



StainlessPress®

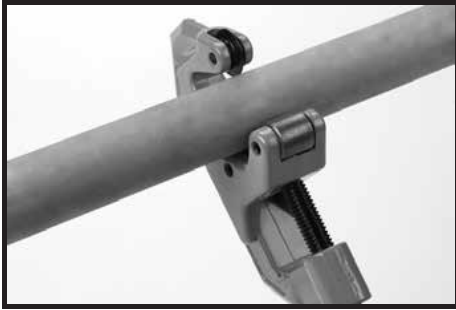
IsoTubi-USA, By Merit Brass Co.



INSTALLATION INSTRUCTIONS

IsoTubi-USA Stainless Steel Fittings and Valves must be installed in accordance with this section.

Always ensure that the pressing tool and its jaws are appropriate for the schedule of pipe and size of fitting or valve. Always refer to the pressing tool manufacturer's instructions for operation and maintenance prior to use with IsoTubi-USA Stainless Steel Fittings and Valves. *Failure to follow these instructions may void the warranty.*



1. SELECT & CUT PIPE

Select the correct size of pipe, fitting or valve for the job. Ensure that both are clean and free from damage and imperfections. Cut pipe squarely, making sure to avoid jagged edges or scratching and denting pipe surface.



4. MEASURE & MARK PIPE

With a permanent marker, mark the insertion depth at the appropriate distance from the end of the pipe.



2. DEBURR PIPE

Deburr inside and outside of pipe, removing debris that can impede flow or damage the O-Ring Seal material. Clean pipe surface of oil and debris.

5. INSERT PIPE INTO FITTINGS

Insert the pipe until it contacts the pipe stop of the fitting or valve. With the fitting or valve on the pipe, the insertion mark should be visible.

The Slip Coupling does not have a pipe stop and must be centered between the pipe ends. However, the minimum pipe insertion depth must be maintained and marked.

6. VERIFY TOOL & JAW

Using an approved Press Tool from the Tooling Table, verify the Tool Jaw is the appropriate size for the fitting. For wall and tube clearances, refer to the pressing tool manufacturer's instructions. *Failure to follow these instructions may void the warranty.*



PRESSING TOOLS

The IsoTubi-USA system uses only Type M press configuration and can be installed using any of the press tools shown in the table above and on page 8. Tools are powered with a rechargeable battery. Each tool has a unique set of easily interchangeable jaws/collars for each pipe size.



3. CHECK PRESS FITTINGS

Check the press fittings and valves to ensure the O-Ring Seal material is appropriate for the application. The color of the O-Ring Seal indicates the material type. Select the O-Ring Seal based on the intended application.

7. POSITION TOOL & SQUEEZE TRIGGER

Position the Tool Jaws on the raised surface of the fitting or valve, then squeeze the trigger until the pressing action is complete. The pressing will complete a cycle and then stop.

Do not release the trigger until the pressing action is complete. Incomplete presses may reduce the pressure retention capabilities of the joint and lead to subsequent system leakage.

8. REMOVE TOOL FROM FITTING & INSPECT

Release the trigger and remove the Jaw from the fitting. Inspect the connection to make sure the fitting or valve insertion mark is in the appropriate place.

INSERTION MARK LOCATION

Nominal Size	Insertion Mark Distance
1/2	0.875
3/4	1.000
1	1.063
1-1/4	1.16
1-1/2	1.250
2	1.813

PRESSING TOOLS

Milwaukee's M18 Force Logic Long Throw Press Tool

See Tooling PDF for Associated Jaws and Rings