



AusPress®

STAINLESS

# Install Guide



profile



15 - 168mm

**Start here**

## Start to install quicker...

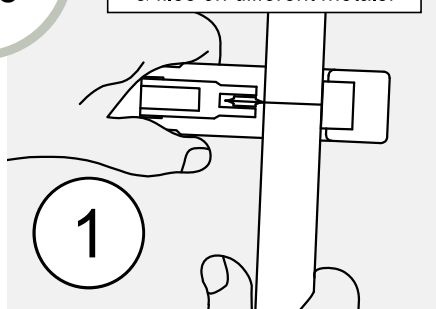
AusPress press-fit is installed easily and quickly using a Press Tool to form a permanent 'M' profile join. Installation only by a qualified & licensed plumber to AS 3500.

## 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!**

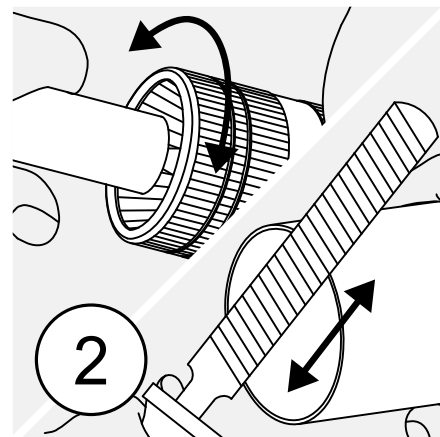
Keep your tools for stainless separate - don't use blades & files on different metals!



## Cut to Length

Cut the tube square using a tube cutter with an 'inox' suitable blade.

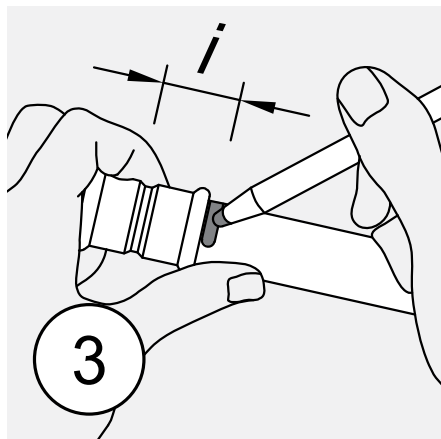
For larger sizes, cut square with an 'inox' blade using a stainless rotary cutter or 5" thin blade grinder disc.



## Deburr Tube

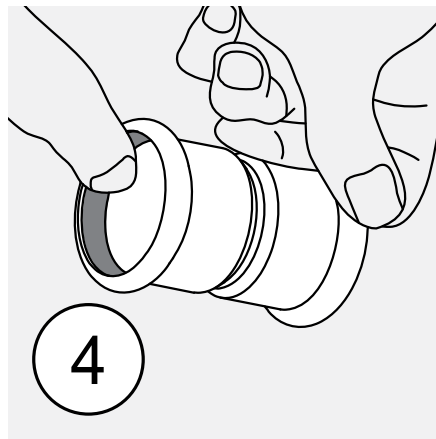
Deburr both inside & outside edges of tube ends to avoid cutting the ring seal on insertion.

For large sizes, use a half round smooth file reserved for stainless.



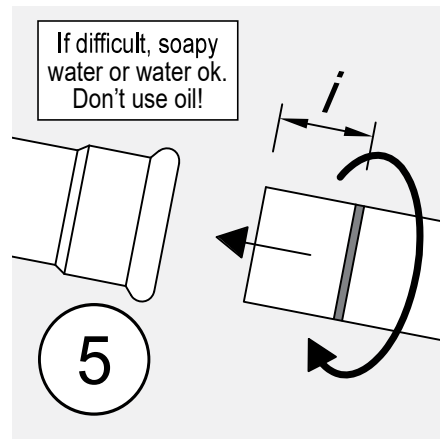
## Mark the Insertion Depth "i"

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



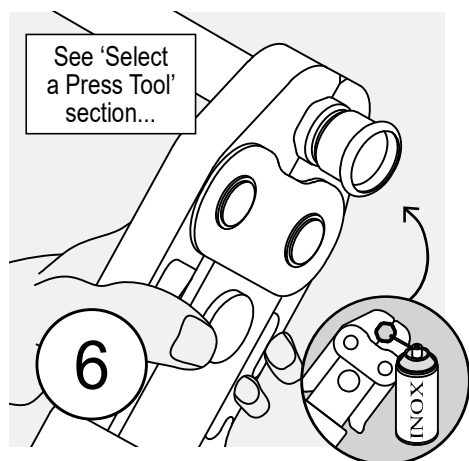
## Inspect Fitting & Ring Seals

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



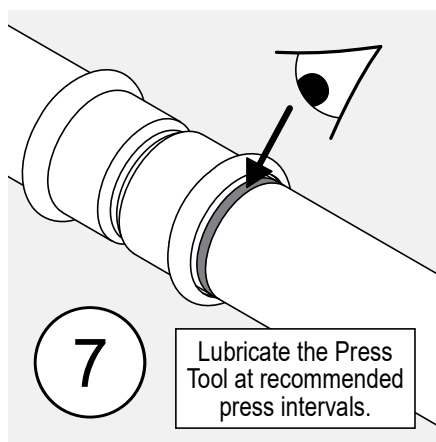
## Join the Tube & Fitting

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



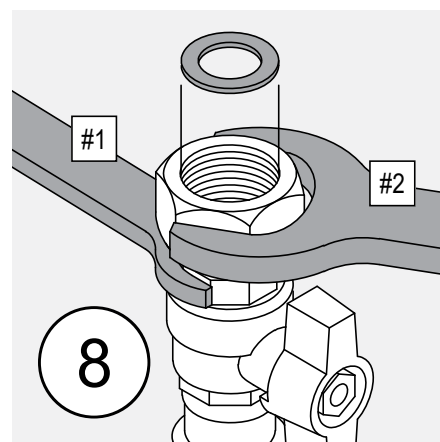
## Press Tool Selection

Use a press tool, jaw or collar to suit the fitting, dimension and application pressures. Ensure press zone is Inox 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 join alone.



