

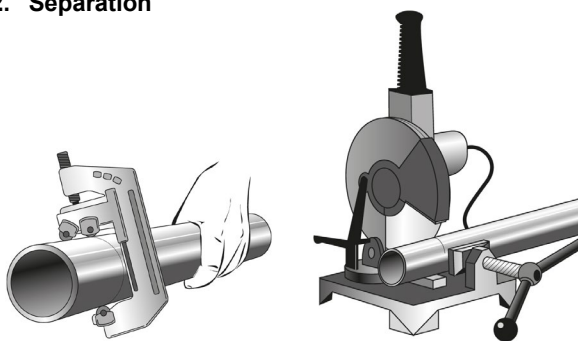
Assembly instructions for PRESS STEEL HD

Please follow the assembly instructions! All system components are designed and tested to be compatible within the system. For components of other suppliers we do not take any guarantee. We assume the compliance with the currently valid technical rules.

1. Transport and storage

In transport and storage PCC press fittings and system-compatible pipes have to be protected against damage, moisture, UV-radiation and defilement.

2. Separation



The system-compatible pipes can be cut to length using commercial cutting tools suitable for metallic pipes.

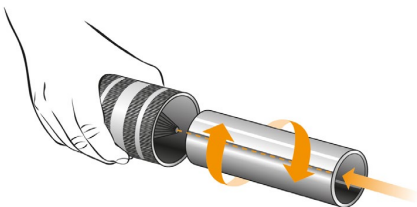
We recommend the use of:

- pipe cutters
- fine-toothed hand saws
- slow running electronic machine saws

The following tools are not permitted:

- oil-cooled saws
- angle grinders

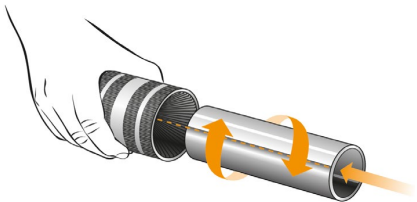
3. Deburring



After cutting procedures the pipe ends must be finished internally and externally with a deburrer or a suitable hand files for steel pipes.

This to ensure that the grip ring/o-ring (gasket) is not damaged when inserting the pipe into the press fitting.

internally



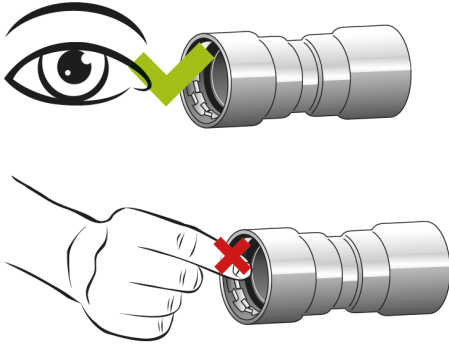
externally



Deburring with suitable hand file

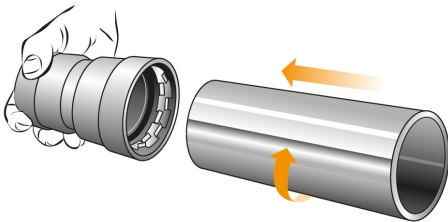
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4. Inspection



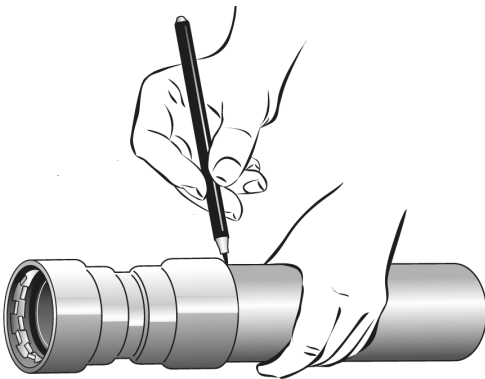
Before inserting the end of the pipe into the press fitting, it is necessary to inspect the sealing element for proper placement, damage and defilement visually.

5. Insertion into the press fitting



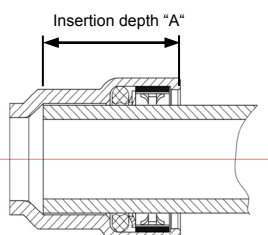
The pipe has to be pushed with light force and a small twist into the press fitting.

6. Marking of the insertion depth



A permanent marking on the PCC system pipe (or insert adapters, street bends f/m or male and crossover bends) is required to make a solid press connection. This marking is to be applied before attaching to the end of the pipe.

