SPECIFICATIONS — Copper Pipe and Fitting

Pipe

Specification BSEN 1057

Grade Table X and Table Y

Usage

- Drinking Water
- Hot/Cold Water
- General Engineering
- Sanitation
- Central Heating

The EN 1057 product range is suitable for drinking water purposes, both hot and cold, sanitation, central heating, gas and general engineering applications. The range is available in half hard and hard drawn tempers and is supplied in diameters from 15mm to 108mm diameter, and in a variety of wall thicknesses to meet the old Table X and Table Y requirements.

TABLE X COPPER TUBE

SIZE	OD	WALL THICKNESS	SAFE WORKING PRESSURE		WEIGHT/ LENGTH
			ANNEALED	AS SUPPLIED	
	(mm)	(mm)	(Kpa)	(Kpa)	(kg/5.8m)
1/2"	15	0.7	4500	5870	1.63
3/4"	22	0.9	3920	5120	3.09
1"	28	0.9	3060	3990	3.98
1-1/4"	35	1.2	3270	5150	6.61
1-1/2"	42	1.2	2710	4270	7.98
2"	54	1.2	2090	3300	10.33
2-1/2"	66.7	1.2	1690	2660	12.81
3"	76.1	1.5	1850	2920	18.24
4"	108	1.5	1300	2040	26.04

TABLE Y COPPER TUBE

SIZE	OD	WALL THICKNESS	SAFE WORKING PRESSURE		WEIGHT/ LENGTH
			ANNEALED	AS SUPPLIED	
	(mm)	(mm)	(Kpa)	(Kpa)	(kg/5.8m)
1/2"	15	1.0	6570	8570	2.28
3/4"	22	1.2	5310	6920	4.07
1"	28	1.2	4120	5370	5.24
1-1/4"	35	1.5	4120	6490	8.19
1-1/2"	42	1.5	3410	5370	9.9
2"	54	2.0	3540	5580	16.95
2-1/2"	66.7	2.0	2840	4480	21.09
3"	76.1	2.0	2480	3910	24.15
4"	108	2.5	2180	3440	42.99

SPECIFICATIONS — Copper Pipe and Fitting

Copper Capillary Fitting

Specification BSEN 1254-1:1998

Assembly

- Ensure the copper tube and fitting sizes are compatible. Cut the tube end square, and ensure it retains its shape.
- Deburr the tube, both inside and outside.
- Clean tube with an abrasive cloth, and fitting socket with a wire brush.
- Apply a thin layer of flux to the tube, and to the fitting socket.
- Insert the tube into the fitting until the tube stop is reached. Rotate the tube or fitting and remove any excess flux where possible.
- Light the blow lamp, and heat the fitting socket until the flux starts to boil. Keep the flame moving over the fitting and tube, do not provide excessive heat.
- Apply lead free solder to the tube-fitting interface until it fills the void.
- As a rule of thumb, a length of solder equivalent to the tube diameter will be adequate for a satisfactory joint.
- Remove the blow lamp, allow to cool and wipe the joint(s) with a damp cloth.
- Flush all residues out of the system

Operating Parameter:

16bar @ up to 30Deg C

10bar @ up to 65DEg C

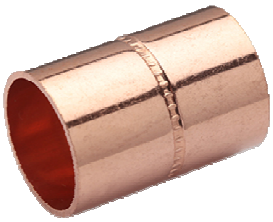
7bar @ up to 95DEg C

6bar @ up to 110Deg C

SPECIFICATIONS — Copper Pipe and Fitting

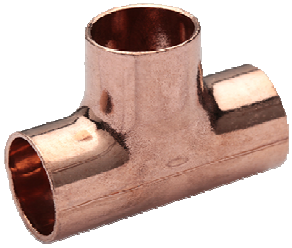
Copper Capillary Fitting

Specification BSEN 1254-1:1998



PLAIN SOCKET

SIZE	PIPE OD (mm)
1/2"	15
3/4"	22
1"	28
1-1/4"	35
1-1/2"	42
2"	54
2-1/2"	66.7
3"	76.1
4"	108



EQUAL TEE

SIZE	PIPE OD (mm)
1/2"	15
3/4"	22
1"	28
1-1/4"	35
1-1/2"	42
2"	54
2-1/2"	66.7
3"	76.1
4"	108

90DEG ELBOW

SIZE	PIPE OD (mm)
1/2"	15
3/4"	22
1"	28
1-1/4"	35
1-1/2"	42
2"	54
2-1/2"	66.7
3"	76.1
4"	108

45DEG ELBOW

SIZE	PIPE OD (mm)
1/2"	15
3/4"	22
1"	28
1-1/4"	35
1-1/2"	42
2"	54
2-1/2"	66.7
3"	76.1
4"	108

FEMALE THREAD SOCKET

SIZE
15 X 1/2" FPT
22 X 3/4" FPT
28 X 1" FPT
35 X 1-1/4" FPT
42 X 1-1/2" FPT
54 X 2" FPT
66.7 X 2-1/2" FPT
76.1 X 3" FPT
108 X 4" FPT

MALE THREAD SOCKET

SIZE
15 X 1/2" MPT
22 X 3/4" MPT
28 X 1" MPT
35 X 1-1/4" MPT
42 X 1-1/2" MPT
54 X 2" MPT
66.7 X 2-1/2" MPT
76.1 X 3" MPT
108 X 4" MPT

FEMALE THREAD ELBOW

SIZE
15 X 1/2" FPT
22 X 3/4" FPT
28 X 1" FPT

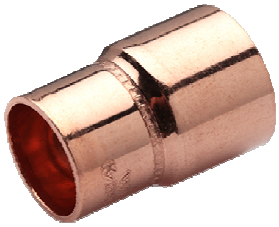
MALE THREAD ELBOW

SIZE
15 X 1/2" MPT
22 X 1/2" MPT
28 X 1/2" MPT

SPECIFICATIONS — Copper Pipe and Fitting

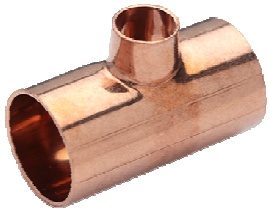
Copper Capillary Fitting

Specification BSEN 1254-1:1998



RED SOCKET

SIZE	PIPE OD (mm)	SIZE	PIPE OD (mm)
3/4" X 1/2"	22 X 15	2-1/2" X 1"	66.7 X 28
1" X 1/2"	28 X 15	2-1/2" X 1-1/4"	66.7 X 35
1" X 3/4"	28 X 22	2-1/2" X 1-1/2"	66.7 X 42
1-1/4" X 1/2"	35 X 15	2-1/2" X 2"	66.7 X 54
1-1/4" X 3/4"	35 X 22	3" X 1-1/2"	76.1 X 42
1-1/4" X 1"	35 X 28	3" X 2"	76.1 X 54
1-1/2" X 1/2"	42 X 15	3" X 2-1/2"	76.1 X 66.7
1-1/2" X 3/4"	42 X 22	4" X 2"	108 X 54
1-1/2" X 1"	42 X 28	4" X 2-1/2"	108 X 66.7
1-1/2" X 1-1/4"	42 X 35	4" X 3"	108 X 76.1
2" X 1/2"	54 X 15		
2" X 3/4"	54 X 22		
2" X 1"	54 X 28		
2" X 1-1/4"	54 X 35		
2" X 1-1/2"	54 X 42		



RED TEE

SIZE	OD (mm)	SIZE	PIPE OD (mm)
3/4" X 1/2"	22 X 15	2-1/2" X 1"	66.7 X 28
1" X 1/2"	28 X 15	2-1/2" X 1-1/4"	66.7 X 35
1" X 3/4"	28 X 22	2-1/2" X 1-1/2"	66.7 X 42
1-1/4" X 1/2"	35 X 15	2-1/2" X 2"	66.7 X 54
1-1/4" X 3/4"	35 X 22	3" X 1-1/2"	76.1 X 42
1-1/4" X 1"	35 X 28	3" X 2"	76.1 X 54
1-1/2" X 1/2"	42 X 15	3" X 2-1/2"	76.1 X 66.7
1-1/2" X 3/4"	42 X 22	4" X 2"	108 X 54
1-1/2" X 1"	42 X 28	4" X 2-1/2"	108 X 66.7
1-1/2" X 1-1/4"	42 X 35	4" X 3"	108 X 76.1
2" X 1/2"	54 X 15		
2" X 3/4"	54 X 22		
2" X 1"	54 X 28		
2" X 1-1/4"	54 X 35		
2" X 1-1/2"	54 X 42		

