En Product Instructions
Viega ProPress® Stainless XL

This document is subject to updates. For the most current Viega technical literature please visit www.viega.us.

EN

![Image](image1)

**Product Instructions**

**Viega ProPress Stainless XL Fittings**

For use only with Viega stainless steel tubing.

1. Cut stainless steel tubing only with an approved stainless steel pipe cutting tool. Cut the tube square using a displacement-type cutter or fine toothed saw. **DANGER!** Read and understand all instructions for installing Viega ProPress Stainless XL fittings. Failure to follow all instructions may result in extensive property damage, serious injury or death.

2. Deburr inside and outside of the tube to the proper insertion depths to prevent cutting sealing element. Use a wire brush, Scotchbrite pad, sand cloth, or sandpaper to remove loose dirt and rust particles from the pressing area.

3. Check the sealing element, separator ring, and grip ring for correct fit. Do not use oils or lubricants. Use only Viega ProPress shiny black EPDM for 316 or dull black FKM for 304 sealing elements.

4. Mark the proper insertion depth as indicated by the Viega ProPress Stainless XL Insertion Depth Chart. Improper insertion depth may result in an improper seal.

5. While turning slightly, slide press fitting onto tubing to the marked depth. End of tubing must contact stop.

6. Press Viega ProPress Stainless XL fittings with Viega ProPress XL-C rings and V2 ACTUATOR. Use only rings that are compatible with ProPress XL-C fittings. Do not use rings intended for XL Bronze fittings.

7. Open XL-C ring and place at right angles on the fitting. Ensure that the XL-C ring is engaged on the fitting bead.

8. With V2 Actuator inserted into the press tool, open the V2 Actuator to the XL-C Ring. Look at insertion depth mark on the tube to make sure that the tube is properly inserted into the fitting.

9. Hold the trigger until the Actuator has engaged the XL-C ring.

10. Upon completion of the press, release the V2 Actuator from XL-C ring. Remove the XL-C ring from fitting. Remove product instruction label from fitting to indicate that press has been completed.

11. 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.

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.

Use only rings that are compatible with ProPress XL-C fittings. Do not use rings intended for XL Bronze fittings.

Test 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 304 and 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 304 or 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.