

## Tips and Tricks

# Diaphragm valves



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# 1 General information about this document

This document is valid only as a supplement to the existing GF documentation. The remarks and details in the general user manual are still to be followed.

The following pages should provide support concerning the handling of GF diaphragm valve. Further information can also be found under [www.gfps.com/dv](http://www.gfps.com/dv) or in the GF planning fundamentals industry.







## 1.1 Diaphragm valves 5 series overview

### Manually operated

General	Type	514	515	517	519
					
	Description	True Union	Spigot ends	Flange version	3-Way
	Dimension	DN15-DN50			
	Pressure level	PN10/ PN16 *			
Materials	PVC-U	✓	✓	✓	
	PVC-C	✓	✓	✓	
	ABS	✓	✓		
	PP-H	✓	✓	✓	✓
	PP-n		✓		
	PVDF	✓	✓	✓	✓
	PVDF-HP	✓	✓		✓
Connection type	Sockets	✓			
	Spigot	✓	✓		✓
	Flange			✓	
	Threaded socket	✓			
Diaphragm materials	EPDM	✓	✓	✓	✓
	PTFE/EPDM	✓	✓	✓	✓
	PTFE/FPM	✓	✓	✓	✓
	FPM	✓	✓	✓	
	NBR	✓	✓	✓	
Accessories	Feedback electric	✓	✓	✓	✓

\* See pressure-temperature diagram in the respective data sheet

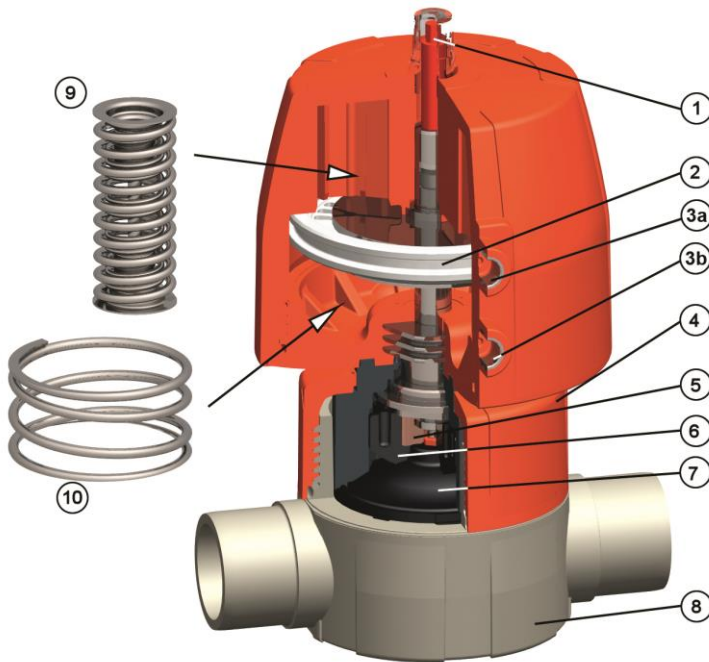
Pneumatically operated

General	Type	604	605	DIASTAR Six	DIASTAR Ten	DIASTAR TenPlus	DIASTAR Sixteen**
							
	Dimension	DN15		DN15-DN50			
	Pressure level	PN6		PN6	PN10	PN10 on both sides	PN16
Functions	FC	✓	✓	✓	✓	✓	✓
	FO	✓	✓		✓	On request	On request
	DA	✓	✓		✓	On request	On request
Spring assemblies	Number	1	1	3-6	3-6	4-6	6
Recommended pressure range*	Bar	0-6	0-6	0-6	0-10	4-10	8-16
Pneumatic connections	Size	G $\frac{1}{4}$ "	G $\frac{1}{4}$ "	G $\frac{1}{8}$ "	to DN40: G $\frac{1}{8}$ " from DN40: G $\frac{1}{4}$ "	to DN32: G $\frac{1}{8}$ " from DN32: G $\frac{1}{4}$ "	to DN32: G $\frac{1}{8}$ " from DN32: G $\frac{1}{4}$ "
Materials	PVC-U	✓	✓	✓	✓	✓	On request
	PVC-C	✓	✓	✓	✓	✓	
	ABS	On request	On request	✓	✓	✓	
	PP-H	✓	✓	✓	✓	✓	
	PP-n	On request	On request		✓		
	PVDF	✓	✓		✓	✓	✓
	PVDF-HP				✓	✓	✓
Type of valve body	514 (union)	✓		✓	✓	✓	✓
	515 (spigot)		✓	✓	✓	✓	✓
	517 (flange)			On request	✓	✓	✓
	519 (spigot)				✓	✓	✓
Connection type	Sockets	✓		✓	✓	✓	✓
	Spigot	✓	✓	✓	✓	✓	✓
	Flange			On request	✓	✓	✓
	Threaded socket			✓	✓	✓	✓
Diaphragm materials	EPDM	✓	✓	✓	✓	✓	✓
	PTFE/EPDM	✓	✓		✓	✓	✓
	PTFE/FPM	✓	✓		✓	✓	✓
	FPM	✓	✓	On request	On request	On request	On request
	NBR			On request	On request	On request	On request
Accessories	Feedback electric				✓	✓	✓
	Emergency manual override				✓	✓	✓
	Stroke limiter				✓	✓	✓
	Positioner				✓	✓	✓
	Bus connection			On request	✓	✓	✓

