

Press Fitting – Assembly Procedure

1. PREPARATION:

- Ensure the o-ring is present & is seated correctly (not loose in the fitting).
- Cut the tube square.



2. TUBE PREPARATION:

- Check the tube ends are not damaged.
- De-burr the end of the tube.
- Ensure no sharp edges or swarf are present.



3. INSERTION AND DEPTH MARKING:

- Insert the tube into the fitting using a “twisting motion”.
- Using a permanent pen place a mark on the tube to indicate that the fitting is fully engaged.
- When all tubes are inserted double check the “depth marks” are in the correct position.



4. PRESS THE JOINT:

- Ensure the correct tool and jaws are selected.
- Place the jaw around the “bead” of the fitting.
- When correctly located press the trigger button to commence the pressing process.
- The tool will automatically stop when this is complete.
- Remove the pressed assembly from the jaw.



***** PLEASE NOTE *****

A pressing sling, as shown below, is required for 42mm & 54mm fittings:



5. INSPECTION:

- Check everything is correct.
- The “depth marks” should still be in the same place.
- No damage should be present.



6. POST PROCESSING:

- Remove the black pressing indicator.
- You now have a fully functional pressed assembly!

