

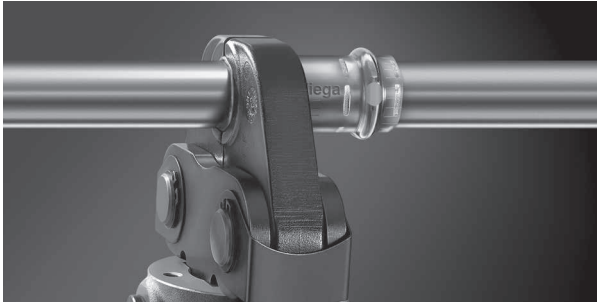
## Product Instructions

# Viega ProPress® Stainless ½" to 4"

## EN Product Instructions

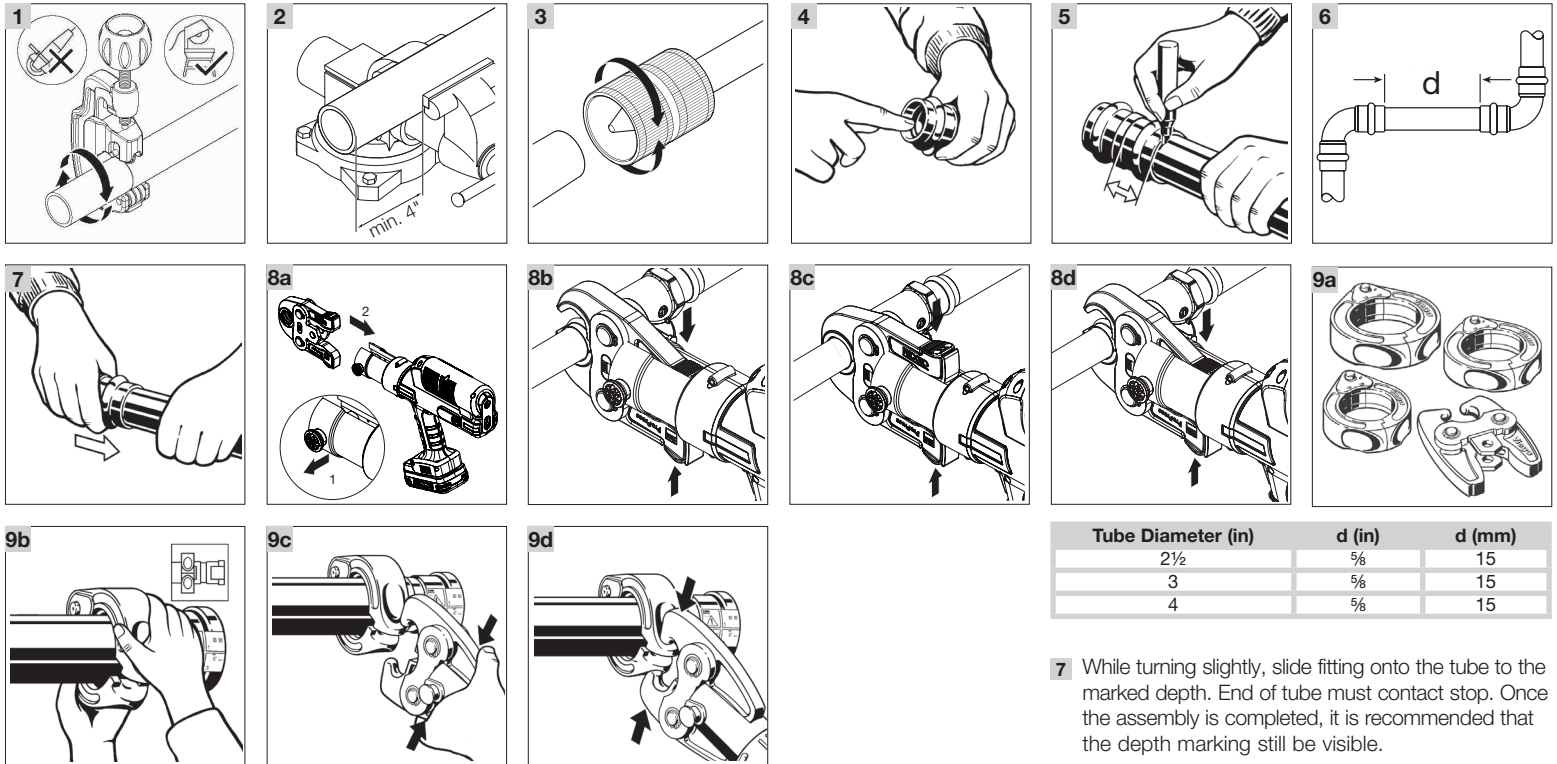
### Viega ProPress Stainless ½" to 4"

This document is subject to updates. For the most current Viega technical literature please visit [www.viega.us](http://www.viega.us).