\* See Chapter 1.4. pressure range and spring assemblies DIASTAR

\*\*Water use only

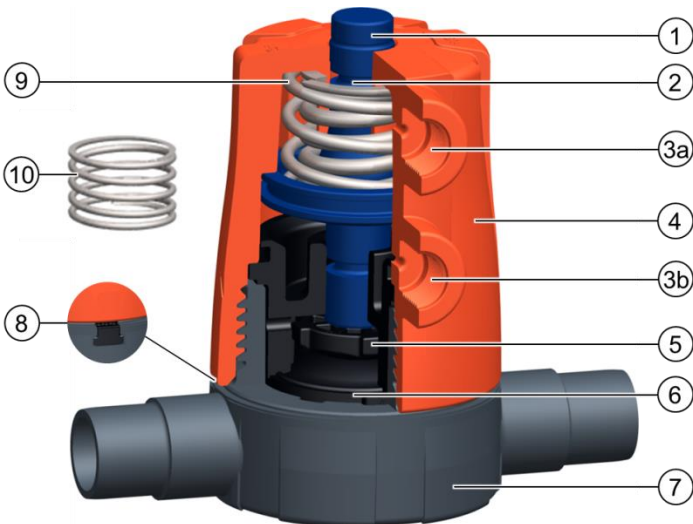
## 1.2 Construction DIASTAR



No.	Description
1	Optical position indicator with indicator cap
2	Piston
3a	Control air connection FO / DA
3b	Control air connection FC / DA
4	Full plastic housing
5	Diaphragm holder
6	Thrust piece compressor
7	Diaphragm
8	Valve body
9	Pre-loaded spring sets for FC mode
10	Spring for FO mode

Mode of operation, the DA does not use any springs for the control function

## 1.3 Construction Type 604/605



No.	Description
1	Optical position indicator
2	Piston
3a	Control air connection FO / DA
3b	Control air connection FC / DA
4	Top part with plastic thread
5	Thrust piece compressor
6	Diaphragm
7	Valve body
8	Indicator for diaphragm material
9	Pre-loaded spring sets for FC mode
10	Spring for control function FO

Mode of operation, the DA does not use any springs for the control function

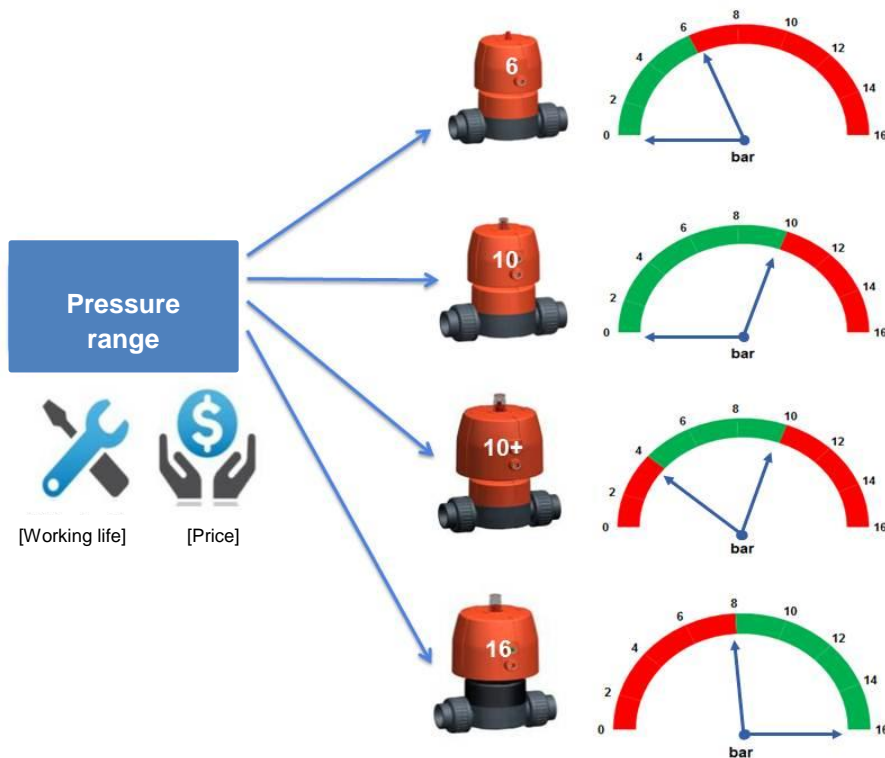
## 1.4 Pressure ranges and spring packages DIASTAR

