



AusPress®

STAINLESS

# Install Guide



profile



15 - 168mm

**Start here**

Keep your tools for stainless separate - don't use blades & files on different metals!

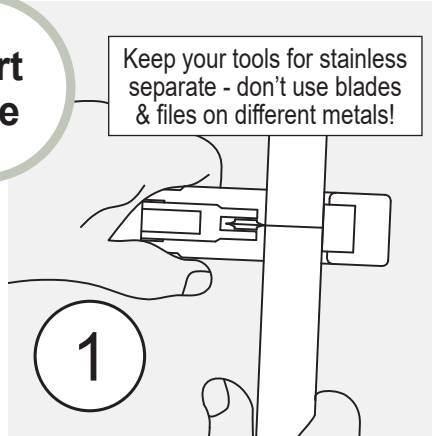
## Start to install quicker...

AusPress press-fit is installed easily and quickly using a Press Tool to form a permanent 'M' profile join. Installation only by a qualified & licensed plumber to AS3500 and AS5601.

## Check for suitability...

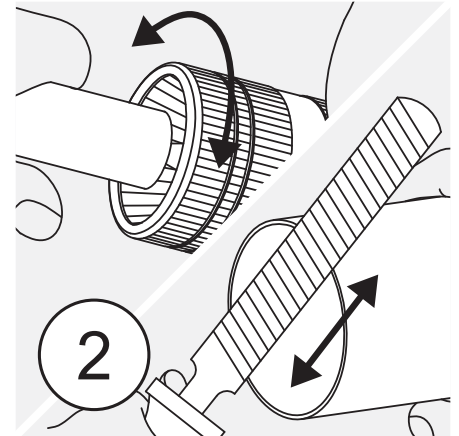
Both the grade 316 stainless material and the rubber ring seal must be checked if suitable for the possible fluids and exterior environment conditions.

**If in doubt, ask us!**



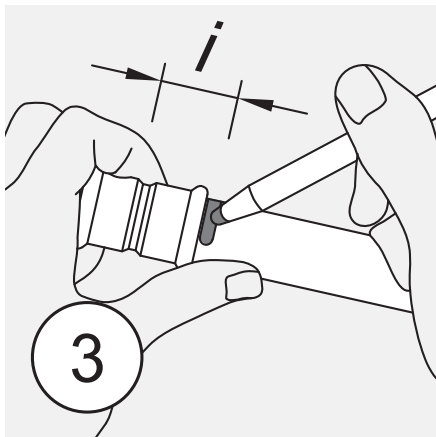
## Cut to Length

Cut the tube square using a tube cutter with an 'inox' suitable blade. For larger sizes, cut square with an 'inox' blade using a stainless rotary cutter or 5" thin blade grinder disc.



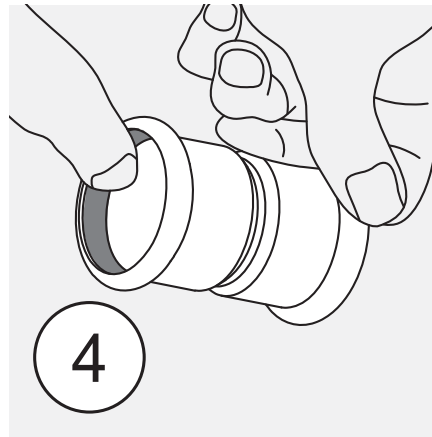
## Deburr Tube

Deburr both inside & outside edges of tube ends to avoid cutting the ring seal on insertion. For large sizes, use a half round smooth file reserved for stainless.



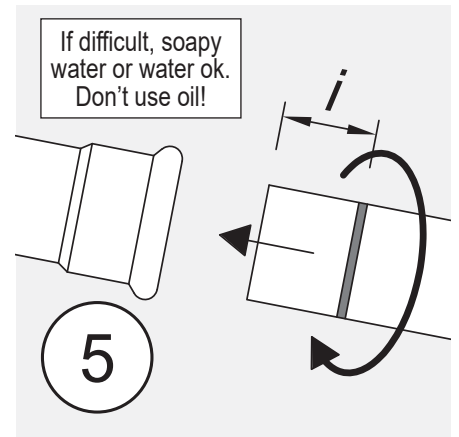
## Mark the Insertion Depth "i"

Measure and permanently mark the insertion depth (socket depth) from the end of the tube.



