

CONNECT + CONTROL

PEGLER 
Valve technology



XPRESS PRESS POWER TOOLS

CONNECT WITH CONFIDENCE

XPress





CONNECT WITH CONFIDENCE

With a wealth of expertise and the broadest range of solutions and systems on the market, Pegler Yorkshire's Connect products mean you'll complete your installation as seamlessly, efficiently and effectively as possible.

TOTAL FUNCTIONALITY, COMPLETE EFFICIENCY

Pegler Yorkshire's range of **Connect** solutions offer innovatively designed, efficient and reliable products and systems that reduce installation time and cost without compromising quality, aesthetics or reliability.

Our **XPress** and **Tectite** product ranges are designed to perform faultlessly in a variety of applications and environments – so you can always be sure to connect with confidence whatever your challenge.

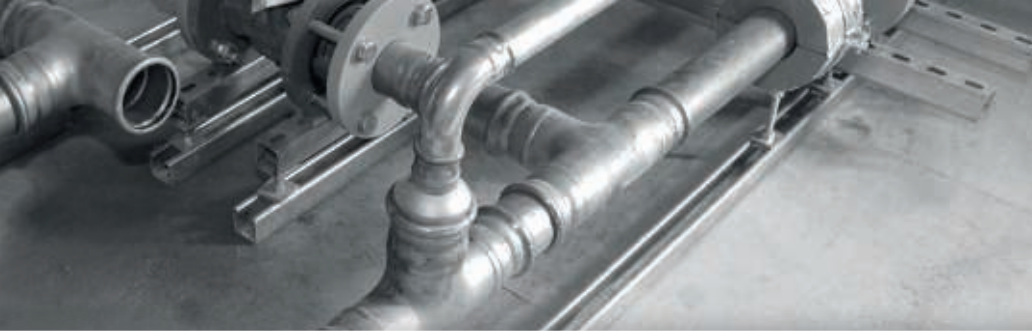
GLOBAL EXPERIENCE, COMBINED EXPERTISE

With over 100 years of manufacturing and innovation combined with extensive industry knowledge and worldwide market experience, Pegler Yorkshire offers the most advanced and complete **Connect + Control** systems on a global scale.

As one of Britain's largest and most respected manufacturers and suppliers of products for the plumbing and heating industries, Pegler Yorkshire is confident we can provide you with all the connection, control and support your project needs.

For more information visit
www.pegleryorkshire.co.uk





XPress

CONNECT + CONTROL

CONTENTS

Pegler Yorkshire is pleased to be associated with several influential industry organisations:



Association of Plumbing and Heating Contractors



The Bathroom Manufacturers Association



The UK Copper Board



Heating and Ventilating Contractors Association

Brass

The Brass Page for specifiers, designers, engineers and manufacturers



British Plumbing Employers Council



British Electrotechnical Allied Manufacturers Association



Construction Products Association



The Copper Development Association



Scottish and Northern Ireland Plumbing Employers Federation



Builders Merchants Federation



Institute of Plumbing



The UK District Energy Association



The Chartered Institution of Building Services Engineers



British Automatic Fire Sprinkler Association



Bundesverband Technischer Brandschutz e.V.



European Fire Sprinkler Network

POWER TOOLS

Tool/system compatibility

4-5

PRESS TOOLING

Up to 35mm

6

Up to 54mm

7-8

Up to 108mm

9-12

Up to 168.3mm & Sprinkler applications

13

ACCESSORIES

Batteries & chargers

14

PRESS TOOL COMPATIBILITY

Press tools approved for pressing XPress

15-16

INSTALLATION INSTRUCTIONS

Step by step process

17-21

Operating procedure

22-23

TOOL/SYSTEM COMPATIBILITY

Tool Type	Material						
	Copper	Carbon	Stainless	Copper Gas	Stainless Gas	Solar	Sprinkler
ACO102 Battery	12-35mm	12-35mm	12-35mm	12-35mm	12-35mm	12-35mm	12-35mm
ECO203 Mains	12-54mm	12-54mm	12-54mm	12-54mm	12-54mm	12-54mm	12-54mm
ACO203 Battery	12-54mm	12-54mm	12-54mm	12-54mm	12-54mm	12-54mm	12-54mm
ACO203XL Battery	12-108mm	12-108mm	12-108mm	12-108mm	12-108mm	12-108mm	12-54mm
ECO301 Mains	12-108mm	12-108mm	12-108mm	12-108mm	12-108mm	12-54mm	12-54mm
ACO401 Battery	-	76.1-108mm	76.1-168.3mm	-	76.1-108mm	-	76.1-108mm

Tool Type	Product															
	S11 PB1 PB1 Jaws	S227 ECOTEC Jaws	S327 ECO301 Jaws	S288 Snap On Sling	S330 Snap On Sling	S322 Cu Only Sling	S323 Sling Set 139.7mm	S324 Sling Set 168.3mm	S410 HP Snap On Sling	S411 HP401 Snap On Sling	S229 ZB203 Adaptor	S331 ZB323 Adaptor	S332 ZB324 Adaptor (2nd Press)	S329 ZB303 Adaptor	S231 ZB221 Adaptor	S232 ZB222 Adaptor (2nd Press)
ACO102	12-35mm	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-
ECO203	-	15-35mm	-	42-54mm	-	-	-	-	35-54mm	-	35-54mm	-	-	-	-	-
ACO203	-	15-35mm	-	42-54mm	-	-	-	-	35-54mm	-	35-54mm	-	-	-	-	-
ACO203XL	-	15-35mm	-	42-54mm	66.7-108mm	108mm	-	-	35-54mm	-	35-54mm	-	-	-	66.7- 108mm	108mm
ECO301	-	-	15-35mm	42-54mm	66.7-108mm	108mm	-	-	35-54mm	-	-	66.7- 108mm	108mm	35-54mm	-	-
ACO401	-	-	-	-	-	*	139.7mm	168.3mm	^	76.1-108mm	-	-	-	-	-	-