The closing force of the actuators were designed for the specified PN pressure level. Operation at very low line pressures and very strong actuators results in increased wear of the diaphragm:

For example: Use DIASTAR Sixteen (FC) only at medium pressures >PN6.

To extend the working life for low line pressures, adjusting the number of spring packages is recommended. For the specific dimensioning, please contact your representative at Georg Fischer Piping Systems.

The following figure shows the recommended media-pressure range depending on the DIASTAR valve:



### **! DANGER**

**Personal injury or material damage may occur by reducing the spring assemblies!**

Reduced spring sets lead to a reduced closing force. At a rising line pressure the valve cannot close or not close properly due to missing spring sets. Death or serious injury could occur due to open piping. The process can be influenced negatively.

**Configure diaphragm valve and actuator according to your line pressure.**

## 2 Turn the air connections at the DIASTAR

The connections for the control medium can be positioned in 90° increments, to optimally align it to the piping system.



### **Risk of injury due to uncontrolled evasion of the medium!**

If the pressure has not been fully removed, the medium can escape uncontrollably. Depending on the type of medium, risk of injury may exist.

- Completely relieve pressure from the pipeline before changing the position.
- Hazardous to health, flammable or explosive media:

Completely drain and flush piping system and DIASTAR before changing position. Pay attention to possible residues.

- Take the appropriate measures to ensure that the medium is collected safely.

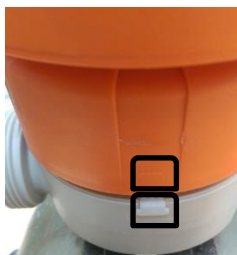


1. Turn screws in threaded inserts and fix valve body in a vice so that the screws come out (see image)

2. FC connection: Pressurise with compressed air.

3. Unscrew the housing nut using a strap wrench or a special tool (cf. section 3.1, Tool).

4. Turn actuator through 90°.



5. Align the diaphragm parallel to the sealing weir  
Hand-tighten.

6. Tighten the housing nut with the strap wrench or the special tool until the indicator on the housing nut is aligned with the valve body (cf. mark in figure).



### 3 Changing the diaphragm DIASTAR DN15-DN50

This chapter describes the changing of a diaphragm.

It is possible to change the diaphragm whether the valve is installed or not.



**Type and composition of the medium, pressure and temperature can significantly influence the working life of the diaphragm. The inspection intervals are adapted to the particular application requirements.**

#### Maintenance plan

Maintenance interval	Maintenance task
Regularly	Check the connection between top part and valve body for leakage
1 - 2 times a year	Operate to check functionality of permanently open or closed diaphragm valves
100,000 operations with less than 10 bar nominal pressure with 20°C and water DIASTAR Ten/ TenPlus	Perform visual inspection of the valve body Remove the actuator and check diaphragm for damage Change diaphragm in case of damage
50,000 operations with more than 10 bar nominal pressure with 20°C and water DIASTAR Sixteen	Perform visual inspection of the valve body Remove the actuator and check diaphragm for damage Change diaphragm in case of damage

#### Colour coding of the diaphragm material

The colour of the index plate shows which diaphragm material is installed. The coding is as follows:

Colour of index plate	Diaphragm material
Black	EPDM diaphragm
White	PTFE/ EPDM diaphragm
Green	PTFE/ FPM diaphragm
Red	FPM diaphragm
Blue	NBR diaphragm



### 3.1 Tool

The following material is required for a change of diaphragm:

- Strap wrench (EasyGrip) or special open-end wrench
- Tip: Use screw clamp and pipe piece for simplified disassembly

#### 3.1.1 Strap wrench EasyGrip



EasyGrip is a strap wrench for pulling and releasing round screw connections. This tool enables the safe screwing of the housing nut and a quick maintenance of all GF diaphragm valves.

