

## Engineering Specifications

# Viega ProPress® Stainless System



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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.**

## Part 1: General

### 1.1 Summary

Stainless steel tube and fitting system using cold press connection technology. The system is assembled when the tube is fully inserted into the fitting, then pressed on both sides of the fitting seal, creating a mechanical joint.

### 1.2 Definitions

ASME: American Society of Mechanical Engineers  
 ASTM: American Society for Testing and Materials  
 AWWA: American Water Works Association  
 EPDM: Ethylene Propylene Diene Monomer  
 FKM: Fluoroelastomer  
 IAPMO: International Association of Plumbing & Mechanical Officials  
 ICC: International Code Council  
 MSS: Manufacturers Standardization Society  
 NSF: National Sanitation Foundation

### 1.3 References

ASME A13.1: Scheme for the Identification of Piping Systems  
 ASME B1.20 Pipe Threads, General Purpose (Inch)  
 ASME B31.1 Power Piping  
 ASME B31.3 Process Piping  
 ASME B31.9 Building Services Piping  
 ASTM 1029: Standard Practice for Press-Connect Joints with Seamless Copper and Copper Alloy Tube and Press Fittings  
 ASTM A312 Standard Specification for Seamless, Welded, and Heavily Cold Worked Austenitic Stainless Steel Pipes  
 ASTM A554 Standard Specification For Welded Stainless Steel Mechanical Tubing  
 ASTM A778 Unannealed Austenitic Stainless Steel Tubular  
 AWWA C651 Standard for Disinfecting Water Mains  
 IAPMO: Uniform Mechanical Code (UMC)  
 IAPMO: Uniform Plumbing Code (UPC)  
 ICC: International Plumbing Code (IPC)

ICC: International Mechanical Code (IMC)  
MSS-SP-58 Pipe Hangers and Supports - Materials, Design and Manufacture  
NSF®-61-372 Drinking Water System Components-Health Effects

#### 1.4 Quality Assurance

- A. Installer shall be a qualified installer, licensed within the jurisdiction, and familiar with the installation of stainless steel tube.
- B. The installation of stainless steel tube for hot and cold water distribution systems shall conform to the requirements of the ICC International Plumbing Code or IAPMO Uniform Plumbing Code. The installation of stainless steel tube in hydronic systems shall conform to the requirements of the ICC International Mechanical Code or the IAPMO Uniform Mechanical Code.

#### 1.5 Delivery, Storage, and Handling

- A. Stainless steel tube shall be shipped to the job site on truck or in such a manner to protect the tube. The tube and fittings shall not be roughly handled during shipment. The tube and fittings shall be unloaded with reasonable care.
- B. Protect the stored tube from moisture and dirt. Elevate above grade. When stored inside, do not exceed the structural capacity of the floor.
- C. Protect fittings and piping from moisture and dirt.

#### 1.6 Project Conditions

Verify length of tube required by field measurements.

#### 1.7 Warranty

- A. The tube and fittings manufacturer shall warrant that the tube and fittings are free from defects and conform to the designated standard. The warranty shall only be applicable to tube and fittings installed in accordance with the manufacturer's installation instructions.
- B. The manufacturer of the tube and fittings shall not be responsible for the improper use, handling, or installation of the product.

## Part 2: Products

#### 2.1 Manufactures

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

#### 2.2 Material

- A. Tube standard: stainless steel tube shall conform to ASTM A312 or ASTM A554.
- B. Fitting standard: stainless steel fittings shall conform to the material requirements of ASTM A312 or ASTM A554.
- C. Press fitting: stainless steel press fittings shall conform to the material and sizing requirements of ASME A312 or ASTM A554. O-rings for stainless steel press fittings shall be EPDM or FKM, depending on the application.
- D. Threaded fittings: tube threads shall conform to ASME B1.20.1.
- E. Hanger standard: hangers and supports shall conform to MSS-SP-58.

#### 2.3 Source Quality Control

All tube, fittings, and joining materials in contact with drinking water shall be listed by a third party agency to NSF 61.

## Part 3: Execution

### 3.1 Examination

The installing contractor shall examine the stainless steel tube and fittings for defects and cracks. There shall be no defects of the tube or fittings. Any damaged tube or fittings shall be rejected.

