Claims based on warranty or liability shall become time-barred twelve (12) months after receipt of the delivery by the end user, at the latest, however, eighteen (18) months after dispatch of the delivery by Georg Fischer.

15.7 For Products that are customarily used for a building and caused such building's defectiveness or for products, which find application in underground pipeline construction,
a) Georg Fischer assumes in connection with the subsequent performance the proportionate dismantling and assembly costs for the restoration of the original state of the affected object as well as – in cases of negligence – all other direct damages (personal injury and property damage). Section 16, however, applies accordingly, and
b) in deviation of Section 15.6 warranty and liability claims, expire five (5) years after installation, but not later than seven (7) years after the manufacturing date.
Thereby, Georg Fischer assumes the costs of dismantling and assembly costs for the restoration of the original state of the affected object up to a maximum of € 730.000 per occurrence; this liability shall, moreover, be limited to an overall maximum of € 2.000.000 in the case of serial losses. This limitation shall not apply in cases of intent or blatant gross negligence on the part of Georg Fischer.

16 Limitation of Liability

Only in instances of intent and blatant gross negligence shall Georg Fischer (including his officers, his employees and other vicarious agents) be liable for breach of contractual and extra-contractual obligations, in particular due to frustration, delay, demonstrable false advice, pre-contractual liability. This disclaimer applies in particular to the liability of indirect and consequential damages, such as loss of production, loss of orders, claims for compensation by third parties and loss of profits.
Insofar Georg Fischer's liability thereby exists it is limited to foreseeable, typically occurring damage.
If one Party claims a breach of contract by the other party, it must take all necessary measures to mitigate the damage caused thereby, provided that this can be done with economically reasonable means.
If the party concerned does not comply with its duty to mitigate damages, the other party may demand adequate reduction of its obligation to pay damages.
This limitation of liability does not apply to any culpable infringement of essential contractual obligations, the lack of assured properties as well as in cases of compulsory liability according to the product liability law applicable to the respective product delivered.

17 Severability

Should certain provisions in these general conditions of sale in whole or in part be or become invalid or null and void, the contracting parties undertake to replace the invalid or null and void provision with a valid provision which comes as close as possible to fulfilling the meaning and purpose of the invalid or null and void provision.

18 Place of Performance and Place of Jurisdiction

18.1 Place of performance for the products shall be the Georg Fischer works from which the products are despatched.

18.2 **If any disputes arise out of the contractual relationship, the lawsuit is to be filed exclusively with the competent court in St. Pölten, Austria. Georg Fischer is, however, also entitled to bring an action before any other competent court.**

18.3 **The contractual relationship is subject to Austrian law (excluding the choice of law principles thereof and the United Nations Convention on Contracts for the International Sale of Goods) in accordance with the Austrian Code of Civil Law (ABGB) and the Austrian Code of Commercial Law (HGB).**

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www.gfps.com
www.fittings.at

Production / Sales in Austria
Georg Fischer Fittings GmbH
Mariazeller Strasse 75
A-3160 Traisen
Tel. +43(0)2762 90300-371
Fax +43(0)2762/90300-432
primofit.ps@georgfischer.com
www.fittings.at

Belgium / Luxembourg
Georg Fischer NV/SA
Vaartdijk 109-111 Digue du Canal
B-1070 Bruxelles/Brüssel
Tel. +32(0)2/556 40 20
Fax +32(0)2/524 34 26
be.ps@georgfischer.com
www.gfps.com/be

Denmark
Georg Fischer A/S
Malervej 4DK-2630 Taastrup
Tel. +45(0)70 22 19-75
Fax +45(0)70 22 19-76
info.dk.ps@georgfischer.com
www.gfps.com/dk

France
Georg Fischer SAS
Bâtiment Le Rabelais
Paris Nord 2
22 Avenue des Nations
BP 88026 Villepinte
F-95932 Roissy Charles
de Gaulle Cedex
Tel. +33(0)1/41 84 68 84
Fax +33(0)1/41 84 68 85
fr.ps@georgfischer.com
www.gfps.com/fr

Germany
Georg Fischer GmbH
Daimlerstrasse 6
D-73095 Albershausen
Tel. +49(0)7161/302-0
Fax +49(0)7161/302-259
info.de.ps@georgfischer.com
www.gfps.com/de

Italy
Georg Fischer S.p.A.
Via Sondrio 1
I-20063 Cernusco S/N (MI)
Tel. +39(0)2/921 861
Fax +39(0)2/921 862 47
it.ps@georgfischer.com
www.gfps.com/it

Netherlands
Georg Fischer N.V.
Lange Veenteweg 19
NL-8161 PA Epe
Tel. +31(0)578/678 222
Fax +31(0)578/621 768
nl.ps@georgfischer.com
www.gfps.com/nl

Norway
Georg Fischer AS
Rudsletta 97
N-1351 Rud
Tel. +47(0)67 18 29 00
Fax +47(0)67 13 92 92
no.ps@georgfischer.com
www.gfps.com/no

Spain
Georg Fischer S.A.
Paseo de la Castellana 184
7ª Planta
E-28046 Madrid
Tel. +34(0)91/781 98 90
Fax +34(0)91/426 08 23
es.ps@georgfischer.com
www.gfps.com/es

Sweden
Georg Fischer AB
Lijeholmsstranden 5
SE-11743 Stockholm
Tel. +46(0)8 506 775 00
Fax +46(0)8 749 237 0
info.se.ps@georgfischer.com
www.gfps.com/se

Switzerland
Georg Fischer
Rohrleitungssysteme (Schweiz) AG
Ebnatstrasse 101
CH-8201 Schaffhausen
Tel. +41(0)52 631 30 26
Fax +41(0)52 631 28 96
ch.ps@georgfischer.com
www.gfps.com/ch

United Kingdom
George Fischer Sales Limited
Paradise Way
Coventry, CV2 2ST
Tel. +44(0)2476 535 535
Fax +44(0)2476 530 450
uk.ps@georgfischer.com
www.gfps.com/uk

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