EasyGrip can be used for all dimensions of the whole range of the diaphragm valves (DN15-DN50).

<b>No.</b>	198 154 019
------------	-------------

#### 3.1.2 Special wrench (GF)



For more frequent maintenance a dimension-dependent special wrench can be used. By using this tool, the maintenance on a diaphragm valve can be carried out efficiently.

The wrench with the following code number can be used for hand and pneumatic valves:

DN	15	29	25	32	40	50
No	198 154 012	198 154 013	198 154 014	198 154 015	198 154 016	198 154 017



Hook wrench

<b>Type</b>	604/605
-------------	---------

<b>No.</b>	700 278 354
------------	-------------

## 3.2 Instructions for replacing the diaphragm

Replacing the diaphragm is possible even with valves already installed. A service video is available on <http://www.gfps.com/dv>.

### Preparation



1. Screw two screws into the inserts

Dimension	Screws
DN10-DN25	M6
DN32-DN50	M8

### Fix DV



2. Tighten the valve in a vice so that the screws come out. (Image)

### Prepare the actuator



3. FC connection: Pressurize with compressed air

Pulls the diaphragm upwards and eases opening.

**i** Use of a small ball valve for permanent pressurisation is helpful

### Install protection



**i** To prevent damage, use short pipe spigots or similar to protect the position indicator

### Place screw clamp



**i** Clamp the DV via the pipe spigots and valvebody. Hand-tighten.

### Release actuator



4. Open the valve with the EasyGrip or special wrench counterclockwise, to simplify tighten the vice.

### Remove actuator



5. Remove top part with actuator.

### Protect position indicator



**i** Use union nut to protect the actuator.

### Replace diaphragm



6. Unscrew old diaphragm
7. Screw in the new diaphragm hand-tight.
8. Turn back the diaphragm again at least 90° / maximum 360°
9. Realign the sealing bead of the diaphragm parallel to the sealing weir. In doing this, position the lugs of the diaphragm precisely between the narrow guide groove of the inner housing.

### Replace the index plate



10. Change the index plate at the valve body

### Screw on the actuator



11. Screw the upper part of the valve back onto the valve body.

Pay attention to correct position of the sealing bead.

### Tighten the actuator



12. Using the EasyGrip or special wrench pull back to the position. (Position indicator of the housing nut aligns with the index plate)

### Type 604/605



Use hook key



Pressurise the FC connection with compressed air



For changing the diaphragm, see the description DIASTAR Steps 6-10



Screw the upper part of the valve back onto the valve body. Pay attention to correct position of the sealing bead.

Pull back to the position using the hook key. (Semicircular position indicator of the housing nut aligns with the index plate)

## 4 Changing the diaphragm DIASTAR DN65-DN150

In the following chapters, replacing the diaphragm, with large DIASTAR dimensions is described.

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### WARNING

#### **Risk of injury due to uncontrolled evasion of the medium!**

If the pressure has not been fully removed, the medium can escape uncontrollably. Depending on the type of medium, risk of injury may exist.

- Completely relieve pressure from the pipeline before changing the position.
- Hazardous to health, flammable or explosive media:

Completely drain and flush piping system and DIASTAR before changing position. Pay attention to possible residues.

- Take the appropriate measures to ensure that the medium is collected safely.
- 

### WARNING

#### **Replacement of PTFE diaphragm with backing diaphragm!**

Personal injury or material damage through uncontrolled leakage or continued flow from the medium pipe or valve.

- Using PTFE diaphragm with rear position diaphragm EPDM or FPM:  
Make sure that both diaphragms are replaced.
- 

### 4.1 Replacing the diaphragm



Different connections of diaphragms on the compressor piece; depending on the material and dimension. If the diaphragm material was to be changed, also replace the compressor!