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General product performance specifications only. Check for suitability before installation with AusPress.

### Check the Ring Seal



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



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



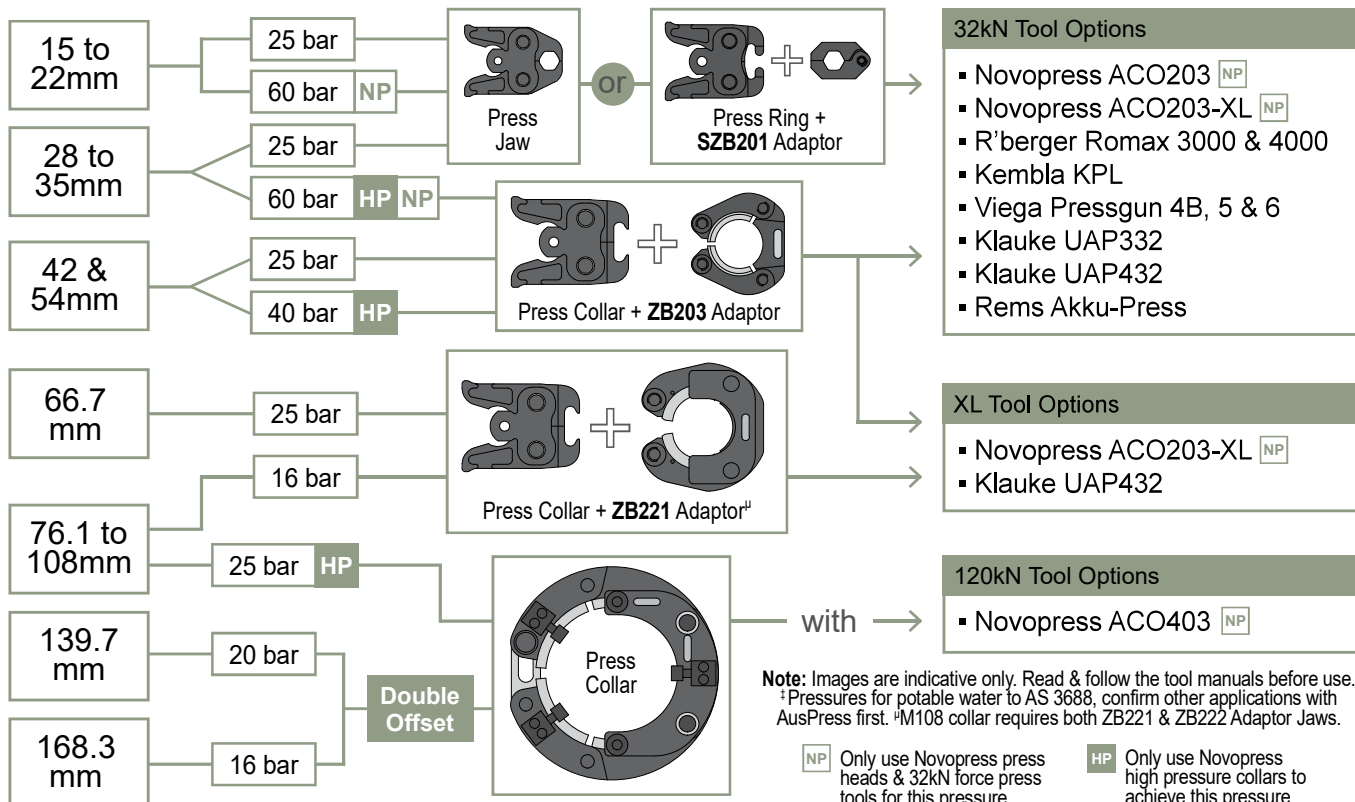
**FKM Ring Seal**  
for high temp,  
oils & chemicals

**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 M-Profile, with the tool and press heads used dictating the joint maximum operating pressure rating (shown for ambient potable water).

Project Tool Training  
available on request.



### 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	22	50	10	23	85	35	55
18	M	23	52	10	26	81	35	56
22	M	23	52	10	32	95	35	56
28	M	26	56	10	38	107	35	58
35	M	29	72	20	45	121	35	61
42	M	32	80	20	54	147	35	65
54	M	37	90	20	66	174	35	70
66.7	M	51	118	20	84	173	35	84
76.1	M	54	126	20	95	223	75	128
88.9	M	61	136	20	110	249	75	135
108	M	82	158	20	133	292	75	150
139.7	M	98	256	60	165	332	70	168
168.3	M	121	302	60	195	456	70	191

tube insertion depth measurement.

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**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.

