78mm



# installation instructions

### 1. mark the socket depth:

Ensuring full socket depth is achieved is vital for the integrity of the joint. To check that the tube and fitting remains in the correct position throughout the pressing process you must mark the socket depth with a 'V-Tail' mark.

If using slip sockets elongate the V (as per picture) as the depth mark and V can be inserted past this mark.



S110 - orange socket depth tool for copper tube S111 - blue socket depth tool for carbon and stainless steel tube by hand

# 2. check the O-ring seal:

Insert the tube into the fitting until it meets the tube stop, using the insertion depth mark as a visual aid.

Only when the tube reaches the tube stop should the pressing operation be commenced.

### 3. prepare the press-fit tool:

Select the correct combination of Press-tool, Jaws, Slings and adaptors for the joint being made.

note:

- always refer to the manufacturer's instructions for detailed information on how to operate your press-tool safely
- check that the press tool and relevant jaws/slings have been maintained in accordance with their servicing/ calibration schedule

Make the tool safe by isolating it from the power supply. Select the correct jaws/sling jaws/sling jaw adaptor for the joint being made, checking that they are free from damage. Attach the jaws/sling jaws/sling jaw adaptor to your press-tool, following the instructions for your particular press-tool, and reconnect the power supply when ready.

### 66.7mm (67mm) Sling (S330 Snap on sling)

Novopress offers alternative slings for use on different press systems. As such Pegler reinforces the following instruction.

Where 66.7mm slings are required for crimping XPress fittings, installers must only use the following XPress/ Novopress slings and adaptors:

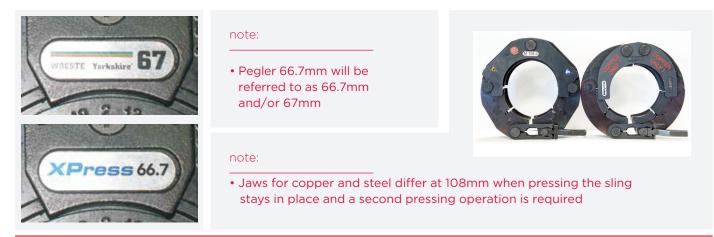
Novopress reference	Sling marking	Novopress adaptor	
36516-50	"Woeste" 67mm	7B302 42-66.7mm	
30310-30	Woeste Omm	20302 42-00.711111	
45184-50	"XPress" 66.7mm	ZB323 66.7-108mm	

Under no circumstances should any other brand of sling be used with our 66.7mm fittings as these will lead to an incorrect crimp resulting in an immediate joint failure and invalidate the Pegler Yorkshire warranty.

XPress 66.7mm fittings that have inadvertently been crimped with the wrong brand of sling cannot be successfully re-crimped with the XPress 66.7 sling and will unfortunately have to be cut out and replaced with a new fitting using the correct sling.

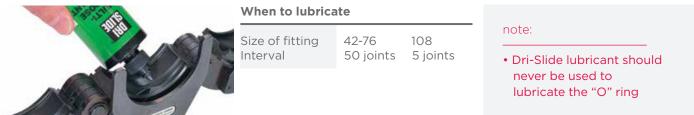
	Size	Depth
	12mm	17mm
	15mm	20mm
	18mm	20mm
	22mm	21mm
	28mm	23mm
	35mm	26mm
	42mm	30mm
	54mm	35mm
	66.7mm	50mm
	76.1mm copper	50mm
	76.1mm stainless/carbon	55mm
	88.9mm	64mm
	108mm copper	64mm

108mm stainless/carbon



### 4. Dri-Slide lubricant

Use of S135 Dri-Slide lubricant is essential when jointing large sized fittings. The pressing profile groove of the sling jaws should be cleaned and lightly lubricated after every 50 joints for 42mm to 76.1mm sizes, and every 5 joints for 108mm. Dri-Slide should also be applied between the main sling arms and the moving segments; and along the pivot pins between the arms. Wipe clean any excess lubricant so that it does not come into contact with the fitting "O" ring.



### 5. press the joint:

Mount the jaws/sling jaws over the bead at the mouth of the fitting. With the tool fully supported and not hanging from the pipework, and with your hands safelyaway from the joint, press the trigger or button to start the jointing cycle. When the jaws/sling jaws fully enclose the mouth of the fitting, the joint is complete. The jaw should then be released from around the fitting



note:

the use of Sling Jaws for sizes 42 to 108mm

### 6. check the joint:

Inspect the finished joint making sure all is in order, when satisfied the joint has been made correctly mark the joint as complete.

- the socket depth mark you made indicates that full socket depth has been maintained throughout the pressing cycle
- the fitting and pipe bear the witness marks from your jaws/sling jaws
- we recommend all systems are thoroughly pressure tested before hand over to end user. Refer to www.pegleryorkshire.co.uk for detailed recommendations, particularly regarding Carbon Steel installations



# further details

### **Aalberts Integrated Piping Systems Ltd**

St. Catherine's Avenue / Doncaster South Yorkshire / DN4 8DF / England +44 (0) 800 1560 050 tel: email: technical@aalberts-ips.com

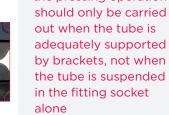
# www.pegler.co.uk



operations (Novopress only)

• the 108mm joint is not fully made until the

fitting has been through two pressing



 allow press-fit jaws to be attached without hindrance