EPDM diaphragm with thread connection



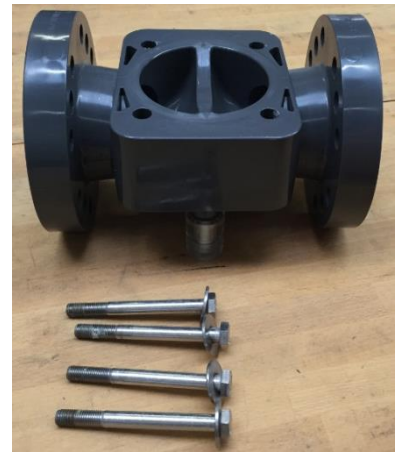
PTFE diaphragm with bayonet connection





 **FO and DA actuator:**  
Use compressed air to  
pressurize the compressor  
(description see  
diaphragm replacement)

1. Unscrew the protection cap of the position indicator.



2. Turn around the diaphragm valve and place on a union coupling nut to prevent damage to the position indicator.

3. Unscrew the screws of the valve body.



4. Invert the diaphragm and unscrew it counterclockwise.



5. Install a new diaphragm in the same position as the old diaphragm

- Place the actuator straight up for the first rotations, this is so that the grub screw of the diaphragm holder can grip the diaphragm.
- Install the diaphragm hand tight clockwise.
- Turn back the diaphragm again at least 90° / maximum 360°.
- Realign the sealing bead of the diaphragm parallel to the sealing weir. In doing this, position the butt strap of the diaphragm between the narrow guide groove (recess) of the inner housing.

6. Assemble in reverse order

Torque housing screws:

Dimension	Torque
DN65	25 Nm
DN80	30 Nm
DN100	30 Nm
DN150	40 Nm

## 5 Accessories

The respective accessories are not suitable for all types manual or pneumatic valves. Examination of the respective specifications is strongly recommended. The information in this document should provide an overview of available accessories and the respective versions.

### 5.1 Stroke limiter and manual override

The stroke limiter is suitable only for DIASTAR valves and is used for the mechanical flow limitation. In addition, the stroke limiter can be used as an emergency manual override. For information on the respective stroke of the DV, please refer to the Annex.

- For DIASTAR Ten, Ten Plus and Sixteen



Stroke limiter and emergency manual override

### 5.2 Electrical feedback

The electrical feedback is different for manual and pneumatic diaphragm valves.

For manual diaphragm valves, there are 2 different versions:



- AgNi 250V – 6A
- AU 4 -30 V, 1-100 mA

The following options are available for the DIASTAR valves:



Version	Description
EL position indicator with 2 auxiliary switch Ag Ni	Voltage 250 V ~ 6 A
EL position indicator with 2 auxiliary switch Au	Voltage 4-30 V 1-100 mA
EL position indicator with 2 inductive switch NPN	Voltage 5-30 V (10 - 30 V) = 100 mA
EL position indicator with 2 inductive switch PNP	Voltage 5-30 V (10 - 30 V) = 100 mA
EL position indicator with 2 inductive switch Namur Eexi	Intrinsically safe / voltage 8V =
EL position indicator with 2 inductive switch Eecd	Voltage 250V ~ 5 A
EL position indicator with reed contact	DN15-150 / voltage 250V ~ 200 mA



**The stroke limiter / emergency manual override and electronic feedback can be combined. To ensure proper installation with the Diastar valves an appropriate adapter is necessary.**



## 5.3 Electro-pneumatic positioner - DSR

Type DSR 100 – DN15-50

Type DSR 101 – DN65-150

Available also with optical position indicator.

- Installation on pneumatic control valves
- Linear and rotary actuators
- Nominal stroke 3 - 28 mm
- Self-learning
- Input signal 4 - 20 mA
- 24 V DC



Electro-pneumatic positioner - DSR

## 5.4 Pilot valve

Various pilot valves are available depending on the requirement:

Type	Description
PV 94	3/2-way valve with compressed air connection G1/8 or hose connector (push - in)
PV 95	3/2-way valve with compressed air connection G1/4
PV 2000	3/2-way and 5/2-way valve Connection module AS-interface or Profibus interface
MNL 532	Version for 3/2-way and 5/2-way valves Using a Namur connection plate



Type PV94



Type PV95



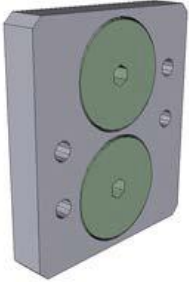
Type PV2000



Type MNL 532

### Namur connection plate

If you want to use a NAMUR pilot solenoid valve we offer connection plates. The connection plate is mounted between the actuator and the pilot solenoid valve.



