Viega ProPress® 2½” to 4” Fittings*
*formerly ProPress XL-C

1. Cut copper tubing at right angles using displacement-type cutter or fine-toothed steel saw.
2. Keep end of tubing a minimum of 4” away from the contact area of the vise to prevent possible damage to the tubing in the press area.
3. Remove burr from inside and outside of tubing to prevent cutting sealing element.
4. Check seal and grip ring for correct fit. Ensure sealing element is free of cuts and damage. Do not use oils or lubricants.

5. Illustration demonstrates proper fit of grip ring, separation ring and sealing element.
6. Mark proper insertion depth as indicated by the ProPress 2½” to 4” Insertion Depth Chart. Improper insertion depth may result in an improper seal.

ProPress 2½” to 4” Insertion Depth Chart

<table>
<thead>
<tr>
<th>Tube Size</th>
<th>Insertion Depth</th>
</tr>
</thead>
<tbody>
<tr>
<td>2½”</td>
<td>1 1/9&quot;</td>
</tr>
<tr>
<td>3”</td>
<td>1 5/9&quot;</td>
</tr>
<tr>
<td>4”</td>
<td>2 5/9&quot;</td>
</tr>
</tbody>
</table>

7. While turning slightly, slide press fitting onto tubing to the marked depth. End of tubing must contact stop.
8. ProPress 2½” to 4” fitting connections must be performed with rings that are compatible with fittings. Do not mix actuators and rings from different manufacturers. Use of ProPress XL rings and/or actuator (for bronze fittings) will result in an improper connection. See Operator’s Manual for proper tool instructions.

CAUTION!
Use only rings that are compatible with ProPress 2½” to 4” fittings.
- Use of incompatible rings will result in an improper connection.
- Do not mix actuators and rings from different manufacturers.
- Do not use rings intended for 2½” to 4” Bronze fittings.

9. 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.
10. With V2 actuator inserted into the tool, open the V2 actuator as shown and connect V2 actuator to the XL-C ring.
11. Place V2 actuator onto XL-C ring and start pressing process. Hold the trigger until the actuator has 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.
12. Release V2 actuator from XL-C ring and then remove the XL-C ring from the fitting on completion of press. Remove tag from fitting, indicating press has been performed.

Pressure Testing with Smart Connect®
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.