

Installation guide for 15mm to 35mm fittings

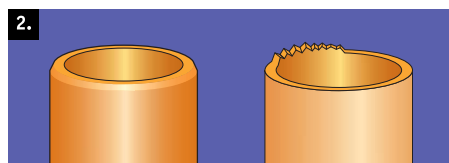
Preliminaries

Select the correct size of tube and fitting for the job. Ensure that both are clean, in good condition and free from damage and imperfections.

Preparation



1. Cut the tube square using a rotary tube cutter.



2. Care must be taken to ensure that tube is cut square, properly deburred and free from scores.



3. Deburr both internal and external tube ends then wipe clean of all swarf and debris to avoid damage to the 'O' ring upon tube insertion. A S120 deburring tool can be used for this purpose.



4. If a deburrer is not available use a fine file to prepare the tube end.



5. The tube must be fully inserted to the fitting until it meets the tube stop. Use a S110 XPress depth gauge or ruler to mark the insertion (socket) depth of the fitting onto the tube – see table below.

Fitting socket depths

Size	XPress Copper
15mm	20mm
22mm	21mm
28mm	23mm
35mm	26mm

Jointing 15mm to 35mm

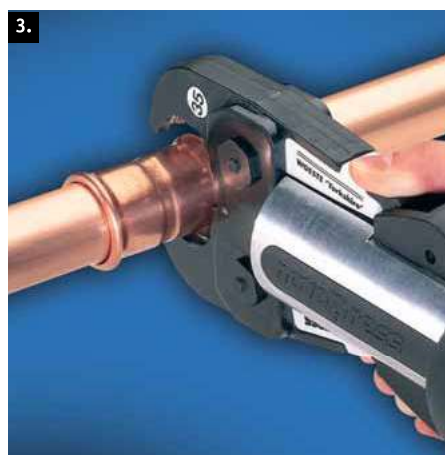
Please refer to the press-fit tool manufacturers instructions for detailed operating and safety information before pressing joints. Yorkshire Fittings recommends Novopress tools.



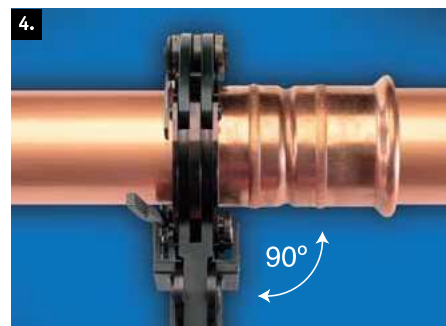
1. Keep all fittings in their bag prior to installation to ensure the lubrication does not dry out. Ensure the 'O' ring is seated correctly within the fitting socket.



2. Assemble the joint, ensuring the tube is inserted 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 undertaken.



3. Insert the correctly sized jaws into the press-fit tool and place them over the bead at the mouth of the fitting.



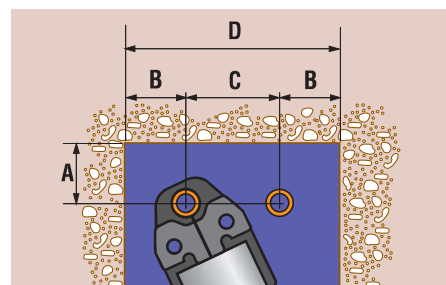
4. A 90° angle between the tube and jaws must be maintained when pressing all joints. The pressing operation should only be carried out when the tube is adequately supported by brackets, not when the tube is suspended in the fitting socket alone.



5. Press the trigger or button to start the jointing cycle. When the jaws fully enclose the mouth of the fitting, the joint is complete. The jaw should then be released from around the fitting.

Spacing

Allow sufficient clearance around each fitting to allow press-fit jaws to be attached without hindrance.



Pipework clearance

Size	A	B	C	D
15mm	25mm	28mm	75mm	131mm
18mm	25mm	28mm	75mm	131mm
22mm	31mm	35mm	80mm	150mm
28mm	31mm	35mm	80mm	150mm
35mm	31mm	44mm	80mm	170mm

Health and Safety

1. We recommend that eye protection is worn when operating all press-fit tools.
2. Do not activate a press-fit tool without a fitting in the jaws.

Further information

Further detailed information about our XPress Copper range can be downloaded from our website.

Installation guide for 42mm to 108mm fittings

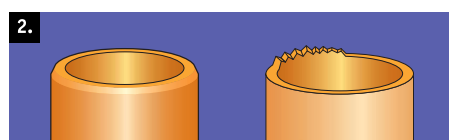
Preliminaries

Select the correct size of tube and fitting for the job. Ensure that both are clean, in good condition and free from damage and imperfections.

Preparation



1. Cut the tube square using a rotary tube cutter.



2. Care must be taken to ensure that tube is cut square, properly deburred and free from scores.



3. Deburr both internal and external tube ends then wipe clean of all swarf and debris to avoid damage to the 'O' ring upon tube insertion. A S120 deburring tool can be used for this purpose.



4. Alternatively use the appropriate sized S122 XPress percussion deburrer.



5. If a deburrer is not available use a fine file to prepare the tube end.



6. The tube must be fully inserted to the fitting until it meets the tube stop. Use a S110 XPress depth gauge or ruler to mark the insertion (socket) depth of the fitting onto the tube – see table below.

Fitting socket depths

Size	XPress Copper
42mm	30mm
54mm	35mm
67mm	50mm
76mm	50mm
108mm	64mm

Joining 42mm to 108mm

Please refer to the tool press-fit manufacturers instructions for detailed operating and safety information before pressing joints. Yorkshire Fittings recommends Novopress tools. 108mm XPress Copper fittings must only be pressed with sling jaws marked for copper only.



1. Assemble the joint, ensuring the tube is inserted 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 undertaken.



2. Select the appropriate size sling jaw, open the sling by depressing the spring loaded pin, pull the sling apart and place over the fitting. Make sure the groove in the sling corresponds to the bead on the fitting and the support plate on the sling fits over the tube side of the joint.



3. Turn the catch mechanism toward the locking pin, depress the spring loaded pin and push the catch into the pin until the mechanism engages. Revolve the sling around the fitting to the desired pressing position.



4. Attach the appropriate adaptor to the press tool and close the breach bolt.



5. Attach the sling by depressing the jaw levers and inserting the claws as far as possible into the grooves of the sling. A 90° angle between the tube and sling must be maintained when pressing all joints. Commence the pressing operation by pressing the trigger or button.



6. When pressing has been completed the adaptor should be disengaged by depressing the jaw levers, and the slings removed from the fitting.

108mm Second press



7. For 108mm fittings the press sling should be left in place and the secondary adaptor (S324) attached. Re-check to ensure the tube is still fully inserted into the fitting and repeat the pressing operation to complete the procedure.

The 108mm joint is not fully made until the fitting has been through two pressing operations.

Dri-Slide lubricant



The use of S135 Dri-Slide lubricant is essential when joining large sized fittings. The pressing profile groove (1) of the sling jaws should be cleaned and lubricated after every 50 joints for 42mm to 76mm sizes, and every 5 joints for 108mm. Dri-slide should also be applied between the main sling arms (2) and the moving segments; and along the pivot pins (3) between the arms.

Note: Wipe clean any excess lubricant so that it does not come into contact with the fitting 'O' ring.

Spacing

Allow sufficient clearance around each fitting to allow press-fit jaws to be attached without hindrance.

Health and Safety

1. We recommend that eye protection is worn when operating all press-fit tools.

2. Do not activate a press-fit tool without a fitting in the jaws.