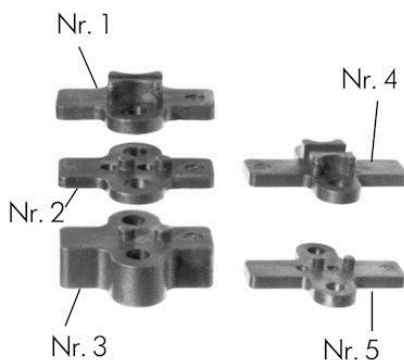
Namur connection plate

### Mounting blocks PP

The mounting plates are designed to allow differently sized manual and pneumatic diaphragm valves to be aligned on the same pipe centre line by equalising the different heights from the base to the centre line of the pipe. The mounting blocks can be plugged together to achieve the desired height.

The mounting blocks can be combined as follows:

- DN15-DN25: Mounting block 1 directly on the valve, mounting plate 2 and 3 for additional height equalisation
- DN32-DN50: Mounting block 4 directly on the valve, mounting plate 5 for additional height equalisation



Mounting blocks PP

## **6 Spare Parts**

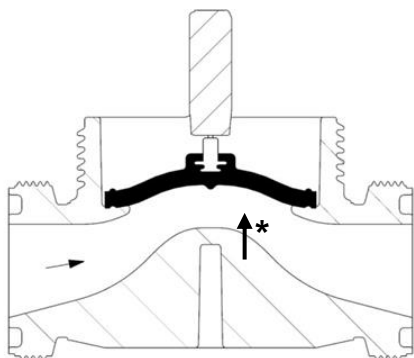
Various spare parts are available for the GF diaphragm valve range of products:

- Upper parts for hand operated valves
- Actuators for pneumatic valves
- Valve bodies
- Sealing kits
- Diaphragm

Other spare parts are available depending on the type and dimension. Please check GF product catalogue for further options.

## Annex

### Information on the valve stroke



\* Maximum valve stroke

DN	Actuator		Valve stroke
	Size	Variant	Target (mm)
15	1	Six, 604/605	6.0
	1	Ten	6.0
			6.0
20	2	Sixteen	6.0
	2	Six	9.0
	2	Ten	9.0
	2	Sixteen	9.0
25	2	Six	12.0
	2	Ten	12.0
	3	Sixteen	12.0
32	3	Six	14.0
	3	Ten	14.0
	4	Sixteen	14.0
40	3	Six	14.0
	4	Ten	14.0
			14.0
	5	Sixteen	14.0
50	3	Six	14.0
			14.0
			14.0
	4	Ten	22.0
	5	Sixteen	22.0

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[www.gfps.com](http://www.gfps.com)

## Argentina / Southern South America

Georg Fischer Central Plastics  
Sudamérica S.R.L.  
Buenos Aires, Argentina  
Phone +54 11 4512 02 90  
[gfcentral.ps.ar@georgfischer.com](mailto:gfcentral.ps.ar@georgfischer.com)  
[www.gfps.com/ar](http://www.gfps.com/ar)

## Australia

George Fischer Pty Ltd  
Riverwood NSW 2210 Australia  
Phone +61 (0) 2 9502 8000  
[australia.ps@georgfischer.com](mailto:australia.ps@georgfischer.com)  
[www.gfps.com/au](http://www.gfps.com/au)

## Austria

Georg Fischer  
Rohrleitungssysteme GmbH  
3130 Herzogenburg  
Phone +43 (0) 2782 856 43-0  
[austria.ps@georgfischer.com](mailto:austria.ps@georgfischer.com)  
[www.gfps.com/at](http://www.gfps.com/at)

## Belgium / Luxembourg

Georg Fischer NV/SA  
1070 Bruxelles/Brüssel  
Phone +32 (0) 2 556 40 20  
[be.ps@georgfischer.com](mailto:be.ps@georgfischer.com)  
[www.gfps.com/be](http://www.gfps.com/be)

## Brazil

Georg Fischer Sist. de Tub. Ltda.  
04571-020 São Paulo/SP  
Phone +55 (0)11 5525 1311  
[br.ps@georgfischer.com](mailto:br.ps@georgfischer.com)  
[www.gfps.com/br](http://www.gfps.com/br)

