

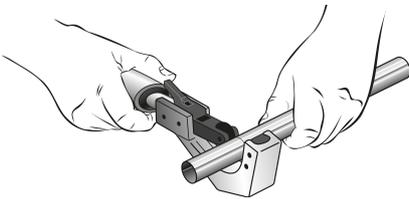
## Assembly instructions for PRESS STEEL M, PRESS INOX M, PRESS COPPER M and PRESS COPPER AQUAGAS M

***Please follow the assembly instructions! All system components are designed and tested to be compatible within the system. For components of other suppliers we do not take any guarantee. We assume the compliance with the currently valid technical rules.***

### 1. Transport and storage

In transport and storage PCC press fittings and PCC system pipes have to be protected against damage, moisture, UV-radiation and defilement.

### 2. Separation



PCC system pipes can be cut to length using commercial cutting tools suitable for metallic pipes. It should be ensured that there are no burrs after cutting procedure of PRESS INOX PIPE.

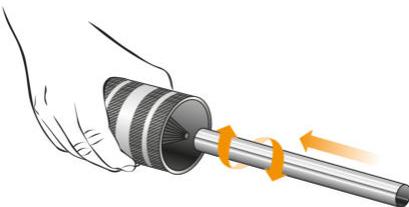
#### **We recommend the use of:**

- pipe cutters
- fine-toothed hand saws
- slow running electronic machine saws

#### **The following tools are not permitted:**

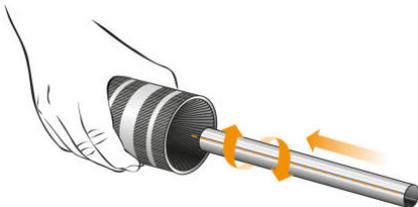
- tools that cause burrs
- oil-cooled saws
- angle grinders

### 3. Deburring



After cutting procedures the PCC pipe ends must be finished internally and externally with a suitable deburrer. This to ensure that the gasket/o-ring is not damaged when inserting the pipe into the press fitting.

Internally



Externally

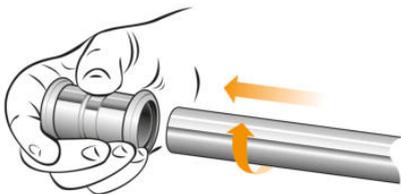
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### 4. Inspection



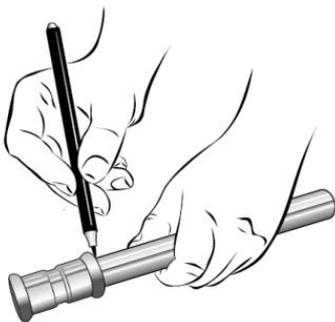
Before inserting the end of the pipe into the press fitting, it is necessary to inspect the gasket for proper placement, damage and defilement.

### 5. Insertion into the press fitting



The pipe has to be pushed with light force and a small twist into the press fitting.

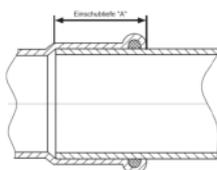
### 6. Marking of the insertion depth



A permanent marking on the PCC system pipe (or insert adapters, street bends f/m or male and crossover bends) is required to make a solid press connection.

This marking is to be applied to the insertion side of the pipe before pressing.

Insertion depth "A"



Dimension [d] in mm	Insertion depth "A" in mm
12	17
15	20
18	20
22	21
28	23
35	26
42	30
54	35
66,7	50
76,1	55
88,9	63
108	76
139,7	100
168,3	121

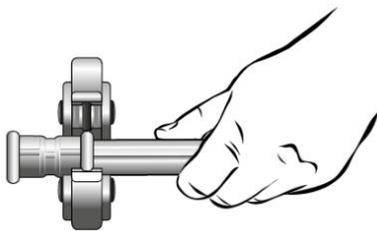
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### 7. Making the press connection

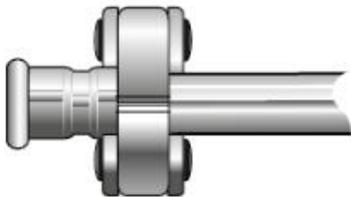
After inserting the PCC system pipe into the PCC press fitting the press connection can be made with the correct and suitable press machines and corresponding press jaws/press collars with the right press profile.

For sizes 42 and up only press collars with the corresponding press profile may be used.

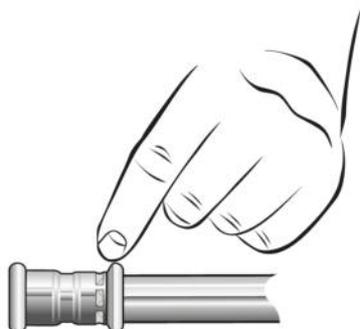
Depending on the dimension of the press fitting the corresponding press jaws are to be inserted into the press device/ proper press chain on the moulding. In doing so the press jaw/press collar must rest on the bead of the press fitting. After the pressing operation the correctness and proper execution as well as compliance with the designated insertion depth are to be inspected. The user must affirm that all connections have been pressed. After the pressing locations have undergone pressing operations the pipes may no longer be adjusted. Threaded connections must be executed in advance.



Before pressing ensure that the fitting is correctly positioned, because it cannot be moved or twisted once the press cycle is completed. Attach the press jaw/press collar with the correct diameter and correct press profile to the correct positioning and begin the pressing process.



Now run the press cycle and ensure that the press jaw/press collar are closed completely. Only interrupt the pressing cycle in case of emergency!



Once the press cycle is finished the press connection is complete. The correct system pressing can be seen by markings on the press profile.

Before leak and pressure test each pressing must be checked visually. We recommend to mark the type of press profile next to or on the press profile.

### 8. Pressing with machines and/or press jaws/press collars of other suppliers

If pressing machines or press jaws/press collars which have not been delivered by PCC are used, it has to be ensured that these tools are suitable for PRESS INOX, PRESS STEEL, PRESS COPPER and/or PRESS COPPER AQUAGAS.

### Applications press fittings

system name								
<b>PRESS STEEL M</b>	X	✓	X	✓ [1]	X	✓	✓	on request
<b>PRESS INOX M</b>	✓	✓	on request	✓ [1]	✓ [1]	✓	✓	on request
<b>PRESS INOX M 304</b>	✓	✓	X	✓ [1]	✓ [1]	X	✓	on request
<b>PRESS COPPER M</b>	✓	✓	on request	on request	✓ [1]	X	✓	on request
<b>PRESS COPPER AQUAGAS M</b>	✓	✓	✓ [2]	on request	✓ [1]	X	✓	on request

✓ [1] = only with FKM (Viton) o-ring

✓ [2] = These products are according Gastec AR214 Hydrogen ready

X = not suitable

### Applications o-rings

Article name	Picture	Dimension	°C / bar	Application
EPDM Black		12 – 168,3 mm	-10°C/+110°C (120°C) 16 bar	Drinking water / Fire-fighting water / Rainwater Purified water / Water heating systems Circulation pipes / Demineralised Water
FPM (DIN ISO 1629) FKM (ASTM D1418) Green		15 – 168,3 mm	-30°C /+180°C (230°C) 16 bar	Compressed Air systems / Heating oil Mineral oil / Fats / Solar systems
HNBR Yellow		12 – 168,3 mm	-20°C /+ 70°C 5 bar	gas installations with natural gas (NG) and liquefied petroleum gas (LPG) other gases on request only Pressure class MOP5/GT1
			-20°C/+ 95°C 16 bar	Drinking water / Water heating systems