

# 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.



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	78mm

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	ZB302 42-66.7mm
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.



note:

- Pegler 66.7mm will be referred to as 66.7mm and/or 67mm



note:

- Jaws for copper and steel differ at 108mm when pressing the sling stays in place and a second pressing operation is required

#### 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.



#### When to lubricate

Size of fitting	42-76	108
Interval	50 joints	5 joints

note:

- Dri-Slide lubricant should never be used to lubricate the "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 safely away 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.



#### 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

15 to 35mm

Pegler Yorkshire recommend the use of Sling Jaws for sizes 42 to 108mm

note:

- the 108mm joint is not fully made until the fitting has been through two pressing operations (Novopress only)
- maintain a 90° angle between the tube and jaws at all times, this is to ensure the integrity of the joint as well as protect the operator from 'kickback'



- the pressing operation should only be carried out when the tube is adequately supported by brackets, not when the tube is suspended in the fitting socket alone
- allow press-fit jaws to be attached without hindrance

- we recommend all systems are thoroughly pressure tested before hand over to end user. Refer to [www.pegler-yorkshire.co.uk](http://www.pegler-yorkshire.co.uk) for detailed recommendations, particularly regarding Carbon Steel installations



#### further details

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