## Canada

Georg Fischer Piping Systems Ltd  
Mississauga, ON L5T 2B2  
Phone +1 (905) 670 8005  
Fax +1 (905) 670 8513  
[ca.ps@georgfischer.com](mailto:ca.ps@georgfischer.com)  
[www.gfps.com/ca](http://www.gfps.com/ca)

## China

Georg Fischer Piping Systems Ltd  
Shanghai 201319  
Phone +86 21 3899 3899  
[china.ps@georgfischer.com](mailto:china.ps@georgfischer.com)  
[www.gfps.com/cn](http://www.gfps.com/cn)

## Denmark / Iceland

Georg Fischer A/S  
2630 Taastrup  
Phone +45 (0) 70 22 19 75  
[info.dk.ps@georgfischer.com](mailto:info.dk.ps@georgfischer.com)  
[www.gfps.com/dk](http://www.gfps.com/dk)

## Finland

Georg Fischer AB  
01510 VANTAA  
Phone +358 (0) 9 586 58 25  
Fax +358 (0) 9 586 58 29  
[info.fi.ps@georgfischer.com](mailto:info.fi.ps@georgfischer.com)  
[www.gfps.com/fi](http://www.gfps.com/fi)

## France

Georg Fischer SAS  
95932 Roissy Charles de Gaulle  
Cedex  
Phone +33 (0) 1 41 84 68 84  
[fr.ps@georgfischer.com](mailto:fr.ps@georgfischer.com)  
[www.gfps.com/fr](http://www.gfps.com/fr)

## Germany

Georg Fischer GmbH  
73095 Albershausen  
Phone +49 (0) 7161 302-0  
[info.de.ps@georgfischer.com](mailto:info.de.ps@georgfischer.com)  
[www.gfps.com/de](http://www.gfps.com/de)

## India

Georg Fischer Piping Systems Ltd  
400 083 Mumbai  
Phone +91 224007 2001  
[branchoffice@georgfischer.com](mailto:branchoffice@georgfischer.com)  
[www.gfps.com/in](http://www.gfps.com/in)

## Indonesia

Georg Fischer Pte Ltd –  
Representative Office  
Phone +62 21 2900 8564  
Fax +62 21 2900 8566  
[sgp.ps@georgfischer.com](mailto:sgp.ps@georgfischer.com)  
[www.gfps.com/sg](http://www.gfps.com/sg)

## Italy

Georg Fischer S.p.A.  
20063 Cernusco S/N (MI)  
Phone +39 02 921 861  
[it.ps@georgfischer.com](mailto:it.ps@georgfischer.com)  
[www.gfps.com/it](http://www.gfps.com/it)

## Japan

Georg Fischer Ltd  
556-0011 Osaka,  
Phone +81 (0) 6 6635 2691  
[jp.ps@georgfischer.com](mailto:jp.ps@georgfischer.com)  
[www.gfps.com/jp](http://www.gfps.com/jp)

## Korea

GF Piping Systems  
Georg Fischer Korea Co., Ltd.  
Unit 2501, U-Tower  
120 HeungdeokJungang-ro  
(Yeongdeok-dong)  
Giheung-gu, Yongin-si, Gyeonggi-do,  
Korea  
Phone: +82 31 8017 1450  
Fax: +82 31 217 1454  
[kor.ps@georgfischer.com](mailto:kor.ps@georgfischer.com)  
[www.gfps.com/kr](http://www.gfps.com/kr)

## Malaysia

Georg Fischer (M) Sdn. Bhd.  
40460 Shah Alam, Selangor Darul  
Ehsan  
Phone +60 (0) 3 5122 5585  
Fax +603 5122 5575  
[my.ps@georgfischer.com](mailto:my.ps@georgfischer.com)  
[www.gfps.com/my](http://www.gfps.com/my)

## Mexico / Northern Latin America

Georg Fischer S.A. de C.V.  
Apodaca, Nuevo Leon  
CP66636 Mexico  
Phone +52 (81) 1340 8586  
Fax +52 (81) 1522 8906  
[mx.ps@georgfischer.com](mailto:mx.ps@georgfischer.com)  
[www.gfps.com/mx](http://www.gfps.com/mx)

## Middle East

Georg Fischer  
Piping Systems (Switzerland) Ltd  
Dubai, United Arab Emirates  
Phone +971 4 289 49 60  
[gcc.ps@georgfischer.com](mailto:gcc.ps@georgfischer.com)  
[www.gfps.com/int](http://www.gfps.com/int)