* Cu Only. ^ Not for Cu

	S351 203 42/54mm Jaw & Sling Set	S352 301 76.1/88.9 Jaw & Sling Set	S352 301 108 Jaw & Sling Set	S211 PB1 Jaw Set 15-35mm	S227 ECOTEC Jaw Set 15-35mm	S353 203XL 66.7-88.9 Sling + Adaptor Set	S353 203XL 108 Sling & Adaptor Set
ACO102	-	-	-	15-35mm Jaws	-	-	-
ECO203	42-54mm Slings + ZB203 Adaptor	-	-	-	15-35mm Jaws	-	-
ACO203	42-54mm Slings + ZB203 Adaptor	-	-	-	15-35mm Jaws	-	-
ACO203XL	42-54mm Slings + ZB203 Adaptor	-	-	-	15-35mm Jaws	66.7-88.9 Slings + ZB221 Adaptor	108 Sling + ZB222 Adaptor
ECO301	42-54 Slings + ZB203 Adaptor	76.1-88.9mm Slings + ZB323 Adaptor	108mm S330 Sling + ZB324 Adaptor	-	-	-	-
ACO401	-	-	-	-	-	-	-

Pegler Yorkshire recommends the preferred XPress branded tooling for jointing XPress fitting Systems utilising the XPress Slings, Jaws and Tools. New and improved, they provide greater performance whilst being lighter and easier to handle. Incorporating an 'X' symbol, they provide an instant visual aid indicating the joint has been pressed using the preferred XPress tooling. The maintenance of tooling is critical to the joint integrity, therefore the installer should ensure the tools are maintained in accordance with the manufacturer's instructions and serviced by a recommended tool-hire service centre.

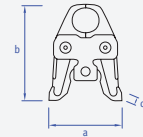
ACO102



Power	Charging Time	Piston Force	Piston Stroke	Item Code
Battery 12V UPCR Li-Ion 1.5/3.0Ah	60 min	Max. 19kN	30mm	39195
Compatible with XPress Systems		Tool Dimensions		Other
Copper, Carbon Steel, Stainless Steel, Copper Gas, Stainless Steel Gas and Solar		350 x 62 x 80mm 1.7Kg		LED display for battery status and press error indicator
Contains				
S210 ACO102, 2 x Batteries, Battery Charger Carry Case 480 x 350 x 110mm Total Weight: 4.1Kg				

S211 PB1 Jaws

Size	a	b	c	Kg	Code
12mm	122	101	35	1	39191
15mm	122	101	35	1	39188
18mm	124	101	35	1	39189
22mm	126	101	35	1	39202
28mm	131	101	35	1	39203
35mm	143	101	35	1	39209



The full kit of 15-35mm jaws is available under product code 39065

Domestic Tool Box 15-28mm

Size	Height	Width	Depth	Kg	Code
15-28mm	290	510	130	12	84727
Contains					
Rems Mini Press Tool Acc + Spare Battery + Charger 15-28mm Jaws + Installation accessories					



PRESS TOOLING UP TO 54mm

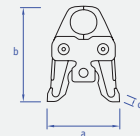
ACO203



Power	Charging Time	Piston Force	Piston Stroke	Item Code
Battery 18V Li-Ion 1.5/3.0Ah	60 min	Max. 32kN	40mm	39201
Compatible with XPress Systems	Tool Dimensions		Other	
Copper, Carbon Steel, Stainless Steel, Copper Gas, Stainless Steel Gas and Solar	408 x 80 x 125mm 3.3Kg		Visible electronic sensor for jaw locking bolt. Contains electronic log book for analysis	
Contains				
S226 ACO203, 1 x Battery, Battery Charger, Carry Case 557 x 422 x 132mm Total Weight: 7.9Kg				

S227 ECOTEC PB2 Jaws

Size	a	b	c	Kg	Code
12mm	143	110	39	2	39179
15mm	143	110	39	2	39180
18mm	143	110	39	2	39181
22mm	147	110	39	2	39182
28mm	147	110	39	2	39183
35mm	154	110	39	2	39184

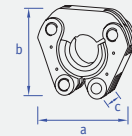


A full kit of ACO203 tool with the 15-35mm jaws is available under product code 39040

A full kit of 15-35mm jaws is available under product code 39068

S228 Snap On sling

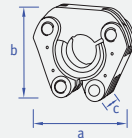
Size	a	b	c	Kg	Code
42mm	112	100	41	1	39186
54mm	124	112	41	2	39187



S410 HP Snap On sling

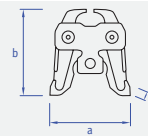
Not suitable for copper *For Sprinkler applications

Size	a	b	c	Kg	Code
42mm	125	120	41	2	39269
54mm	125	122	41	2	39271



S229 ZB203 Adaptor

Size	a	b	c	Kg	Code
35-54mm	142	124	33	1	39190



S351 42-54mm Kit (S228 42 and 54mm Slings and ZB203 Adaptor)

Size	Height	Width	Depth	Kg	Code
42-54mm	355	410	110	5	39041



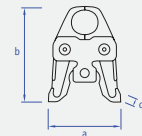
ECO203



Power	Piston Force	Piston Stroke	Item Code
Mains 110V, 450W	Max. 32kN	40mm	39244
Compatible with XPress Systems	Tool Dimensions		Other
Copper, Carbon Steel, Stainless Steel, Copper Gas, Stainless Steel Gas and Solar	430 x 75 x 111mm 3.9Kg		Visible electronic sensor for jaw locking bolt. Contains electronic log book for analysis
Contains			
S225 ECO203 Carry Case 430 x 75 x 111mm Total Weight: 5.5Kg			

S227 ECOTEC PB2 Jaws

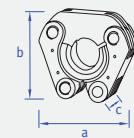
Size	a	b	c	Kg	Code
12mm	143	110	39	2	39179
15mm	143	110	39	2	39180
18mm	143	110	39	2	39181
22mm	147	110	39	2	39182
28mm	147	110	39	2	39183
35mm	154	110	39	2	39184