STUB END

SIZE	PIPE OD (mm)
1/2"	15
3/4"	22
1"	28
1-1/4"	35
1-1/2"	42
2"	54
2-1/2"	66.7
3"	76.1
4"	108

END CAP

SIZE	PIPE OD (mm)
1/2"	15
3/4"	22
1"	28
1-1/4"	35
1-1/2"	42
2"	54
2-1/2"	66.7
3"	76.1
4"	108

SPECIFICATIONS — Copper Pipe and Fitting

Brass Compression Fitting

Specification BSEN 1254-2

Assembly

- Ensure the tube conforms to the specification and select the correct fitting for the size of the tube to be connected.
- Deburr the tube, both inside and outside.
- Enter the tube through the thrust nut and compression olive fully into the fitting untul positive contact is made with tube stop
- Make sure the sealing faces of the joint and threads are clean and free form swarf and any contamination. A little light oil applied to the threads of the fittings is useful in reducing friction during tightening. With correct made joints, jointing compound should not be required although in certain circumstances these may offer practical advantages.
- Care should be taken that the compression olive is not placed over any identification mark ot other indentation on the tube.
- Hand tighten the thrust nut until all slack in joint is taken up
- Complete tightening using a suitable spanner. Ensure the axial alignment of the tube and fittings during tightening should be avoided as this may destroy the watertight seal.

Operating Parameter:

16bar @ up to 30Deg C

10bar @ up to 65DEg C

7bar @ up to 95DEg C

6bar @ up to 110Deg C

SPECIFICATIONS — Copper Pipe and Fitting

Brass Compression Fitting

Specification BSEN 1254-2

PLAIN COUPLING

SIZE	PIPE OD (mm)
1/2"	15
3/4"	22
1"	28
1-1/4"	35
1-1/2"	42
2"	54
2-1/2"	66.7
3"	76.1
4"	108

90DEG ELBOW

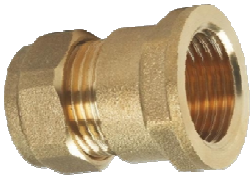
SIZE	PIPE OD (mm)
1/2"	15
3/4"	22
1"	28
1-1/4"	35
1-1/2"	42
2"	54
2-1/2"	66.7
3"	76.1
4"	108

EQUAL TEE

SIZE	PIPE OD (mm)
1/2"	15
3/4"	22
1"	28
1-1/4"	35
1-1/2"	42
2"	54
2-1/2"	66.7
3"	76.1
4"	108

MALE SOCKET

SIZE
15 X 1/2" MPT
22 X 3/4" MPT
28 X 1" MPT
35 X 1-1/4" MPT
42 X 1-1/2" MPT
54 X 2" MPT
66.7 X 2-1/2" MPT
76.1 X 3" MPT
108 X 4" MPT



FEMALE SOCKET

SIZE
15 X 1/2" FPT
22 X 3/4" FPT
28 X 1" FPT
35 X 1-1/4" FPT
42 X 1-1/2" FPT
54 X 2" FPT
66.7 X 2-1/2" FPT
76.1 X 3" FPT
108 X 4" FPT

FEMALE ELBOW

SIZE
15 X 1/2" FPT
22 X 3/4" FPT
28 X 1" FPT
35 X 1-1/4" FPT
42 X 1-1/2" FPT
54 X 2" FPT

MALE ELBOW

SIZE
15 X 1/2" MPT
22 X 3/4" MPT
28 X 1" MPT
35 X 1-1/4" MPT
42 X 1-1/2" MPT
54 X 2" MPT

SPECIFICATIONS — Copper Pipe and Fitting

Brass Compression Fitting

Specification BSEN 1254-2

BRACKET FEMALE ELBOW

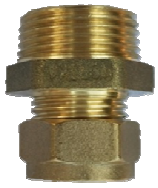
SIZE
15 X 1/2" FPT
15 X 3/4" FPT
22 X 1/2" FPT
22 X 3/4" FPT

FEMALE TEE

SIZE
15 X 1/2" FPT
22 X 3/4" FPT
28 X 1" FPT
35 X 1-1/4" FPT
42 X 1-1/2" FPT
54 X 2" FPT

MALE TEE

SIZE
15 X 1/2" MPT
22 X 3/4" MPT
28 X 1" MPT
35 X 1-1/4" MPT
42 X 1-1/2" MPT
54 X 2" MPT



RED COUPLING

SIZE	PIPE OD (mm)
3/4" X 1/2"	22 X 15
1" X 1/2"	28 X 15
1" X 3/4"	28 X 22
1-1/4" X 1/2"	35 X 15
1-1/4" X 3/4"	35 X 22
1-1/4" X 1"	35 X 28
1-1/2" X 1/2"	42 X 15
1-1/2" X 3/4"	42 X 22
1-1/2" X 1"	42 X 28
1-1/2" X 1-1/4"	42 X 35
2" X 1/2"	54 X 15
2" X 3/4"	54 X 22
2" X 1"	54 X 28
2" X 1-1/4"	54 X 35
2" X 1-1/2"	54 X 42