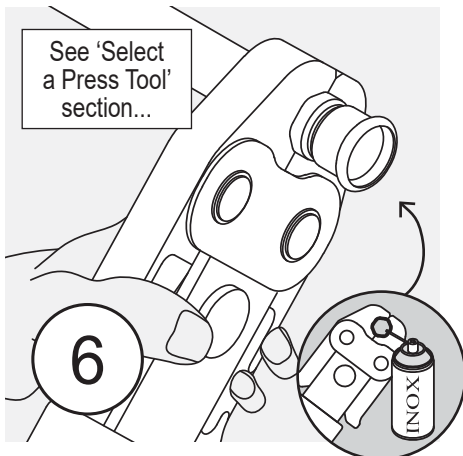
## Inspect Fitting & Ring Seals

Check that the rubber ring seal is not damaged, the correct type (colour) and both fitting & seal are free of debris.



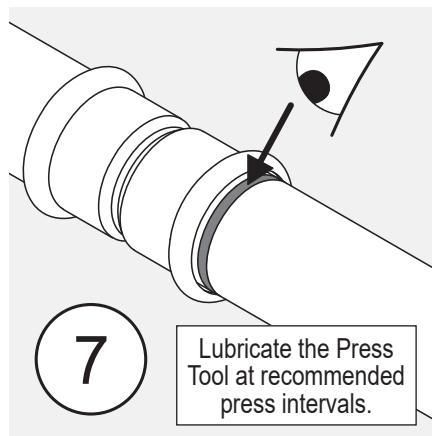
## Join the Tube & Fitting

Insert the tube into the fitting press socket, turning slightly until it reaches the previously marked insertion depth.



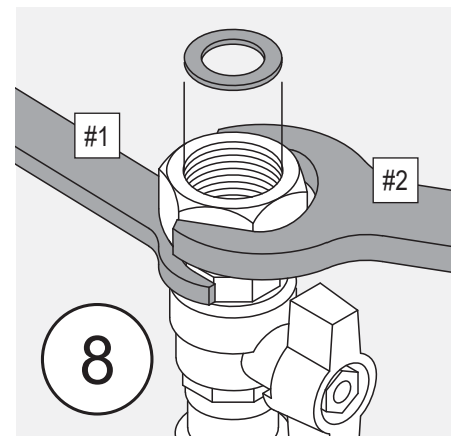
## Press Tool Selection

Use a press tool, jaw or collar to suit the fitting, dimension and application pressures. Ensure press zone is Innox lubricated each press.



## Check the Press

Visually inspect the pressed fitting & that the insertion mark is aligned with the end of the socket.



## Threaded Ends

Tighten threads with the fitting supported, don't tighten against the pressed joint alone.



AusPress®

# Install Guide



profile



15 - 168mm

**STAINLESS**

## Check the Ring Seal

Product performance specifications only - always install to AS 3500 & local requirements.



