

INSTALLATION MANUAL

Pressing EROPEX systems

TH, U and H profiles - 16 to 40 mm

Document	EX-IM-001
Revision	04
Applies to	All EROPEX press fittings, PEX and multilayer pipe
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1. Before you start

- Check that the press tool has a valid service sticker; jaws are serviced every 20.000 cycles or 12 months.
- Confirm the jaw profile (TH, U or H) matches the profile marked on the fitting sleeve.
- Store fittings dry and dust-free; do not remove the protective caps until assembly.
- Inspect the O-ring seat - never install a fitting with a damaged, dry or contaminated O-ring.

2. Pipe preparation

- Cut the pipe square with a pipe cutter. Never use a saw or angle grinder.
- Ream and calibrate the pipe end with the EROPEX combination tool.
- Remove burrs inside and outside; burrs are the most common cause of O-ring damage.
- Check the pipe end for ovality; correct any deformation before insertion.

3. Assembly

- Push the pipe into the fitting until it is visible through the full depth of the inspection window.
- Mark the insertion depth with a marker so it can be verified after pressing.
- Position the jaw square to the fitting axis, fully seated on the press sleeve.
- Complete the press cycle without interruption; the tool releases automatically at full force.
- Minimum distance between two press joints: 5 mm for 16 - 26 mm, 10 mm for 32 - 40 mm.

4. Testing and commissioning

- Leak test unpressed joints at 6 bar for 15 minutes - unpressed connections leak visibly.
- Pressure test the completed installation at 1.5 x working pressure for 30 minutes.
- Flush drinking water installations to EN 806-4 before handover.
- Record the test in the commissioning report and file the batch codes for traceability.

5. Do not

- Do not press a joint twice - a pressed fitting is permanent and cannot be reworked.
- Do not use oil, grease or jointing compound on the O-ring.
- Do not expose fittings to open flame or temperatures above 110 C.
- Do not mix press profiles or use jaws from an unapproved system.

Warranty

EROPEX grants a 10-year system warranty on material and manufacturing defects when EROPEX

ittings are installed with EROPEX or approved pipe and tooling, in accordance with this manual and applicable national installation standards. Warranty claims are handled through info@eropex.eu with batch code and installation documentation.