**Viega LLC**  
585 Interlocken Blvd.  
Broomfield, CO 80021  
  
Phone (800) 976-9819  
[www.viega.us](http://www.viega.us)

PI-PP 531439 1123 ProPress Stainless ½ to 4



Tube Diameter (in)	d (in)	d (mm)
2½	5/8	15
3	5/8	15
4	5/8	15

- 7** While turning slightly, slide fitting onto the tube to the marked depth. End of tube must contact stop. Once the assembly is completed, it is recommended that the depth marking still be visible.

**Warning!**  
Keep extremities and foreign objects away from press tool during pressing operation to prevent injury or incomplete press.

## EN

### Viega ProPress Stainless ½" to 4" Fittings For use only with Viega stainless steel tubing.

**!** Viega products are designed to be installed by licensed and trained plumbing and mechanical professionals who are familiar with Viega products and their installation. **Installation by non-professionals may void Viega LLC's warranty.**

**DANGER!**  
**Read and understand all instructions for installing Viega ProPress fittings.** Failure to follow all instructions may result in extensive property damage, serious injury, or death.

- Cut copper tube square using displacement-type cutter or fine-toothed saw.
- Cut tube a minimum of 4" away from the contact area of the vise to prevent possible damage to the tubing in the press area.
- Remove burr from inside and outside of the tube and prep to proper insertion depth using a preparation tool or fine-grit sandpaper.
- Check the sealing element for correct fit. Do not use oils or lubricants.

**i** For applications requiring a different sealing element, remove the factory-installed sealing element and replace with the applicable sealing element. See [Changing Sealing Elements Product Instructions](#).

- 5** Mark proper insertion depth as indicated by the Viega ProPress Insertion Depth Chart. Improper insertion depth may result in improper seal. It is recommended that the depth marking be visible on the completed assembly.

Tube Size	½"	¾"	1"	1¼"	1½"	2"	2½"	3"	4"
Insertion Depth	¾"	7/8"	7/8"	1"	1 1/16"	1 9/16"	1 11/16"	1 15/16"	2 3/8"

- 6** Refer to the following chart for minimum distance between fittings. To ensure a correct press, a minimum distance between press fittings must be maintained. Failure to provide this distance may result in an improper seal.

Tube Diameter (in)	d (in)	d (mm)
½	0	0
¾	0	0
1	0	0
1¼	7/16	10
1½	5/8	15
2	¾	20

### Pressing ½" to 2" Fittings

- 8a** Insert appropriate Viega ProPress jaw (2) into the press tool and push in, holding pin (1) until it locks in place.  
**8b** Open the jaw and place at right angle on the fitting. Visually check insertion depth using mark on tubing.  
**8c** Hold trigger on press tool until press jaws have fully engaged the fitting. Jaws will automatically release after a full press is made.  
**8d** After pressing, open the jaw and remove the press tool.

### Pressing 2½" to 4" Fittings

- 9a** ProPress 2½" to 4" connections must be performed with rings that are compatible. Do not mix actuators and rings from different manufacturers. Do not use rings intended for 2½" to 4" bronze fittings. Use of incompatible rings will result in an improper connection.  
**9b** Open XL-C ring and place at right angles on the fitting. XL-C ring must be engaged on the fitting bead. Check insertion depth.  
**9c** With V2 actuator inserted into the tool, open the V2 actuator and connect V2 actuator to the XL-C ring.

- 9d** Hold the trigger until the V2 actuator has fully engaged the XL-C ring. Keep extremities and foreign objects away from XL-C ring and V2 actuator during pressing operation to prevent injury or incomplete press. Upon completion of the press, release the V2 actuator from XL-C ring. Remove the XL-C ring from the fitting.

#### **Pressure testing with Smart Connect® Technology**

Unpressed connections are located by pressurizing the system with air or water. When testing with water the proper pressure range is 15 psi to 85 psi. When testing with compressed air the proper pressure range is ½ psi to 45 psi maximum. If testing with compressed air, use an approved leak-detect solution. Following a successful pressure test, the system may be pressure tested up to 200 psi with air or up to 600 psi with water.



Testing for unpressed connections using Smart Connect is not a replacement for pressure testing requirements of local codes and standards.



#### **CAUTION!**

It is the responsibility of designers of piping systems to verify the suitability of type 316 stainless steel pipe for use with the intended fluid media. The fluid's chemical composition, pH level, operation temperature, chloride level, oxygen level, and flow rate and their effect on AISI type 316 stainless steel must be evaluated by the material specifier to confirm system life will be adequate for the intended service. Failure to do so may cause serious personal injury or property damage. Contact Viega Technical Services for questions and approvals.