

## Press Fitting Installation Method



### Cut The Pipe

Use a pipe cutting device to cut off the pipe. To avoid burr stabbing the seal, use a special deburring or rasp to completely remove the burrs. Can also choose to import convenient pipe cutting machine, cut the end of the tube without burr, no deformation.



### Draw lines

Use the scribe to draw lines at the tube end to ensure that the pipe is inserted enough length to avoid falling off.



### Insert the tube

Insert the pipe straight into the tube, be careful not to scratch the O-Ring, and confirm the end of the pipe and the line position within 3mm



### Press

Place the pressing tool on the press connection to be produced, at right angles to the pipe, in such a way that the bead of the fitting engages in the groove of the press jaw. Then check whether the outer edge of the fitting corresponds with the marking.



### Check the clamping dimensions

Use hexagonal gauge to confirm press size is in right place or not, the press position can be completely inserted into the hexagonal gauge, that is correct. To avoid the failure of the pressing tool.

### Installation Precautions

Do not puncture the O-ring in the pipe fitting;

The pipe must be inserted into the correct position at the mark;

Do not forget the Press work operation.

### PIPE INSERTION LENGTH REFERENCE

Nominal Size DN	Pipe Outside Diameter D (mm)	Pipe fitting Wall Thickness T(mm)	Pipe Insertion Length L1(mm)
15	18	1.5	20±3
20	22	1.5	21±3
25	28	1.5	23±3
32	35	1.5	26±4
40	42	1.5	30±4
50	54	1.5	35±4
65	76.1	2.0	53±5
80	88.9	2.0	60±5
100	108	2.0	75±5