## Netherlands

Georg Fischer N.V.  
8161 PA Epe  
Phone +31 (0) 578 678 222  
[nl.ps@georgfischer.com](mailto:nl.ps@georgfischer.com)  
[www.gfps.com/nl](http://www.gfps.com/nl)

## Norway

Georg Fischer AS  
1351 Rud  
Phone +47 67 18 29 00  
[no.ps@georgfischer.com](mailto:no.ps@georgfischer.com)  
[www.gfps.com/no](http://www.gfps.com/no)

## Philippines

Georg Fischer Pte Ltd  
Representative Office  
Phone +632 571 2365  
Fax +632 571 2368  
[sgp.ps@georgfischer.com](mailto:sgp.ps@georgfischer.com)  
[www.gfps.com/sg](http://www.gfps.com/sg)

## Poland

Georg Fischer Sp. z o.o.  
05-090 Sekocin Nowy  
Phone +48 (0) 22 31 31 0 50  
[poland.ps@georgfischer.com](mailto:poland.ps@georgfischer.com)  
[www.gfps.com/pl](http://www.gfps.com/pl)

## Romania

Georg Fischer  
Piping Systems (Switzerland) Ltd  
020257 Bucharest - Sector 2  
Phone +40 (0) 21 230 53 80  
[ro.ps@georgfischer.com](mailto:ro.ps@georgfischer.com)  
[www.gfps.com/int](http://www.gfps.com/int)

## Russia

Georg Fischer  
Piping Systems (Switzerland) Ltd  
Moscow 125040  
Phone +7 495 748 11 44  
[ru.ps@georgfischer.com](mailto:ru.ps@georgfischer.com)  
[www.gfps.com/ru](http://www.gfps.com/ru)

## Singapore

George Fischer Pte Ltd  
11 Tampines Street 92, #04-01/07  
528 872 Singapore  
Phone +65 6747 0611  
Fax +65 6747 0577  
[sgp.ps@georgfischer.com](mailto:sgp.ps@georgfischer.com)  
[www.gfps.com/sg](http://www.gfps.com/sg)

## Spain / Portugal

Georg Fischer S.A.  
28046 Madrid  
Phone +34 (0) 91 781 98 90  
[es.ps@georgfischer.com](mailto:es.ps@georgfischer.com)  
[www.gfps.com/es](http://www.gfps.com/es)

## Sweden

Georg Fischer AB  
117 43 Stockholm  
Phone +46 (0) 8 506 775 00  
[info.se.ps@georgfischer.com](mailto:info.se.ps@georgfischer.com)  
[www.gfps.com/se](http://www.gfps.com/se)

## Switzerland

Georg Fischer  
Rohrleitungssysteme (Schweiz) AG  
8201 Schaffhausen  
Phone +41 (0) 52 631 30 26  
[ch.ps@georgfischer.com](mailto:ch.ps@georgfischer.com)  
[www.gfps.com/ch](http://www.gfps.com/ch)

## Taiwan

Georg Fischer Co., Ltd  
San Chung Dist., New Taipei City  
Phone +886 2 8512 2822  
Fax +886 2 8512 2823  
[www.gfps.com/tw](http://www.gfps.com/tw)

## United Kingdom / Ireland

Georg Fischer Sales Limited  
Coventry, CV2 2ST  
Phone +44 (0) 2476 535 535  
[uk.ps@georgfischer.com](mailto:uk.ps@georgfischer.com)  
[www.gfps.com/uk](http://www.gfps.com/uk)

## USA / Caribbean

Georg Fischer LLC  
9271 Jeronimo Road  
92618 Irvine, CA  
Phone +1 714 731 88 00  
Fax +1 714 731 62 01  
[us.ps@georgfischer.com](mailto:us.ps@georgfischer.com)  
[www.gfps.com/us](http://www.gfps.com/us)

## International

Georg Fischer  
Piping Systems (Switzerland) Ltd  
8201 Schaffhausen/Switzerland  
Phone +41 (0) 52 631 30 03  
Fax +41 (0) 52 631 28 93  
[info.export@georgfischer.com](mailto:info.export@georgfischer.com)  
[www.gfps.com/int](http://www.gfps.com/int)

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**[gambitsystems.pl](http://gambitsystems.pl)**