A full kit of 15-35mm jaws is available under product code 39068

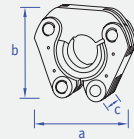
S228 Snap On sling

Size	a	b	c	Kg	Code
42mm	112	100	41	1	39186
54mm	124	112	41	2	39187



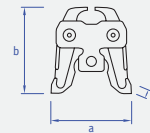
S410 HP Snap On sling Not suitable for copper *For Sprinkler applications

Size	a	b	c	Kg	Code
35mm	112	100	41	2	39268
42mm	125	120	41	2	39269
54mm	125	122	41	2	39271



S229 ZB203 Adaptor

Size	a	b	c	Kg	Code
35-54mm	142	124	33	1	39190



S351 42 and 54mm Kit (S228 42 and 54mm Slings and ZB203 Adaptor)

Size	Height	Width	Depth	Kg	Code
42-54mm	355	410	110	5	39041



PRESS TOOLING UP TO 108mm

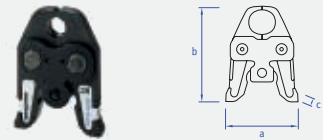
ACO203XL



Power	Charging Time	Piston Force	Piston Stroke	Item Code
Battery 18V Li-Ion 1.5/3.0Ah	60 min	Max. 32kN	40 or 80mm	39285
Compatible with XPress Systems		Tool Dimensions		Other
Copper, Carbon Steel, Stainless Steel, Copper Gas, Stainless Steel Gas and Solar		487 x 79 x 116mm 4.6Kg		Visible electronic sensor for jaw locking bolt. Contains electronic log book for analysis
Contains				
S230 ACO202XL, 2 x Batteries, Battery Charger, Carry Case 639 x 446 x 151mm Total Weight: 10.6Kg				

S227 ECOTEC PB2 Jaws

Size	a	b	c	Kg	Code
12mm	143	110	39	2	39179
15mm	143	110	39	2	39180
18mm	143	110	39	2	39181
22mm	147	110	39	2	39182
28mm	147	110	39	2	39183
35mm	154	110	39	2	39184



A full kit of 15-35mm jaws is available under product code 39068

S228 Snap On sling

Size	a	b	c	Kg	Code
42mm	112	100	41	1	39186
54mm	124	112	41	2	39187



S330 Snap On sling

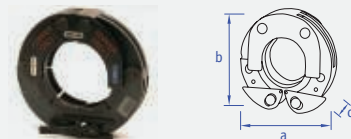
Size	a	b	c	Kg	Code
66.7mm	151	143	61	4	39220
76.1mm	164	155	61	4	39221
88.9mm	175	167	55	4	39224
108mm	209	205	77	6.3	39225



*S330 in size 108mm is not suitable for copper, use S322

S322 Sling (copper only)

Size	a	b	c	Kg	Code
108mm	200	200	60	5	39222



S410 HP Snap On sling Not suitable for copper

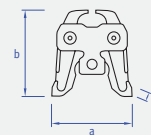
Size	a	b	c	Kg	Code
35mm	112	100	41	2	39268
42mm	125	120	41	2	39269
54mm	125	122	41	2	39271



ACO203XL continued

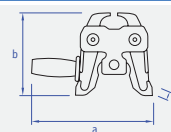
S229 ZB203 Adaptor

Size	a	b	c	Kg	Code
35-54mm	142	124	33	1	39190



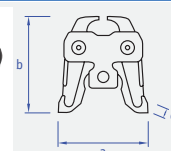
S231 ZB221 Adaptor

Size	a	b	c	Kg	Code
66.7-108mm	155	216	43	5	39286



S232 ZB222 Adaptor (2nd press)

Size	a	b	c	Kg	Code
108mm	155	216	43	5	39287



S351 42-54mm Kit (S228 42 and 54mm Slings and ZB203 Adaptor)

Size	Height	Width	Depth	Kg	Code
42-54mm	355	410	110	5	39041



S336 ACO203XL & Slings Kit (S330 66.7-108mm Slings and ZB221 and ZB222 Adaptors)

Size	Height	Width	Depth	Kg	Code
66.7-108mm	583	639	446	37	39240



S353 66.7-88.9mm Kit (S330 66.7-88.9mm Slings and ZB221 Adaptor)

Size	Height	Width	Depth	Kg	Code
66.7-88.9mm	360	545	280	20	39045



S353 108mm Kit (S330 108mm Sling and ZB222 Adaptor)

Size	Height	Width	Depth	Kg	Code
108mm	360	545	280	14	39046



PRESS TOOLING UP TO 108mm

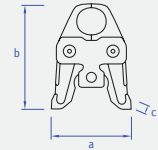
ECO301



Power	Piston Force	Piston Stroke	Item Code
Mains 110V, 560W	Max. 45kN	45mm	39199
Compatible with XPress Systems	Tool Dimensions		Other
Copper, Carbon Steel, Stainless Steel, Copper Gas, Stainless Steel Gas and Solar, Sprinkler ≤ 54mm Carbon Steel and Sprinkler ≤ 54mm Stainless Steel	420 x 85 x 110mm 5.0Kg		Fast pressing cycle for quick installation. Microprocessor driven for constant optimisation of pressing performance
Contains			
S303 ECO301 Carry Case 639 x 466 x 151mm Total Weight: 12.3Kg			

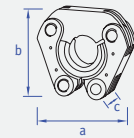
S327 ECO301 PB3 Jaws

Size	a	b	c	Kg	Code
12mm	150	128	39	2	39194
15mm	150	128	39	2	39204
18mm	150	128	39	2	39205
22mm	154	127	39	2	39206
28mm	154	127	39	2	39207
35mm	163	129	39	2	39208



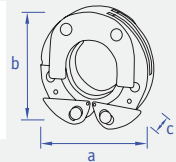
S228 Snap On sling

Size	a	b	c	Kg	Code
42mm	112	100	41	1	39186
54mm	124	112	41	2	39187



S330 Snap On sling

Size	a	b	c	Kg	Code
66.7mm	151	143	61	4	39220
76.1mm	164	155	61	4	39221
88.9mm	175	167	55	4	39224
108mm	209	205	77	6.3	39225



