

## >B< PRESS ASSEMBLY INSTRUCTIONS:

### Tools required:

Tube cutter, deburring tool, press machine, press jaws.

### Assembly

- Ensure the tube and fitting sizes are compatible.
- Cut the tube end square, and ensure it retains its shape.
- Deburr the inside, and outside of the tube.
- Mark the tube to the correct tube stop depth as a visual aid.
- Check O-rings are present in the fitting.
- Insert the tube into the fitting, passed the O-ring, until it meets the tube stop and the mark on the tube is still visible.
- Insert the >B< profile Jaw with the correct profile and size into the >B< Press Tool.
- Open the press jaw, and align with the O-ring bead, allow the jaw to close.
- Operate the press machine to press the fitting.
- The machine will stop at the end of its pressing cycle.
- Open the jaw, and remove from the fitting.
- Make sure all joints have been pressed.
- If the joint(s) is (are) not pressed, when pressure tested they will leak profusely.



### Demounting

- This fitting system is not demountable.

>B< Press fittings are simple to install, just follow these straightforward guidelines.

### Getting started

We recommend you keep the fitting in its packaging until you are ready to begin installation. This is important to keep the fitting free of any dust or dirt and to ensure the 'O' ring stays lubricated and protected from damage.

Select the correct size of tube and fitting for the job. Ensure that both are clean and free from damage and imperfections.

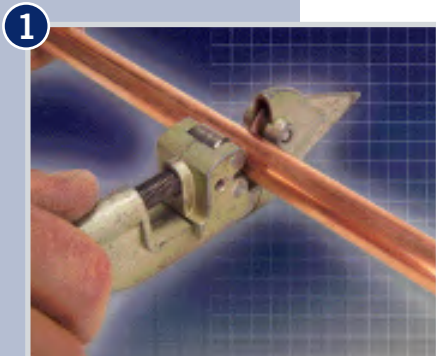
### Preparation

**1** We recommend you use a rotary pipe cutter to cut the tube square. If you use a hacksaw, a fine toothed blade should be used and care taken to ensure the tube is cut square. Grinding machines and wheels are not suitable. If tube ends have become distorted or damaged, the ends should be restored to the outside diameter dimensions specified in EN 1057 or cut back. Tube ends should be clean and free from scratches not less than the socket length. When using plastic coated tube to EN 13349, the plastic coating should be cut back to the minimum socket length without scoring the tube.

**2** Make sure that the internal and external tube end are free from burrs or sharp edges by using a deburring tool. Then wipe the tube end clean to avoid damaging the 'O' ring on tube insertion.

**3** The tube must be fully inserted into the fitting until it reaches the tube stop in order to make a perfect joint. Use a rule to mark the socket depth of the fitting onto the tube (see Table 9). This will ensure that any tube movement is detected, which is especially important if the joints are to be pressed at a later time.

**4** Visually check that the 'O' ring is seated correctly within the fitting socket.



### Joining

**1** To assemble the joint, the tube must be inserted into the fitting up to the tube stop. (Use the mark on the tube which was made earlier as reference.) The pressing operation should only be undertaken when the tube reaches the tube stop.



**2** Using the correct sized jaws in the press tool, place them over the bead at the mouth of the fitting. Maintain a 90° angle between tube and jaws to ensure a sound joint is made.



**3** Depress the trigger/button to begin the compression cycle of the tool. This is complete when the mouth of the fitting is fully enclosed by the jaws. Now release the jaws from around the fitting. (For further information refer to tool manufacturer's instructions.)



### Spacing

Make sure enough clearance is left around each fitting to attach the jaws without obstruction. The critical dimensions can be found in Tables 6 and 7 on page 10.

Table 9

#### Fitting socket depths

Size (mm)	Socket depth (mm)	
	Coupler	Other fittings
14	20	22
15	20	20
16	20	22
22	21	21
28	23	23
35	26	26
42	30	30
54	35	35
64	57	52
67	53	53
76	51.5	51.5
89	51.5	51.5
108	60	60



We recommend the use of press collars rather than two-piece jaws when jointing larger size fittings. The collars provide an equally distributed pull around the circumference of the fitting. For 108mm red brass fittings a secondary press is undertaken to ensure a sound joint.

### Lubrication

Pivot points and collar slides should be regularly lubricated to prolong the life of the collar.

### Getting started and preparation

The same care and attention should be taken with tube preparation and socket depth marking when jointing 64mm to 108mm fittings as outlined in the "Getting Started" and "Preparation" sections for 12mm to 54mm fittings on page 16.



### Jointing

**1** To assemble the joint, the tube must be inserted into the fitting up to the tube stop. (Use the mark on the tube which was made earlier as reference.) The pressing operation should only be undertaken when the tube reaches the tube stop.



**2** Select the appropriate collar and open by depressing the spring loaded pin. Pull apart and position over the fitting.



**3** Ensure that the groove in the collar corresponds to the bead on the fitting and that the support plate on the collar fits over the tube side of the joint.

**4** Turn the catch mechanism towards the locking pin, press down the locking pin and push the catch into the pin until it locks. Revolve the collar around the fitting to the desired pressing position.



**5** Take the appropriate adaptor and attach to the press tool, then close the breach bolt. To attach the collar, depress the jaw levers and attach the claws as far as you can into the grooves of the collar. Unless the adaptor is correctly connected to the press collar pressing will not be possible.



**6** Depress the button on the press tool and begin the pressing operation.



**7** On completion of the pressing operation an audible bleep will be heard; disengage the adaptor by depressing the jaw levers and remove the collar from the fitting. See below for 108mm fitting.



**8** **108mm fitting**  
Leave the press collar in place and attach the secondary adaptor as detailed in point 5, then repeat the pressing operation as described in steps 6 and 7. The fitting must go through two pressing operations to complete the 108mm joint.

