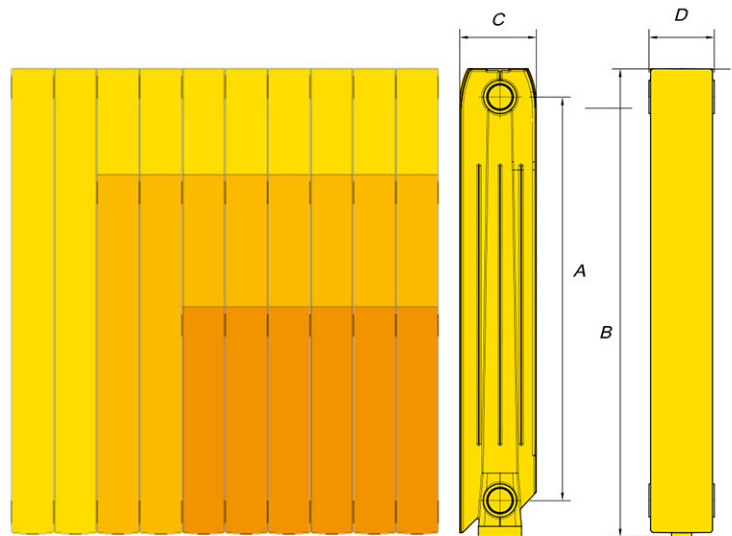


## Alliance Aluminium radiator joining instructions



### Specifications

Material: Die cast aluminium  
Connections: 1" nipples  
Operating Pressure: 6 bar  
pH: 6 to 8.5  
Max Temperature: 90°C

Guarantee for 10 years once installed in accordance with instructions.

### General

The pH values must be between 6.5 and 8.5. Within these values, the aluminium surface will be sealed and protected from any corrosion. In all cases, it is preferable to use specific corrosion inhibitors, please contact RVR for advice.

The presence of corrosive waters in the system will make the warranty null and void.

The heating circuit must be supplied with a suitable earth connection, in compliance with Standards.

For wall positioning or under windows the following DISTANCES are recommended:

From the floor: 120 mm

From the wall: 30 mm

From the shelf/window sill: 120 mm.

Every set of radiators installed must be equipped with an automatic or manual air vent valve.

The radiators are die-cast aluminium, therefore they must be HANDLED WITH CARE during assembly.

### Care & Maintenance

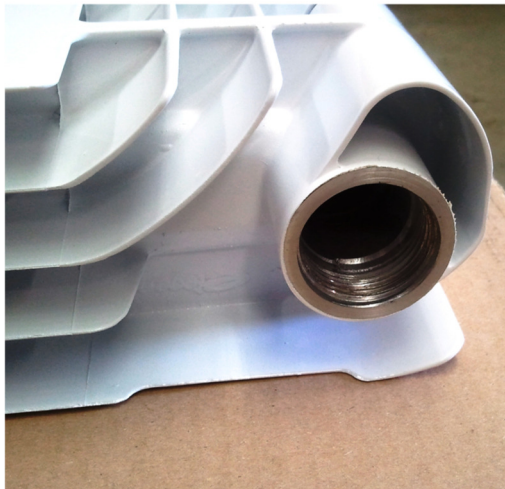
The radiators are protected and finished on the surface with a double coat of paint, one integral with anaphoresis application methods, and one in epoxy polyester powder with electrostatic deposit. Therefore they cannot be readjusted or other paints applied.

To clean the surface USE NEUTRAL NON-ABRASIVE PRODUCTS. It is also recommended NOT TO COVER THE RADIATOR with damp cloths, wet clothing or porous objects.

ATT: If the radiator must be bled very often, contact your technician or our technical dept. directly.

The radiators produced by INDUSTRIE PASOTTI S.p.A. are guaranteed if used in compliance with the relevant standards and if installed by qualified staff with respect to the code of practice. The warranty covers the radiator from any manufacturing faults. The warranty comes into force on the date of the purchase document. Working pressure is certified according to the EN 442/1/2 Standard.

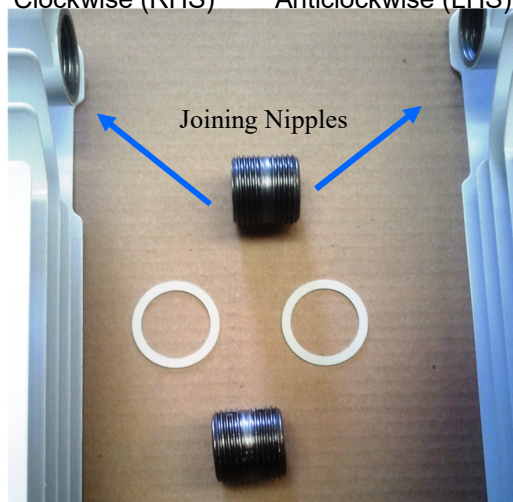
## Step by Step Guide to Joining Radiators



*Please Note: Images shown are for demonstration purposes, actual product design may be different to that shown.*

Radiator must be laid on a flat surface before commencing joining. (See figure 1)  
 The joining surface must be clean. The surface can be painted or unpainted from the factory. If it's painted make sure that the paint is not chipped.  
 If chipped paint is present, surface must be sanded to ensure a clean surface.  
 If the surface is painted clean with no chips, that is satisfactory.