### 3.2 Preparation

- A. Stainless steel tube shall be cut with a wheeled tube cutter or approved stainless steel tube cutting tool. The tube shall be cut square to permit proper joining with the fittings.
- B. Remove scale, slag, dirt, and debris from inside and outside of tube and fittings before assembly. The tube end shall be wiped clean and dry. The burrs on the tube shall be reamed with a deburring or reaming tool.

### 3.3 Installation General Locations

Plans indicate general location and arrangement of piping systems. Identified locations and arrangements are used to size tube and calculate friction loss, expansion, pump sizing, and other design considerations. Install piping as indicated, except where deviations to layout are approved on coordination drawings.

### 3.4 Installation

- A. Pressure rating: install components having a pressure rating equal to or greater than the system operating pressure.
- B. Install piping free of sags, bends, and kinks.
- C. Change in direction: install fittings for changes in direction and branch connections.
- D. Press connections: stainless steel press fittings shall be made in accordance with the manufacturer's installation instructions. The tube shall be fully inserted into the fitting and the tube marked at the shoulder of the fitting. The fitting alignment shall be checked against the mark on the tube to assure the tube is fully engaged (inserted) in the fitting. The joints shall be pressed using the tool approved by the manufacturer.
- E. Threaded joints: threaded joints shall have pipe joint compound or teflon tape applied to the male threads only. Tighten joint with a wrench and backup wrench as required.
- F. Tube protection: provide protection against abrasion where stainless steel tube is in contact with other building members by wrapping with an approved tape, pipe insulation, or otherwise suitable method of isolation.
- G. Penetration protection: provide allowance for thermal expansion and contraction of stainless steel tube passing through a wall, floor, ceiling, or partition by wrapping with an approved tape or pipe insulation or by installing through an appropriately sized sleeve. Penetrations for fire resistant rated assemblies shall maintain the rating of the assembly.
- H. Backfill material: backfill material shall not include any ashes, cinders, refuse, stones, boulders, or other materials which can damage or break the tube or promote corrosive action in any trench or excavation in which tube is installed.
- I. Horizontal support: install hangers for horizontal piping in accordance with local code or the following maximum spacing and minimum rod sizes.

Nominal Tube Size (in)	Stainless Steel Tube Max. Span (ft)	Min. Rod Diameter (in)
Up to ¾	10	¾
1	10	¾
1¼	10	¾
1½	10	¾
2	10	¾
2½	11	1½
3	12	1½
4	14	5/8

All systems must be installed per local codes and/or standards and requirements. Consult the Viega technical support department before installing the system in other applications or applications with temperatures and/or pressures outside the stated ratings. Refer to Viega's Application Guide for more information.

- J. Vertical support: vertical stainless steel tube shall be supported at each floor or at 10 foot intervals.
- K. Galvanic corrosion: hangers and supports shall be either stainless steel or vinyl coated to prevent galvanic corrosion between the tube and the supporting member.
- L. Restraint: in seismic areas, stainless steel tube shall be installed to withstand all seismic forces.
- M. Identification: stainless steel tube systems shall be identified in accordance with the requirements of ASME A13.1.

### 3.5 Field Quality Control

- A. Viega ProPress Stainless includes Smart Connect® technology, a quick and easy way of identifying unpressed connections during the pressure testing process. This indentation is removed during the pressing process, creating a leak-free, permanent connection. Smart Connect technology provides identification of connections which have not been pressed prior to putting the system in to operation. Smart Connect technology may be pressure tested with air or water.
  - When testing with air, the pressure range is ½ psi to 45 psi maximum.
  - When testing with water, the pressure range is 15 psi to 85 psi maximum.
- B. The Smart Connect technology pressure test is not a substitute for local code required pressure testing of the piping system. Carry out the final piping system pressure test in accordance with local codes.

### 3.6 Cleaning (Potable Water Systems)

- A. Disinfection: the stainless steel hot and cold water distribution system shall be disinfected prior to being placed in service. The system shall be disinfected in accordance with AWWA C651 or the following requirements:
  1. The piping system shall be flushed with potable water until discolored water does not appear at any of the outlets.
  2. The system shall be filled with a water chlorine solution containing between 50 and 200 parts per million of chlorine. The system shall be valved in the closed position and allowed to stand for 24 hours.
  3. Following the standing time, the system shall be flushed with water until the chlorine is purged from the system.