

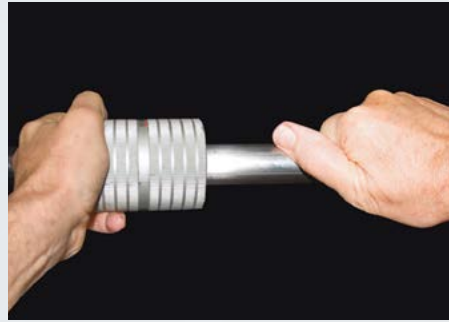
Press Joint Instructions

Sizes: 15, 22, 28 & 35



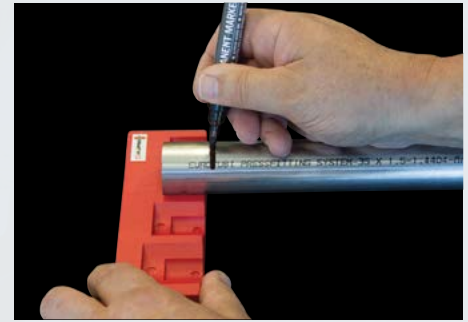
1. Cutting

Cut the pipe using burr free approved cutters. Do not use oxyacetylene or abrasive cut off wheels. Pipes must be cut at right angles to their axis, using a pipe cutter or fine tooth saw, taking into account the depth of insertion into the fitting.



2. Deburring

All pipe cuts must be carefully deburred, both inside and outside, using a manual or electric deburring tool. Any cutting residue (swarf) must be removed to preclude damage to the O-ring when the pipe is inserted into the fitting, avoiding possible leaks.



3. Witness Mark Insertion Depth

To ensure a correctly inserted joint the pipe must be marked with a fine-point felt-tip pen where it meets the fitting using the Europress depth gauge so that full insertion can be verified.



4. Assemble Fitting On Tube

Before assembling the fittings, the positioning of the O-rings must be checked and, if necessary, lubricate O-ring with water or talc to ease the insertion of the pipe. Never use oils, greases, glues or other similar substances. The pipe is inserted in the fitting with a slight rotating motion until it hits the stop.

Check pipe is fully inserted to witness mark.



5. Press Tool & Jaw

The pressing tools must be equipped with M-shaped profile jaw attachments or pressing jaw corresponding to the diameter of the fitting to be pressed. Retract the lock pin, position the jaws into the tool head and ensure the lock pin is fully engaged.



6. Position Press Jaw

Open the jaws by squeezing the two ends together, then position jaws over the fitting so that the internal channel of the jaws form a perfect fit round the toroidal seat of the fitting. Release the jaws and check for a snug fit.



7. Press Joint

Initiate the press cycle by squeezing the trigger **1** - hold until press cycle is completed. Do not allow interruption to the press cycle. If the LED light **2** comes on or warning beep sounds, the joint is NOT approved. If the hydraulic ram stops mid-cycle the automatic reset function can be manually overridden by depressing the reset button **3**.

Check L.E.D. light after each press. If it comes on, battery must be recharged or changed before attempting the next press, see trouble-shooting guide.



Press Joint Instructions

Sizes: 42, 54, 76.1, 88.9 & 108



1. Cutting & 2. Deburring

Cut the pipe using burr free approved cutters. Do not use oxyacetylene or abrasive cut off wheels. Pipes must be cut at right angles to their axis, using a pipe cutter or fine tooth saw, taking into account the depth of insertion into the fitting.

All pipe cuts must be carefully deburred, both inside and outside, using a manual or electric deburring tool. Any cutting residue (swarf) must be removed to preclude damage to the O-ring when the pipe is inserted into the fitting, avoiding possible leaks.



3. Witness Mark Insertion Depth

To ensure a correctly inserted joint, the pipe must be marked with a fine-point felt-tip pen.

42 & 54 use the Europress depth gauge.

Large sizes use rule (pictured)
76.1 mark at 55mm
88.9 mark at 63mm
108 mark at 78mm
140 mark at 97mm
169 mark at 117mm



4. Assemble Fitting on Tube

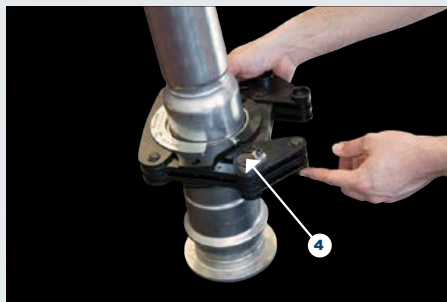
Before assembling the fittings, the positioning of the O-rings must be checked and, if necessary, lubricate O-ring with water or talc to ease the insertion of the pipe. Never use oils, greases, glues or other similar substances. The pipe is inserted in the fitting with a slight rotating motion until it hits the stop.

Check pipe is fully inserted to witness mark.



5. Attach Press Collar

The pressing collar must be M-shaped profile corresponding to the diameter of the fitting to be pressed. Retract the lock pin 3, open the jaws and position the jaws around the fitting.



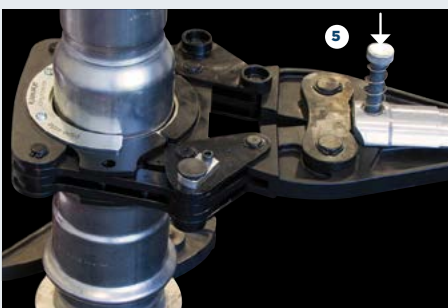
6. Lock Collar

Ensure that the internal channel of the jaws form a perfect fit round the O-ring seat of the fitting. Ensure the lock pin is fully engaged 4.



7. Attach Adaptor

Squeeze the back of the adaptor arms together and hook onto the pressing collar.



8. Connect Press Tool

Retract the lock pin, engage the adaptor and make sure lock pin is fully engaged 5.

Check witness mark for insertion and dept. alignment before initialising press cycle.



9. Press Joint

Initiate the press cycle by squeezing the trigger 1 hold until press cycle is completed. Do not allow interruption to the press cycle. If the LED light comes on or warning beep sounds, the joint is NOT approved. If the hydraulic ram stops mid-cycle the automatic reset function can be manually over-ridden by depressing the reset button 2. Any tool malfunction, check with our Technical dept.

Do not continue using tool without approval.