SIZE	PIPE OD (mm)
2-1/2" X 1"	66.7 X 28
2-1/2" X 1-1/4"	66.7 X 35
2-1/2" X 1-1/2"	66.7 X 42
2-1/2" X 2"	66.7 X 54
3" X 1-1/2"	76.1 X 42
3" X 2"	76.1 X 54
3" X 2-1/2"	76.1 X 66.7
4" X 2"	108 X 54
4" X 2-1/2"	108 X 66.7
4" X 3"	108 X 76.1

RED ELBOW

SIZE	PIPE OD (mm)
3/4" X 1/2"	22 X 15
1" X 1/2"	28 X 15
1" X 3/4"	28 X 22
1-1/4" X 1/2"	35 X 15
1-1/4" X 3/4"	35 X 22
1-1/4" X 1"	35 X 28
1-1/2" X 1/2"	42 X 15
1-1/2" X 3/4"	42 X 22
1-1/2" X 1"	42 X 28
1-1/2" X 1-1/4"	42 X 35
2" X 1/2"	54 X 15
2" X 3/4"	54 X 22
2" X 1"	54 X 28
2" X 1-1/4"	54 X 35
2" X 1-1/2"	54 X 42

RED MALE COUPLING

SIZE	PIPE OD (mm)
3/4" X 1/2"	22 X 15
1" X 1/2"	28 X 15
1" X 3/4"	28 X 22
1-1/4" X 1/2"	35 X 15
1-1/4" X 3/4"	35 X 22
1-1/4" X 1"	35 X 28
1-1/2" X 1/2"	42 X 15
1-1/2" X 3/4"	42 X 22
1-1/2" X 1"	42 X 28
1-1/2" X 1-1/4"	42 X 35
2" X 1/2"	54 X 15
2" X 3/4"	54 X 22
2" X 1"	54 X 28
2" X 1-1/4"	54 X 35
2" X 1-1/2"	54 X 42

SPECIFICATIONS — Copper Pipe and Fitting

Copper Press Fitting

Specification Compatible to BSEN 1057 Tube

Advantages of Press-Fit

- Fast to install
  - Quicker than conventional brazing or compression
  - Reduced labour cost
- Flame free connection
  - No hot works permit required
- Push and Stay
  - Fitting is tight enough to complete the rough in before securing placement by pressing
  - Inside each fitting is an Elastomeric O-Ring. It is essential that the O-rings are not contaminated or damaged by foreign material before usage.
- Lightweight Press-tool
  - Slim lightweight ad ergonomic design
  - One hand operation. Once the jaws are inserted, the weight is balanced

WATER PRESS-FITTING

Application	Pressure Kpa	Temperature °C
Hot & Cold Potable Water	1600	120
Chilled Water	1600	-25
Rainwater Installation	1600	Ambient
Vacuum	-80	Ambient
Domestic Fire Sprinkler System	1600	Ambient
Compressed Air Installation (Oil Free)	1600	70

SPECIFICATIONS — Copper Pipe and Fitting

Copper Press Fitting

Installation Guides size 15mm — 35mm

1. Cut copper tube to length using a pipe cutter.

3. For existing copper tube, clean the end with emery paper or a soft scourer.

5. Select pressing jaw according to the fitting dimension and insert into the pressing machine. Arrest the locking bolts of the machine. Check the jaws are free from debris and in good working order.

2. Deburr carefully the end of the tube on the inside to minimize turbulence and pressure loss according to the relevant plumbing code and on the outside to avoid damaging the O-ring.

4. Mark the insertion depth by lining up the fitting side by side with the tube and mark the tube. When the fitting is inserted onto the tube the outer edge of the fitting must line up with the marking. For correct insertion depths see the table below.