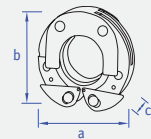
66.7 - 88.9mm

108mm

*S330 in size 108mm is not suitable for copper, use S322

S322 Sling (copper only)

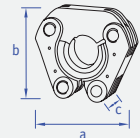
Size	a	b	c	Kg	Code
108mm	200	200	60	5	39222



S410 HP Snap On sling

Not suitable for copper

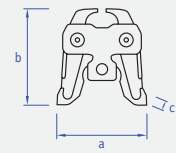
Size	a	b	c	Kg	Code
35mm	112	100	41	2	39268
42mm	125	120	41	2	39269
54mm	125	122	41	2	39271



ECO301 continued

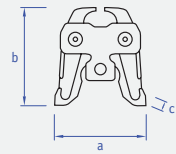
S331 ZB323 Adaptor

Size	a	b	c	Kg	Code
66.7-108mm	136	195	43	4	39213



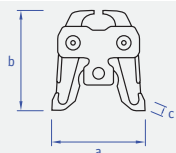
S332 ZB324 Adaptor (2nd Press)

Size	a	b	c	Kg	Code
108mm	136	188	53	4	39214



S329 ZB303 Adaptor

Size	a	b	c	Kg	Code
35-54mm	144	129	39	1	39227



S352 76.1-88.9mm Kit (S330 76.1-88.9mm Slings and ZB324 Adaptor)

Size	Height	Width	Depth	Kg	Code
76.1-88.9mm	355mm	470mm	110mm	14	39042



S352 108mm Kit (S330 108mm Sling and ZB324 Adaptor)

Size	Height	Width	Depth	Kg	Code
108mm	355mm	470mm	110mm	13	39043



PRESS TOOLING UP TO 168.3mm & SPRINKLER APPLICATIONS

ACO401

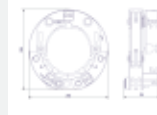


Power	Piston Force	Piston Stroke	Item Code
Battery 18V Li-Ion	Max. 100kN	60mm	39267
Compatible with XPress Systems	Tool Dimensions		Other
Sprinkler; Carbon Steel and Sprinkler; Stainless Steel in sizes 76.1 – 168mm	660 x 100 x 250mm 13.0Kg		Microprocessor driven for constant optimisation of pressing performance
Contains			
S400 ACO401 Carry Case 630 x 130 x 465mm Total Weight: 25Kg			

LARGE SIZE APPLICATION

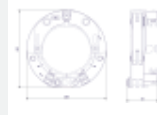
S323 Sling Set 139.7mm

Size	a	b	c	Kg	Code
139.7mm	250	250	110	10	39038



S324 Sling Set 168.3mm

Size	a	b	c	Kg	Code
168.3mm	283	277	111	12	39039



SPRINKLER SYSTEM APPLICATION

S411 HP401 Snap On Sling

Not suitable for copper

Size	a	b	c	Kg	Code
76.1mm	290	400	100	7.8	39273
88.9mm	290	400	100	8.4	39277
108mm	290	400	100	9.4	39279



All 108mm fittings, regardless of material, require a 2nd press using the respective adaptor, with the exclusion of the S400 ACO401 as this is supplied with an internal adaptor.

BATTERIES

S340 ACO102 Battery

Size	Code
Li-Ion 12V 1.5Ah	39288
Li-Ion 12V 3Ah	39289

S340 – for use with ACO102 tool

S342 ACO203 Battery 203XL 401

Size	Code
18V 1.5Ah	39292
18V 3Ah	39293

S342 – for use with ACO203/203XL/401 tools. ACO203XL and ACO401 must use the 3.0Ah battery.

