1 - Ensure pipe end is cut square. Otherwise re-cut the pipe in the right way and debur inside and outside edges.

2 - Lubricate thread and locking ring. Check that the nut follows the entire length of thread without unnecessary force.

3 - Fit the locking ring, locking nut and finally push the pipe against the stop.

4 - Screw in manually the locking ring until stop. Using a one meter lever wrench, rotate the nut 2 turns, until the knife edge on the locking ring engraves the pipe.

5 - Unscrew completely the locking nut and carry out the following checks:
   a) verify that the ring has engraved the whole pipe circumference.
   b) verify that the ring has raised a small lip about 5 mm from the end of the pipe.

6 - Replace and tighten the locking nut as per point 4.