Tube Size mm	Insertion Depth mm
15	20
22	24
28	27
35	32
42	38
54	43
66.7	47
76.1	50
108	69

SPECIFICATIONS — Copper Pipe and Fitting

Copper Press Fitting

Installation Guides size 15mm — 35mm

6. Check the fitting is clean and the O-ring is free from debris and correctly sitting in place. Push fitting on tube all the way to the engagement marking.

7. Check the fitting outer edge still lines up with the marking. Open the pressing jaw and close it around the fitting so the raised bump in the fitting rests inside the groove of the pressing jaw.

8. Initiate the pressing job by pressing the start button. The automatic pressing process creates a tight connection.

9. Visually inspect the fitting to ensure the press has been completed. The KemPress® tool will flash if the fitting did not press correctly. If this occurs a new fitting and tube section is required. At the end of the project visually inspect each fitting to ensure none have been missed.

SPECIFICATIONS — Copper Pipe and Fitting

Brass Compression Fitting

Specification BSEN 1254-2

PLAIN SOCKET

SIZE	PIPE OD (mm)
1/2"	15
3/4"	22
1"	28
1-1/4"	35
1-1/2"	42
2"	54
2-1/2"	66.7
3"	76.1
4"	108

EQUAL TEE

SIZE	PIPE OD (mm)
1/2"	15
3/4"	22
1"	28
1-1/4"	35
1-1/2"	42
2"	54
2-1/2"	66.7
3"	76.1
4"	108

90DEG ELBOW

SIZE	PIPE OD (mm)
1/2"	15
3/4"	22
1"	28
1-1/4"	35
1-1/2"	42
2"	54
2-1/2"	66.7
3"	76.1
4"	108

45DEG ELBOW

SIZE	PIPE OD (mm)
1/2"	15
3/4"	22
1"	28
1-1/4"	35
1-1/2"	42
2"	54
2-1/2"	66.7
3"	76.1
4"	108

FEMALE THREAD SOCKET

SIZE
15 X 1/2" FPT
22 X 3/4" FPT
28 X 1" FPT
35 X 1-1/4" FPT
42 X 1-1/2" FPT
54 X 2" FPT
66.7 X 2-1/2" FPT
76.1 X 3" FPT
108 X 4" FPT

MALE THREAD SOCKET

SIZE
15 X 1/2" MPT
22 X 3/4" MPT
28 X 1" MPT
35 X 1-1/4" MPT
42 X 1-1/2" MPT
54 X 2" MPT
66.7 X 2-1/2" MPT
76.1 X 3" MPT
108 X 4" MPT

FEMALE THREAD ELBOW

SIZE
15 X 1/2" FPT
22 X 3/4" FPT
28 X 1" FPT
35 X 1-1/4" MPT
42 X 1-1/2" MPT
54 X 2" MPT

FEMALE THREAD ELBOW

SIZE
15 X 1/2" FPT
22 X 3/4" FPT
28 X 1" FPT
35 X 1-1/4" MPT
42 X 1-1/2" MPT
54 X 2" MPT

SPECIFICATIONS — Copper Pipe and Fitting

Brass Compression Fitting

Specification BSEN 1254-2

RED SOCKET

SIZE	PIPE OD (mm)
3/4" X 1/2"	22 X 15
1" X 1/2"	28 X 15
1" X 3/4"	28 X 22
1-1/4" X 1/2"	35 X 15
1-1/4" X 3/4"	35 X 22
1-1/4" X 1"	35 X 28
1-1/2" X 1/2"	42 X 15
1-1/2" X 3/4"	42 X 22
1-1/2" X 1"	42 X 28
1-1/2" X 1-1/4"	42 X 35
2" X 1/2"	54 X 15
2" X 3/4"	54 X 22
2" X 1"	54 X 28
2" X 1-1/4"	54 X 35
2" X 1-1/2"	54 X 42

RED TEE

SIZE	OD (mm)
3/4" X 1/2"	22 X 15
1" X 1/2"	28 X 15
1" X 3/4"	28 X 22
1-1/4" X 1/2"	35 X 15
1-1/4" X 3/4"	35 X 22
1-1/4" X 1"	35 X 28
1-1/2" X 1/2"	42 X 15
1-1/2" X 3/4"	42 X 22
1-1/2" X 1"	42 X 28
1-1/2" X 1-1/4"	42 X 35
2" X 1/2"	54 X 15
2" X 3/4"	54 X 22
2" X 1"	54 X 28
2" X 1-1/4"	54 X 35
2" X 1-1/2"	54 X 42