CHARGERS

S341 ACO102 Charger

Size	Code
12V (220-240v)	39290

S343 ACO203/401 Charger 203XL

Size	Code
230V	39291

SS110 Depth gauge

Suitable for copper



Size	Code
12 - 108mm	39173

SS122 Copper tube preparation kit



Size	Code
35 - 54mm	39233

S120 Deburring tool



Size	Code
12 - 54mm	39168

S115 Tube stripper

For use with SC660 tube



Size	Code
15mm	39260
18mm	39261
22mm	39262
28mm	39263
35 - 54mm	39264

SS111 Depth gauge

Suitable for carbon and stainless steel



Size	Code
12 - 108mm	39174

S135 Dri-slide lubricant

For use with jaws and slings only



Size	Code
115ml	39169

PRESS TOOL COMPATIBILITY

PRESS TOOLS APPROVED FOR PRESSING XPRESS						
Dimension (mm)	Manufacturer	Press Tool	Systems	Jaws (up to 35mm)	Sling Jaw adaptor (42mm and above)	Sling (Copper Stainless/Carbon)
12 - 35mm	REMS	REM-578012 Mini-Press ACC Battery powered (14.4V)	-	Mini M12 - M35*	-	-
1 - 54mm	REMS	REM-571013 Akku-Press Battery powered (14.4V)	-	M12 - M35*	Z2	M42 (PR-3S) M54 (PR-3S)
		REM-571014 Akku-Press ACC Battery powered (14.4V)	-	M12 - M35*	Z3	M42 (PR-3S) M54 (PR-3S)
		REM-577011 Power-Press	-	M12 - M35*	Z3	M42 (PR-3S) M54 (PR-3S)
		REM-572110 Power-Press E	-	M12 - M35*	Z3	M42 (PR-3S) M54 (PR-3S)
		REM-577010 Power-Press ACC	-	M12 - M35*	Z3	M42 (PR-3S) M54 (PR-3S)
12 - 28mm	Novopress	AFP101 Battery powered (9.6V)	-	PB1	-	-
		ACO102 Battery powered (12V)	-	PB1	-	-
12 - 54mm	Novopress	EFP2 (230V)	-	PB2 (ECOTEC)	ZB201/ZB203	35 (HP only) / 42 / 54**
		EFP201 / 202 / (230V)	-	PB2 (ECOTEC)	ZB201/ZB203	35 (HP only) / 42 / 54**
		AFP201 / 202 (14.4V)	-	PB2 (ECOTEC)	ZB201/ZB203	35 (HP only) / 42 / 54**
		ECO203	-	PB2 (ECOTEC)	ZB201/ZB203	35 (HP only) / 42 / 54**
		ACO203	-	PB2 (ECOTEC)	ZB201/ZB203	35 (HP only) / 42 / 54**
12 - 54mm	Novopress	ACO203XL	-	PB2 (ECOTEC)	ZB201/ZB203	35 (HP only) / 42 / 54**
		ECO301	-	PB3 (ECO301)	ZB303	35 (HP only) / 42 / 54**
66.7mm	Novopress	ACO203XL	-	-	ZB221	66.7mm Sling***
		ECO301	-	-	ZB323	66.7mm Sling***
76.1 - 108mm	Novopress	ACO203XL	-	-	ZB221	76.1 / 88.9 / 108
		ECO301	-	-	ZB323	76.1 / 88.9 / 108
108mm (2nd)	Novopress	ACO203XL	-	-	ZB222	Snap On Sling (Copper specific)
		ECO301	-	-	ZB324	Snap On Sling (Copper specific)
76.1 - 168.3mm	Novopress	ACO401	Carbon / Stainless / Sprinkler only	-	Integral adaptor on machine	HP401 Snap On Sling
15 - 54mm	Ridgid	RP 340	Not approved with Ridgid jaws - only with compatible Novopress / REMS jaws and slings			

*For 18 and 28mm, only use jaws with marking '108' (Q1,2008) or '208' (Q2 2008) and higher.

**HP Snap On Sling for Stainless / Carbon applications only.

***See page 16 for guidance on pressing 66.7mm fittings.

All 108mm fittings require a 2nd press using the respective adaptor. Copper uses the S322 copper only sling.

*66.7mm (67mm) Sling (S330 Snap On sling)

Novopress offers alternative slings for use on different press systems. As such Pegler Yorkshire reinforces the following instruction.

Where 66.7mm slings are required for crimping XPress fittings, installers must only use the following XPress/Novopress slings and adaptors:

Novopress Reference	Sling Marking	Novopress Adaptor
36516-50	"Woeste" 67mm	ZB302 42-66.7mm
45184-50	"XPress" 66.7mm	ZB323 66.7-108mm

Under no circumstances should any other brand of sling be used with our 66.7mm fittings as these will lead to an incorrect crimp resulting in an immediate joint failure and invalidate the Pegler Yorkshire warranty.

XPress 66.7mm fittings that have inadvertently been crimped with the wrong brand of sling cannot be successfully re-crimped with the XPress 66.7 sling and will unfortunately have to be cut out and replaced with a new fitting using the correct sling.

Note: Pegler Yorkshire 66.7mm will be referred to as 66.7mm and/or 67mm.



POWER SUPPLY

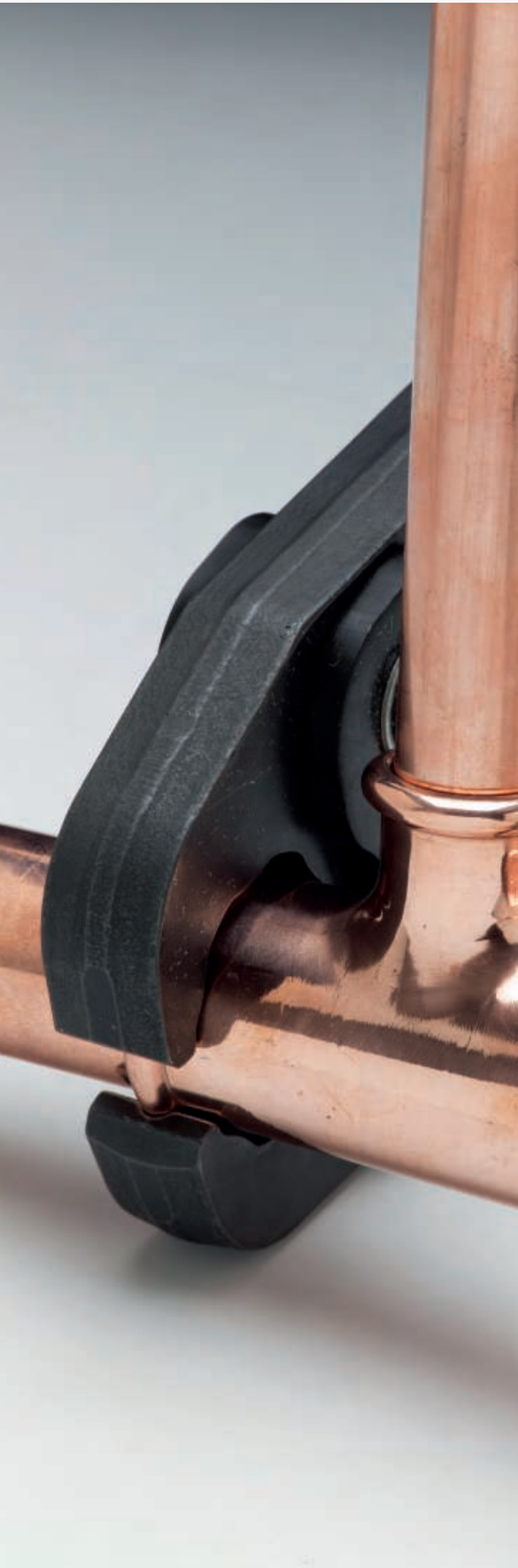
It is essential when preparing to undertake an installation using XPress fittings and tools that a suitable constant power source is available. If the supply of power is not constant it may affect the performance of the joint.

Checking the power source is particularly important prior to joining with the ECO203 and ECO301 tool as it includes safety software, which detects the amount of power available to the machine. If there is not enough for the tool to initiate the pressing cycle and complete a sound joint the tool will not commence the pressing operation. This feature is particularly useful when installing large size press fittings, as the pressure required to press these fittings is significantly greater than for smaller fittings, hence the power supply to the tool must be guaranteed.

