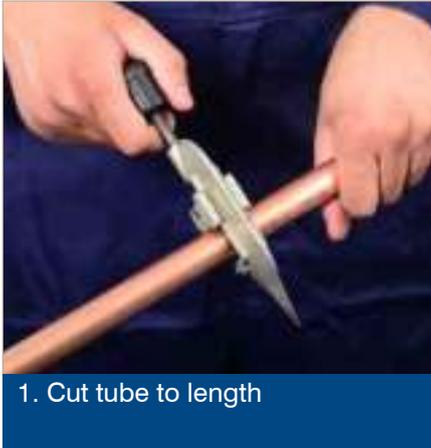


## >B< Press Installation Process

Leave the fittings in the packaging prior to final installation to protect them from contamination and to preserve the lubrication of the O-rings. Please note the space required for pressing tools (see section 2.4.1).



**1. Cut tube to length**

- Use a rotary tube cutter.
- Ensure that the tube is cut square.
- Check the tube has retained its shape and is damage free.



**2. Deburr**

- Deburr the tube both internally and externally.
- Where possible angle the tube downwards to prevent filings entering the tube.
- Make sure the internal and external surfaces of the tube ends are smooth and free from burrs or sharp edges.

Caution: Please ensure that the tube surface is free from any deep scores or scratches.



**3. Check the fittings**

- Check the fitting is the correct size for the tube.
- Check the O-rings are present and correctly seated.
- Additional >B< Press lubricant (silicon oil) may be used to aid tube insertion. (MPABPSOIL100ML)



**4. Assemble and mark the insertion depth**

- The tube must be fully inserted into the fitting until it reaches the tube stop.
- To reduce the risk of dislodging the O-ring, rotate the tube (if possible) while slipping it into the fitting.
- Mark the insertion depth on the tube.
- Prior to pressing ensure the tube has not moved out from the fitting socket.



**5. Complete the joint with the press tool**

- Ensure pipework is correctly aligned prior to pressing.
- Ensure the correct size jaw is inserted into the tool.
- The jaws must be placed squarely on the fitting, locating the groove on the bead.
- The bead on the fitting should fit centrally in the groove of the jaw.
- Depress and hold the start button on the press tool to complete the pressing cycle.
- Pressing is complete when the jaws are fully closed.
- Complete the press cycle once only – do not re-press.



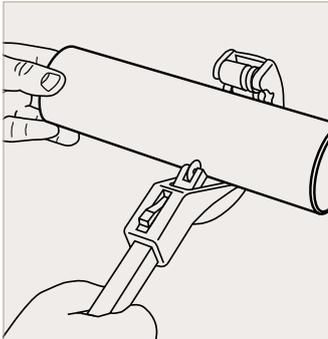
**6. Mark the completed joint**

- Mark the completed joint after pressing.
- This enables joints to be inspected easily before testing.

## >B< Press XL Installation Process

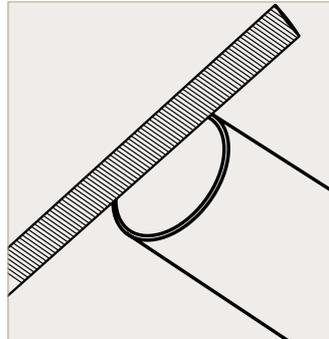
To install >B< Press XL, a press tool, actuator and compatible sized press ring to fit each size fitting is required.

When force is exerted through the press tool a permanent joint is made and the fitting cannot be disassembled or reused.



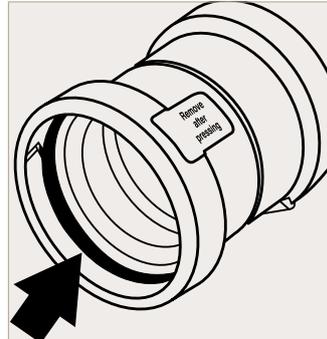
1. Cut tube to length

- We recommend you use a rotary tube cutter. It is important to ensure that the tube is cut completely square.
- Tube ends should be clean and free from scratches no less than the socket length.



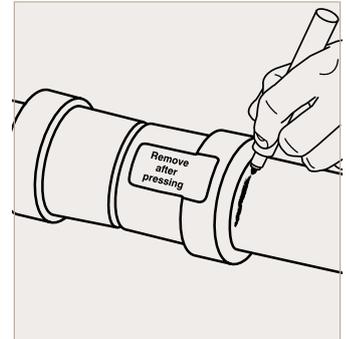
2. Deburr

- Make sure that the internal and external tube end is free from burrs or sharp edges by using a half round file or deburring tool.
- Then wipe the tube end clean to avoid damaging the seal on tube insertion.



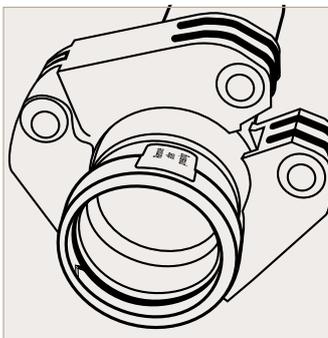
3. Check the fittings

- Before inserting the tube check seal for correct placement, damage or any ingress of debris.
- To prevent this occurring we recommend the fittings are retained in packaging up to the point of use.



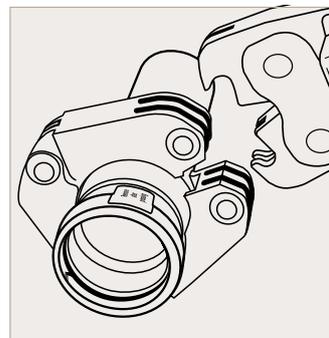
4. Mark the insertion depth

- The tube must be fully inserted into the fitting until it reaches the tube stop in order to make a perfect joint.
- Marking insertion depth will ensure that any tube movement is detected, which is especially important if the joints are to be pressed at a later time.
- The depth marking must be visible on the pressed fitting.



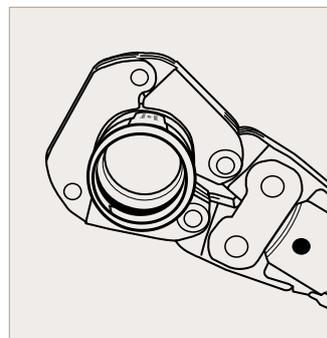
5. Fit the pressing ring

- Using the appropriate size pressing ring, open the pressing ring, locate on the fitting bead and close the pressing ring.



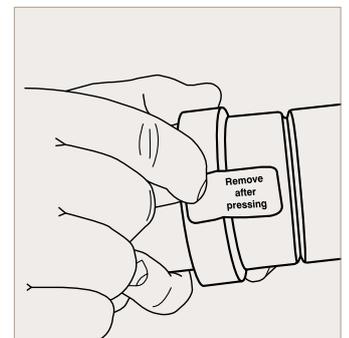
6. Engage the actuator and check insertion depth

- With the actuator fitted in the press tool open the actuator and locate the actuator onto the aperture of the pressing ring.
- Check for any tube movement prior to pressing.



7. Press the joint

- Depress and hold the trigger of the tool until the press cycle of the tool is automatically completed. Keep hands clear of the press actuator and press ring until the cycle is completed.
- Do not repress the fitting.



8. Joint completion

- Remove the actuator from the press ring, remove the press ring from the tube and remove the label to indicate the joint is pressed and complete.

### Important

It is important to keep the fitting free of any dust or dirt, and to ensure the seal stays lubricated and protected from damage. Select the correct size of tube and fitting for the job. Ensure that both are clean and free from damage and imperfections. When using a press tool always wear ear and eye protection.