

Press-fit connections



1. Select the correct size of tube and fitting for the job. Ensure that both are clean, in good condition and free from damage and imperfections.
2. Cut the tube square using a rotary tube cutter whenever possible. If a hacksaw is used to cut the tube, a fine toothed blade should be used, care must be taken to ensure that the tube is cut square and properly de-burred.

When using plastic coated carbon steel tube, the coating must be removed to the exact socket depth of the fitting and the tube deburred.

3. The tube end should then be wiped clean of all swarf and debris, to avoid damage to the 'O' ring upon tube insertion.
4. To make a perfect joint, the tube must be fully inserted into the fitting until it meets the tube stop.
5. Ensure that the 'O' ring is seated correctly within the fitting socket.

Jointing

1. Assemble the joint, ensuring that the tube is inserted into the connection until it meets the tube stop. The mark on the tube made earlier should be used as a guide to ensure this is the case. For plastic coated carbon steel tube, the mouth of the fitting should be in contact with the plastic coating. Only when the tube reaches the tube stop should the pressing operation be undertaken.
2. With the correctly sized jaws inserted into the press tool, place them over the bead at the mouth of the fitting. A 90° angle between tube and jaws must be maintained to ensure a sound joint is made.

3. Depressing the trigger or button will commence the compression cycle of the tool, which is complete when the jaws fully enclose the mouth of the fitting. The jaws should then be released from around the fitting. Please refer to the tool manufacturers instructions for further detailed information.

Spacing

In order to make a joint correctly sufficient clearance around each fitting must be left to allow press-fit jaws to be attached without hindrance.

For full installation details refer to XPress data book.

FITTING SOCKET DEPTHS	
<i>Size</i>	<i>Copper/Stainless/Carbon</i>
15mm	20mm
18mm	20mm
22mm	21mm
28mm	23mm
35mm	26mm
42mm	30mm
54mm	35mm