It is therefore recommended that when using a portable transformer to provide power to the press tool, the transformer should be a minimum of 3KVA rated in order that a continuous uninterrupted power supply is always available.

When a semi-permanent source of power such as a generator is being used it is essential the plant is well maintained. The maximum cable size from generator to outlet and the minimum length of cable between the power outlet and the tool should be used.

XPRESS INSTALLATION INSTRUCTIONS FOR SIZES UP TO 108mm



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.



1. CHECK THE FITTING

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. CUT THE TUBE SQUARE:

It is essential to cut the tube square using a rotary tube cutter. Pegler Yorkshire recommends using a Rems Cento with the correct cutter wheel for the specific material being cut.

! **NOTE: The tube must always be cut completely. Never partially cut and then broken as this could cause corrosion. Do not use a hacksaw, oil cooled saws, abrasive wheels or flame cutting.**

ACCEPTABLE METHODS OF CUTTING TUBE INCLUDE:

Rotary tube cutter.

Rems Cento.



! **NOTE: Use TC155 for cutting carbon steel tube.**

3. DEBURR AND CHECK THE TUBE ENDS:

Both the internal and external tube ends should be deburred then wiped clean of all swarf and debris to avoid damage to the "O" ring upon tube insertion. Also check that the tube end is clean and free from damage such as scores, tape, labels or adhesive residue.

ACCEPTABLE METHODS OF DEBURRING INCLUDE:

S120 - 15 to 54mm internal and external.

S122 - 15 to 54mm external only but can re-round damaged tube. Use on copper only.



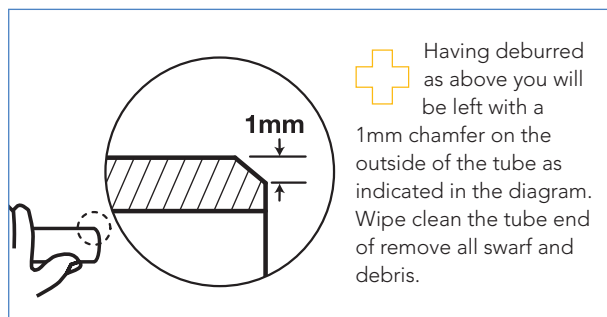
TC150: 15 to 22mm external only, very good for carbon steel tube. TC143 and TC147 internal only.

Hand file.

NOTE: If using plastic coated carbon steel system tube the plastic coating must be removed from the socket depth of the fitting using the S115 stripping tool from the XPress accessories range.



Use the S115 Tube stripper for removing the plastic from plastic coated carbon steel tube.



Having deburred as above you will be left with a 1mm chamfer on the outside of the tube as indicated in the diagram. Wipe clean the tube end of remove all swarf and debris.

4. MARK THE SOCKET DEPTH:

Ensuring full socket depth is achieved is vital for the integrity of the joint. To check that the tube and fitting remains in the correct position throughout the pressing process you must mark the socket depth with a 'V-Tail' mark.



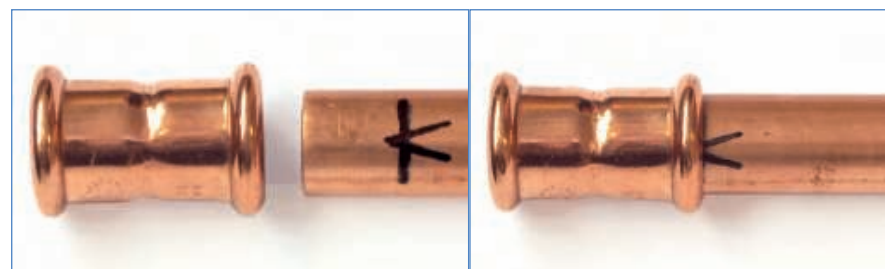
S110 - Orange socket depth tool for copper tube



S111 - Blue socket depth tool for carbon and stainless steel tube



By hand



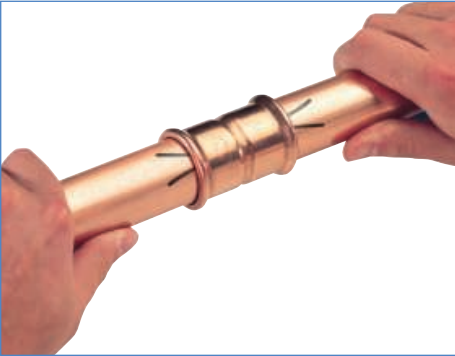
Size	Depth
12mm	17mm
15mm	20mm
18mm	20mm
22mm	21mm
28mm	23mm
35mm	26mm
42mm	30mm
54mm	35mm
66.7mm	50mm
76.9mm (Copper)	50mm
76.9mm (Stainless/Carbon)	55mm
88.9mm	64mm
108mm (Copper)	64mm
108mm (Stainless/Carbon)	78mm

XPRESS INSTALLATION INSTRUCTIONS

5. ASSEMBLE THE JOINT:

Insert the tube 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 commenced.



7. DRI-SLIDE LUBRICANT

Use of S135 Dri-Slide lubricant is essential when jointing large sized fittings. The pressing profile groove of the sling jaws should be cleaned and lubricated after every 50 joints for 42mm to 76.1mm sizes, and every 5 joints for 108mm. Dri-Slide should also be applied between the main sling arms and the moving segments; and along the pivot pins between the arms. Wipe clean any excess lubricant so that it does not come into contact with the fitting "O" ring.

NOTE: Dri-Slide lubricant should never be used to lubricate the "O" ring.

6. PREPARE THE PRESS-FIT TOOL:

Select the correct combination of press-tool, jaws, slings and adaptors for the joint being made.

See notes on page 5 regarding 67mm slings and copper only slings at 108mm.

NOTE: Always refer to the manufacturer's instructions for detailed information on how to operate your press-tool safely.