SIZE	PIPE OD (mm)
2-1/2" X 1"	66.7 X 28
2-1/2" X 1-1/4"	66.7 X 35
2-1/2" X 1-1/2"	66.7 X 42
2-1/2" X 2"	66.7 X 54
3" X 1-1/2"	76.1 X 42
3" X 2"	76.1 X 54
3" X 2-1/2"	76.1 X 66.7
4" X 2"	108 X 54
4" X 2-1/2"	108 X 66.7
4" X 3"	108 X 76.1

FEMALE THREAD TEE

SIZE
15 X 1/2" FPT
22 X 3/4" FPT
28 X 1" FPT

MALE THREAD TEE

SIZE
15 X 1/2" FPT
22 X 3/4" FPT
28 X 1" FPT

WALL PLATED ELBOW

SIZE
15 X 1/2" MPT
22 X 3/4" MPT

END CAP

SIZE	PIPE OD (mm)
1/2"	15
3/4"	22
1"	28
1-1/4"	35
1-1/2"	42
2"	54
2-1/2"	66.7
3"	76.1
4"	108

SPECIFICATIONS — Copper Pipe and Fitting

Copper Press Fitting

Installation Guides size 42mm — 54mm

Prior to the following installation steps, complete st eps 1- 4 as per the 15-35mm installations instructions on page 9.

STEP 5

Select the appropriate press collar and check that it is clean and that the surface is smooth. In order to ensure correct operation of the press collars, the sliding segments must be free to move/slide. The sliding segments are tensioned by springs, holding them in the correct starting position. Please ensure that the marking lines on the inner and outer rings form a line for the correct starting position. If the segments are not freely moving, clean and lubricate with light machine oil or have them serviced by an approved KemPress® service agent.

STEP 6

Place the collar around the KemPress® fitting such that the bead of the fitting is inserted into the groove of the press collar. Close press collar. Make certain that the press collar fits tightly into the fitting. Afterwards position the pressing collar by rotating it so that the pressing machine can be correctly attached.

SPECIFICATIONS — Copper Pipe and Fitting

Copper Press Fitting

Installation Guides size 42mm — 54mm

Prior to the following installation steps, complete st eps 1- 4 as per the 15-35mm installations instructions on page 9.

STEP 7
Select adaptor jaw ZB203 for the dimensions 42 mm and 54 mm. Insert the adaptor jaw into the press tool and close the locking bolts.

STEP 8
Open the adaptor jaw by depressing the jaw levers and attach to the press collar so that the claws of the adaptor jaw grip around the pins of the press collar. Check whether fittings outer edge lines up with the marker of the insertion depth then start the pressing procedure by pressing the start button. The pressing procedure should not be interrupted prematurely. Following this procedure ensures a permanently sealed connection always results. For safety, the pressing process can be stopped by pressing the emergency stop button. Once the emergency button has been activated, the tool will need to be reset. The affected fitting and tube section should be discarded and new components used.

SPECIFICATIONS — Copper Pipe and Fitting

Copper Press Fitting

Installation Guides size 66.1mm—76.1mm

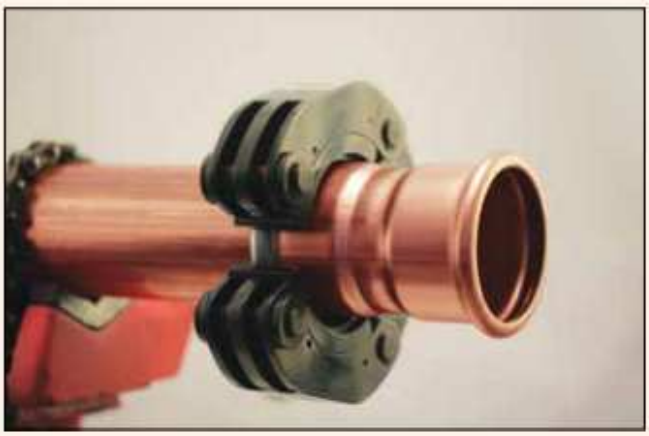
Prior to the following installation steps, complete st eps 1- 4 as per the 15-35mm installations instructions on page 9.

STEP 5

Select the appropriate press collar and check that it is clean and that the surface is smooth. In order to ensure correct operation of the press collars, the sliding segments must be free to move/slide. The sliding segments are tensioned by springs, holding them in the correct starting position. Please ensure that the marking lines on the inner and outer rings form a line for the correct starting position. If the segments are not freely moving, clean and lubricate with light machine oil or have them serviced by an approved KemPress® service agent.