Clockwise (RHS)      Anticlockwise (LHS)      **Figure 1**—Top of radiator



The radiators must be joined using 1 seal for each nipple, which is to be fitted dry. The nipple is to be turned clockwise on the right hand side and to be turned anti-clockwise on the left hand side.

**Figure 2**—Joining Nipples



Position radiators together with nipple threads just located together and not turned in.  
 Pull the two radiators together.  
 Mark the depth of the radiator on the joining key.

**Figure 3**—nipples and seals in place



Mark the depth of the radiator on the joining key.

**Figure 4** —Joining key



Tighten top and bottom of radiator evenly by turning nipples a small bit at a time alternating between top and bottom to ensure that they are joined evenly.

**Figure 5** —Tighten radiators

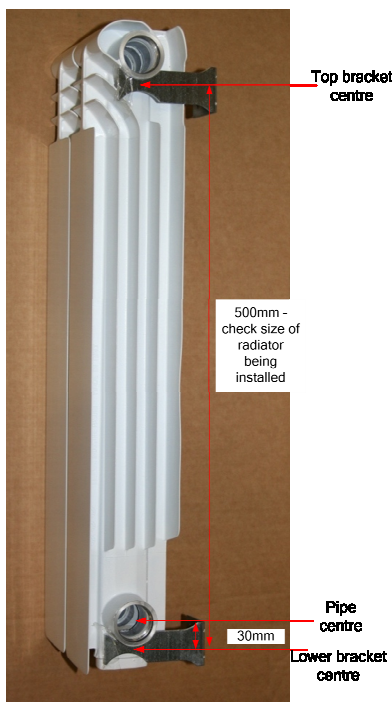


Uneven tightening can result in damaged mating surfaces, resulting in leaks see figure 6.

Take care to tighten the nipples on top and bottom evenly.

**Figure 6** —Uneven tightening

## Mounting Radiators



Angle wall brackets, (SRP902) are used to mount the radiator to the wall.

Four brackets are required per radiator. If you are mounting a radiator which has been joined, then 6 brackets are required.

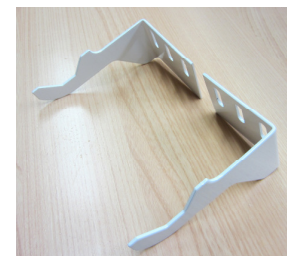
There is a left and a right bracket.

They must be positioned between the radiator sections, i.e. 81mm from edge of radiator.

To work out the vertical position of the brackets, first calculate the distance between the floor and the centre of the lower pipe, feeding into the lower header of the radiator.

The drilling distance on lower bracket is 30mm down from the lower header pipe centre.

The centre of the top bracket is either 350/500/700 mm up from the lower bracket, depending on which size radiator is being installed.



**Figure 7**—Wall bracket

**Figure 8** —Cutaway section of 500mm radiator, showing bracket mounting distances.

**Radiator Specifications**  
CE  
442-1 Radiators and Convectors

Model	No of Sections	Height (mm)	Width (mm)	Distance between Centres	Depth (mm)	Output@ $\Delta T 50 \text{ } ^\circ\text{C}$ (W)	Output@ $\Delta T 30 \text{ } ^\circ\text{C}$ (W)	Water Content (L)	Max Operating Pressure (bar)
Alliance 350	4	430	320	350	95	368	192	1	6
Alliance 350	8	430	640	350	95	736	384	2	6
Alliance 350	10	430	800	350	95	920	480	2.5	6
Alliance 350	12	430	960	350	95	1104	576	3	6
Alliance 500	4	580	320	500	95	496	244	1.36	6
Alliance 500	8	580	640	500	95	992	488	2.72	6
Alliance 500	10	580	800	500	95	1240	610	3.4	6
Alliance 500	12	580	960	500	95	1488	732	4.08	6
Alliance 600	4	680	320	600	95	568	288	1.56	6
Alliance 600	8	680	640	600	95	1135	576	3.12	6
Alliance 600	10	680	800	600	95	1420	720	3.9	6
Alliance 600	12	680	960	600	95	1704	864	4.68	6
Alliance 800	4	880	320	800	95	708	348	1.96	6
Alliance 800	8	880	640	800	95	1416	696	3.92	6
Alliance 800	10	880	800	800	95	1770	870	4.9	6
Alliance 800	12	880	960	800	95	2124	1044	5.88	6

### Terms & Conditions

All products must be inspected once removed from the packaging and RVR notified within 28 days of delivery of any scratches, blemishes or other damage. RVR will then replace the radiator.

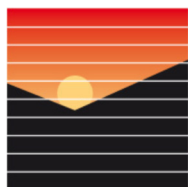
Imperfect radiators should therefore not be fitted and RVR will not accept responsibility for replacement of scratched or damaged radiators once they have been fitted. This includes any consequential loss or cost of fitting.

If RVR are not notified within 28 days of the date on the signed delivery note then it will be deemed that RVR have fully complied with its obligations and claims will not be considered.

Failure to comply with any of the above may invalidate any claims.

We recommend that after you check the product on delivery and that it is stored in its packaging to

**ATTENTION:** the installer is requested to leave a copy of this document with the customer.



**RVR**  
Energy Technology Experts

RVR Energy Technology Limited • Kenmare, Co. Kerry, Ireland  
0818 313 003 (ROI) • 020 3287 0130 (UK) • +353 64 6641344 (INT.)  
www.rvr.ie • www.rvr.co.uk