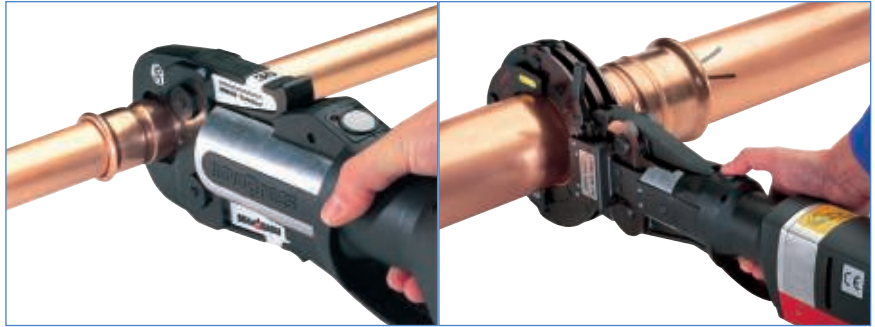
NOTE: Check that the press tool and relevant jaws/slides have been maintained in accordance with their servicing/calibration schedule.

Make the tool safe by isolating it from the power supply. Select the correct jaws/sling jaws/sling jaw adaptor for the joint being made, checking that they are free from damage. Attach the jaws/sling jaws/sling jaw adaptor to your press-tool, following the instructions for your particular press-tool, and reconnect the power supply when ready.



8. PRESS THE JOINT:

Mount the jaws/sling jaws over the bead at the mouth of the fitting. With the tool fully supported and not hanging from the pipework, and with your hands safely away from the joint, press the trigger or button to start the jointing cycle. When the jaws/sling jaws fully enclose the mouth of the fitting, the joint is complete. The jaw should then be released from around the fitting.



15 to 35mm.

Pegler Yorkshire recommend the use of Sling Jaws for sizes 42 to 108mm.



- ⚠ **NOTE: The 108mm joint is not fully made until the fitting has been through two pressing operations.**
- ⚠ **NOTE: Maintain a 90° angle between the tube and jaws at all times, this is to ensure the integrity of the joint as well as protect the operator from 'kickback'.**
- ⚠ **NOTE: 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.**
- ⚠ **NOTE: Allow press-fit jaws to be attached without hindrance.**

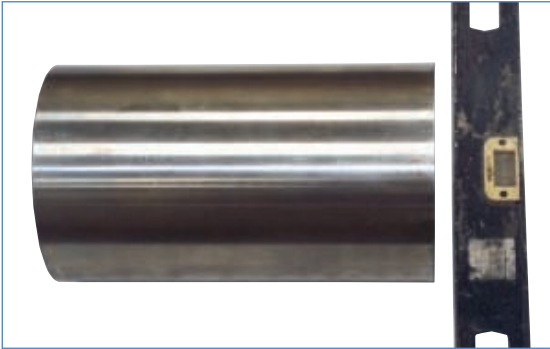
9. CHECK THE JOINT:

Inspect the finished joint making sure all is in order, when satisfied the joint has been made correctly mark the joint as complete.

- ⊕ The socket depth mark you made indicates that full socket depth has been maintained throughout the pressing cycle.
- ⊕ The fitting and pipe bear the witness marks from your jaws/sling jaws.
- ⊕ We recommend all systems are thoroughly pressure tested before hand over to end user.

XPRESS INSTALLATION INSTRUCTIONS FOR SIZES 139.7 - 168.3

Remove the fitting from its packaging and check the fitting and "O" ring for any damage or debris.



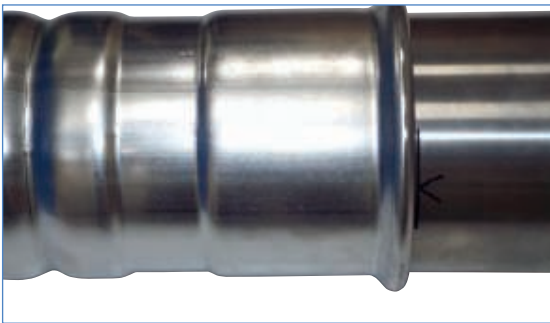
1. Cut tube square to the required length using a fine tooth electric saw and deburr the outer and inner end in order to prevent any damage to the "O" ring.



2. Measure and mark required depth on the tube using a tape measure and marker pen.



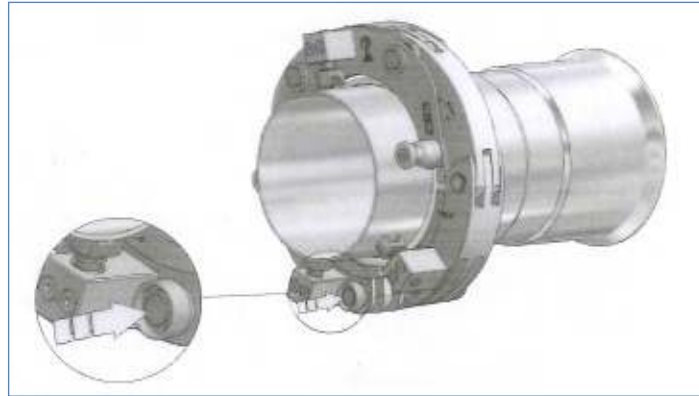
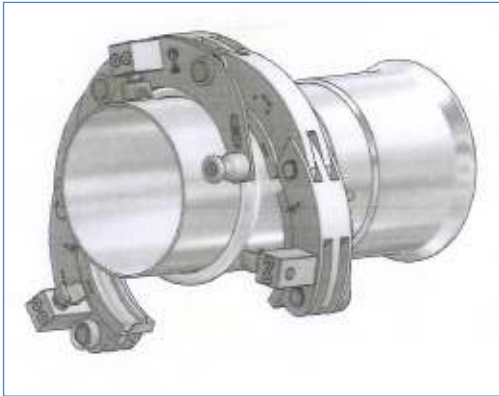
3. Add a 'V' to the mark.
NB: Depth for 139.7mm fitting is 100mm.
Depth for 168.3mm fitting is 121mm.