Dimension [d] in inch	Insertion depth "A" in mm
½"	28
¾"	29
1"	35
1 ¼"	47
1 ½"	49
2"	51



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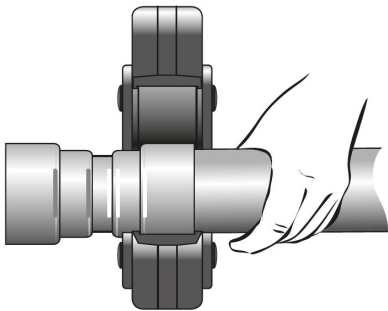
7. Making the press connection

After inserting the PCC system pipe into the PCC press fitting, the press connection can be made with the correct and suitable press machines and corresponding press jaws/press collars with the right press profile.

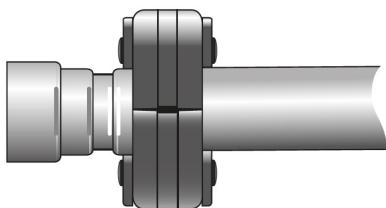
For sizes 42 and up only press collars with the corresponding press-profile may be used.

Depending on the dimension of the press fitting, the corresponding press jaws/press collars are to be inserted into the press device/proper press chain on the moulding. In doing so, the press jaws/press collars must rest on the bead of the press fitting. After the pressing operation, the correctness and proper execution as well as compliance with the designated insertion depth are to be inspected. The user must affirm that all connections have been pressed. After the pressing locations have undergone pressing operations, the pipes may no longer be adjusted. Threaded connections must be executed in advance.

7.1. Pressing with press jaws and visual inspection

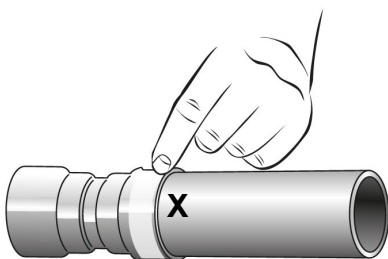


Before pressing, ensure that the fitting is correctly positioned, because it cannot be moved or twisted once the press cycle is completed. Attach the press jaw/press collar with the correct diameter and correct press contour to the correct positioning and begin the pressing process.



Now run the press cycle and ensure that the press jaw/press collar are closed completely.

Only interrupt the pressing cycle in case of emergency.

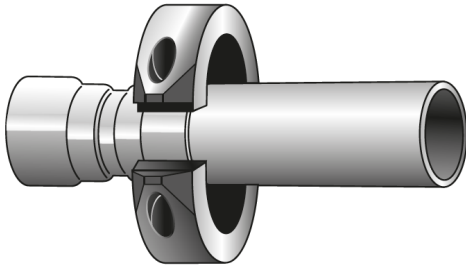


Once the press cycle is finished the press connection is complete. The correct system pressing can be seen by markings on the press profile.

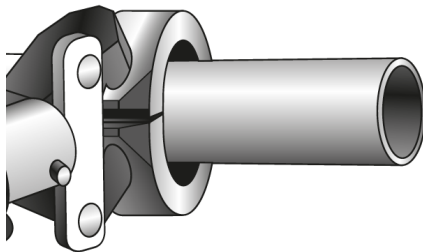
Before leak and pressure test each pressing must be checked visually. We recommend the marking of the system compatible pressing beside or on the press profile.

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7.2. Pressing with press collars and visual inspection

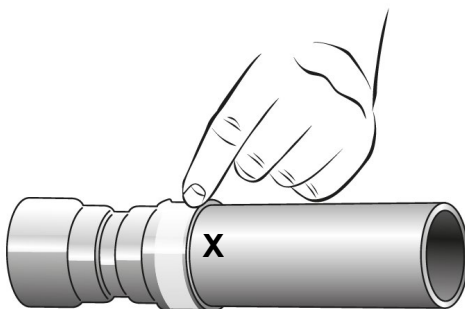


Before pressing, ensure that the fitting is correctly positioned, because it cannot be moved or twisted once the press cycle is completed. Attach the press jaw/press collar with the correct diameter and correct press profile to the correct positioning and begin the pressing process.



Now run the press cycle and ensure that the press jaw/press collar are closed completely.

Only interrupt the pressing cycle in case of emergency.



Once the press cycle is finished the press connection is complete. The correct system pressing can be seen by markings on the press profile.

Before leak and pressure test each pressing must be checked visually. We recommend the marking of the system compatible pressing beside or on the press profile.

8. Pressing with machines and/or press jaws/press collars of other suppliers

If pressing machines or press jaws/press collars which have not been delivered by PCC are used, it has to be ensured that these tools are suitable for PRESS STEEL HD.