**EPDM Ring Seal**  
for potable water  
-20 to +100°C



**hNBR Ring Seal**  
for Gas  
(ie NG & LPG)

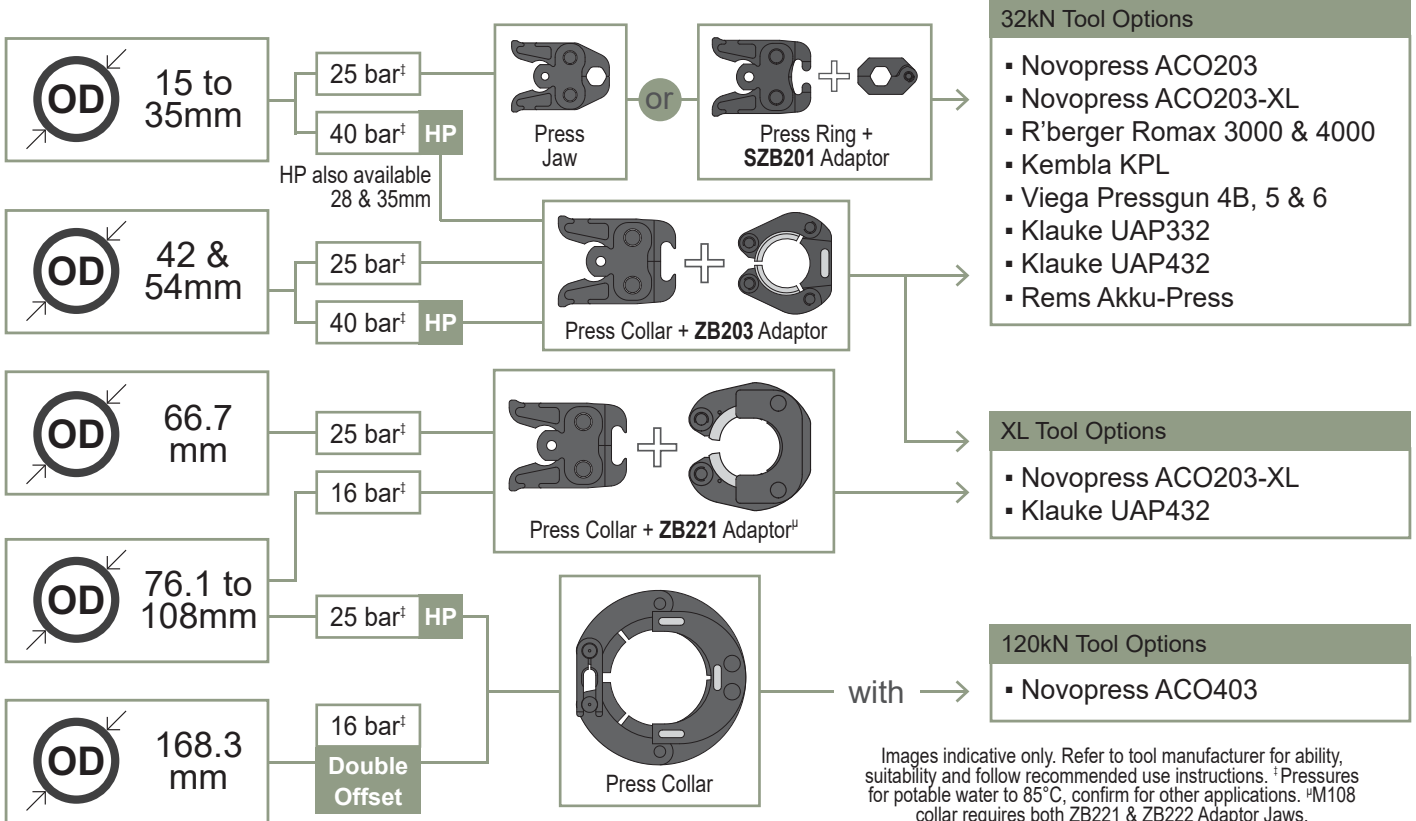


**FKM Ring Seal**  
for high temp,  
oils & chemicals

**Note:** Don't use oils or grease to lubricate the ring seal. Not suitable for medical gases, refrigeration, air conditioning, acetylene, fuels & diesel. Contact us for other chemical suitability before installing.

## Press Tool Options

AusPress Stainless fittings are compatible with M-Profile tool options below.



## Fitting Clearances

Measurements are dependant on the actual fitting dimensions and the Press Tool used to join. Confirm clearances with your particular installation as these may change.

D1	Profile	i	L	A	D2	B	C	D
15	M	20	50	10	23	85	35	55
18	M	21	52	10	26	87	35	56
22	M	21	52	10	32	95	35	56
28	M	23	56	10	38	107	35	58
35	M	26	72	20	45	121	35	61
42	M	30	80	20	54	147	35	65
54	M	35	90	20	66	174	35	70
66.7	M	49	118	20	83	212	75	124
76.1	M	53	126	20	95	223	75	128
88.9	M	58	136	20	110	249	75	135
108	M	69	158	20	133	292	75	150
168.3	M	121	302	60	195	456	70	191

tube insertion depth measurement.

Measurements are dependant on the actual fitting dimensions and the Press Tool used to join. Confirm clearances with your particular installation as these may change.

**Note:** This document is only intended as a guide and users must refer to our full product catalogue and technical information for further detailed information.