STEP 6

Place the collar around the KemPress® fitting such that the bead of the fitting is inserted into the groove of the press collar. Close press collar. Make certain that the press collar fits tightly into the fitting. Afterwards position the pressing collar by rotating it so that the pressing machine can be correctly attached.



SPECIFICATIONS — Copper Pipe and Fitting

Copper Press Fitting

Installation Guides size 66.1mm—76.1mm

Prior to the following installation steps, complete st eps 1- 4 as per the 15-35mm installations instructions on page 9.

STEP 7
Select adaptor jaw ZB221 for the dimensions 66.7 mm 76.1 mm. Insert the adaptor jaw into the press tool and close the locking bolts.

STEP 8
Open the adaptor jaw by depressing the jaw levers and attach to the press collar so that the claws of the adaptor jaw grip around the pins of the press collar. Check whether fittings outer edge lines up with the marker of the insertion depth then start the pressing procedure by pressing the start button. The pressing procedure should not be interrupted prematurely. Following this procedure ensures a permanently sealed connection always results. For safety, the pressing process can be stopped by pressing the emergency stop button. Once the emergency button has been activated, the tool will need to be reset. The affected fitting and tube section should be discarded and new components used.

SPECIFICATIONS — Copper Pipe and Fitting

Copper Press Fitting

Installation Guides size 108mm

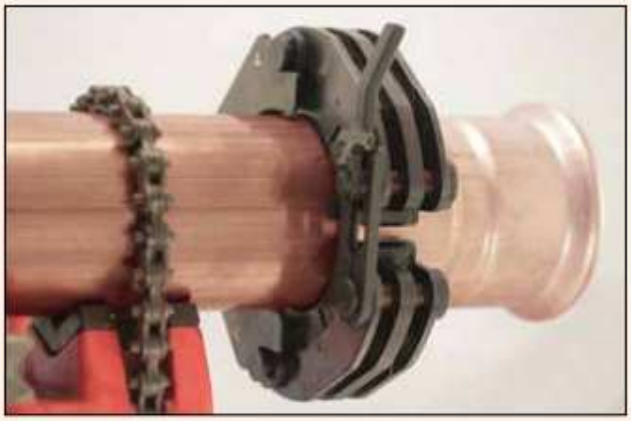
Prior to the following installation steps, complete st eps 1- 4 as per the 15-35mm installations instructions on page 9.

STEP 5

Select the 108mm press collar and check that it is clean and that the surface is smooth. In order to ensure correct operation of the press collar, the sliding segments must be free to move/slide. The sliding segments are tensioned by springs, holding them in the correct starting position. Please ensure that the marking lines on the inner and outer rings form a line for the correct starting position. If the segments are not freely moving, clean and lubricate with light machine oil or have them serviced by an approved KemPress® service agent.

STEP 6

Place the collar around the KemPress® fitting such that the bead of the fitting is inserted into the slot of the press collar. Close press collar and secure the fastening latch. Make certain that the press collar fits tightly into the fitting. Afterwards position the pressing collar by rotating it so that the pressing machine can be correctly attached.



SPECIFICATIONS — Copper Pipe and Fitting

Copper Press Fitting108mm

Prior to the following installation steps, complete st eps 1- 4 as per the 15-35mm installations instructions on page 9.

STEP 7
Select adaptor jaw ZB221 for the 108mm dimensions first press. Insert the adaptor jaw into the press tool and close the locking bolts.

STEP 8
Open the adaptor jaw by depressing the jaw levers and attach to the press collar so that the claws of the adaptor jaw grip around the pins of the press collar. Check whether fittings outer edge lines up with the marker of the insertion depth then start the pressing procedure by pressing the start button. The pressing procedure should not be interrupted prematurely. Following this procedure ensures a permanently sealed connection always results. After completing the pressing process, the pressing tool can be removed from the press collar by opening the intermediate jaw. Then carry out step 7 to 9 using the intermediate jaw ZB222 to complete the second stage of pressing in order to close the press collar completely. For safety, the pressing process can be stopped by pressing the emergency stop button. Once the emergency button has been activated, the tool will need to be reset. The affected fitting and tube section should be discarded and new components used.

NOTE: Step 8 requires the use of the ZB221 and ZB222 adaptor jaws. The process requires two presses in total.