4. Insert the tube into the fitting until it meets the fitting stop and check that the line and 'V' marking is visible.
Refer to the XPress Tooling Operating Procedure on page 15 of XPress Press-fit systems, for large application.

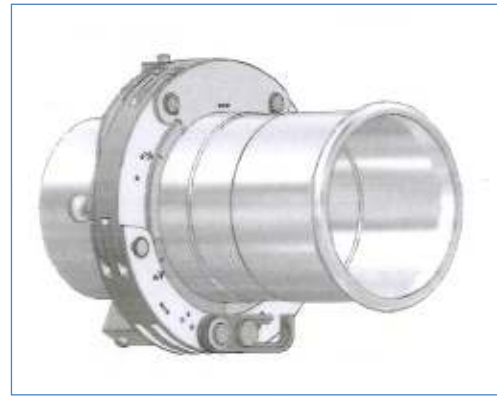
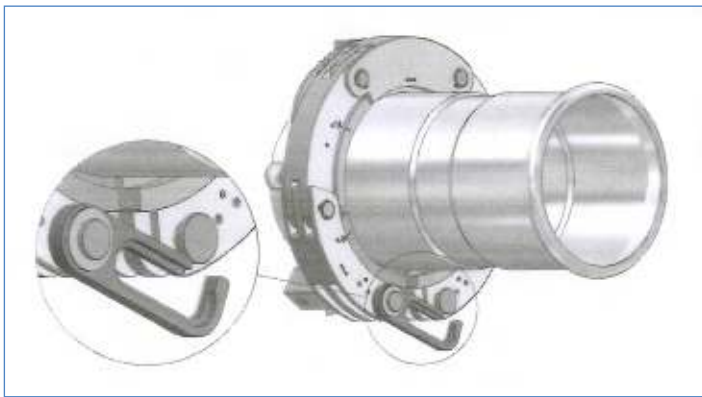
Please see the Pegler Yorkshire website for full installation training video

5. Check the press machine and pressing collar for any signs of damage. If any of these components appear to be damaged, do not continue with the pressing procedure. Be sure to check the tool is within calibration date.



6. Open the collar and place it on the bead of the fitting (the collar joints are spring pre-loaded). Make sure that the wheels are positioned on the tube side of the fitting.

7. Close the collar and press the lock button.



8. Attach the press tool to the mouth of the fitting - use the handle at the top of the press tool to open the jaws on the adaptor. Swivel the catch inwards and secure the lock. The claws of the adaptor jaw must be firmly gripped onto the press collar.

9. Perform pressing operation 1, release the catch and remove the collar. Inspect the finished joint. There will be visible witness marks from your press slings.

DRI-SLIDE LUBRICANT

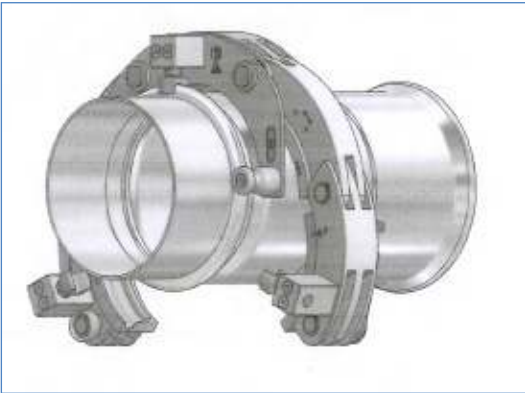
Use of S135 Dri-Slide lubricant is essential when jointing large sizes only. The pressing profile groove of the sling jaws should be cleaned and lubricated after every 5 joints.



NOTE: Dri-Slide lubricant should never be used to lubricate the "O" ring.



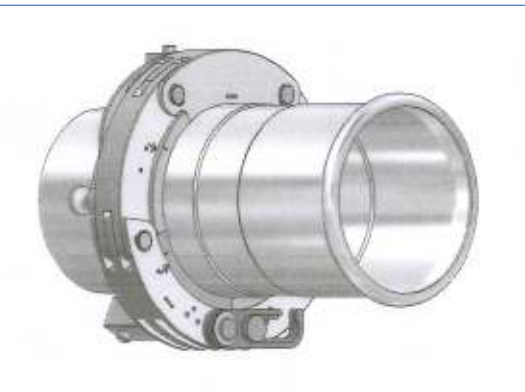
XPRESS TOOLING OPERATING PROCEDURE FOR SIZES 139.7 - 168.3



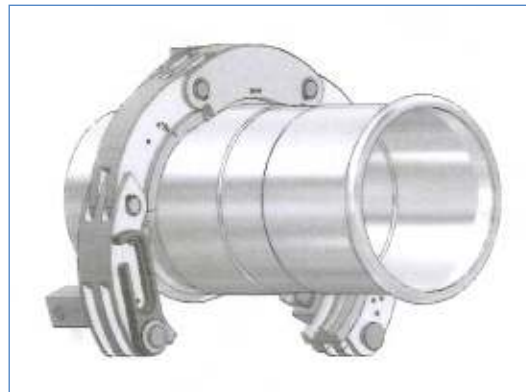
10. Open the mouth of the sling and slide the sling down the fitting until the wheel guides are sitting against the end socket of the fitting.



11. Close the collar, press the lock button, swivel the catch inwards and secure the lock.



12. Attach the press tool to the mouth of the fitting- use the handle at the top of the press tool to open the jaws on the adapter. The claws of the adapter jaw must be firmly gripped onto the press colour. Perform pressing operation 2.



13. Open the lock, swivel the catch away, open the collar and remove it from the fitting.

14. CHECK THE JOINT:

Inspect the finished joint making sure all is in order, when satisfied the joint has been made correctly mark the joint as complete.

- ✚ The socket depth mark you made indicates that full socket depth has been maintained throughout the pressing cycle.
- ✚ The fitting and pipe bear the witness marks from your jaws/sling jaws.
- ✚ We recommend all systems are thoroughly pressure tested before hand over to end user.

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