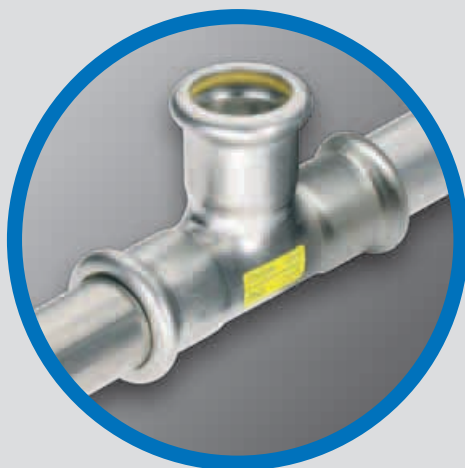
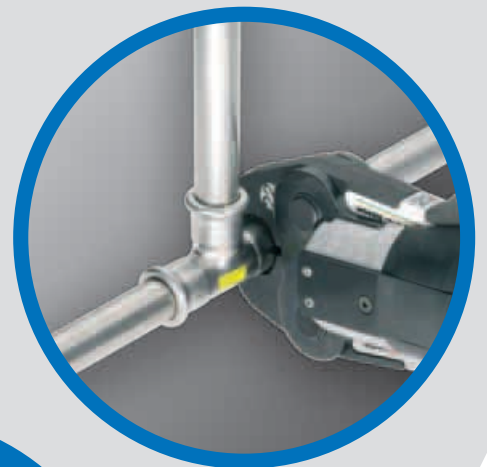


# **XP** *stainless gas* **Press**

Stainless Steel Press-fit Fittings  
for gas installation pipework





- **For gas installation pipework where high levels of hydrogen sulphide prohibits the use of copper**
- **Available in sizes from 15mm to 54mm**
- **Manufactured from high quality 316 stainless steel**
- **30 year System guarantee**
- **Heat-free press-fit jointing system provides a clean bore installation and installed cost savings**
- **DVGW VP614 approved, tested by the GWI; and verified by Advantica**



### **Sales office contacts**

#### **Head office sales**

Telephone: (0113) 270 6945 Fax: (0113) 270 5644

#### **Northern Ireland**

Telephone: (028) 9070 6990 Fax: (028) 9070 6999

### **Introduction**

XPress Stainless Gas press-fit fittings are designed for the fast, efficient, heat-free jointing of XPress Stainless steel System tubes and other stainless steel tubes to DVGW GW541.

XPress Stainless Gas fittings are suitable for use on above ground 2nd and 3rd family gas installation pipework, including instances where high levels of hydrogen sulphide make copper unsuitable. 2nd family gas is natural gas, and 3rd family gas is LPG, compressed propane and butane.

XPress Stainless Gas fittings are manufactured from 316 (BS 316S31/DIN 1.4401) or 316Ti (BS 320S31/DIN 1.4571) stainless steel and have yellow High Quality Acrylonitrile Butadiene Rubber (H-NBR) 'O' rings.

### **Identification**

XPress Stainless Gas fittings can be identified by a yellow PN5 GT/5 label applied to the body. Fittings also have yellow 'O' rings. Fittings not conforming to these means of identification should not be used for gas installations.

### **Working temperatures and pressures**

XPress Stainless Gas fittings are approved for use at temperatures from -20°C to 70°C, with a maximum working pressure for above ground pipework of 5 bar inside and outside buildings.

As part of the DVGW approvals process, XPress Stainless Gas fittings have passed the HTC test (Higher Thermal Capacity) at 650°C for 30 minutes at PN5.

### **Guarantees**

Where XPress Stainless Gas fittings are installed with tube from other manufacturers that meets DVGW GW541, you'll receive a no-quibble 25-year guarantee against all manufacturing defects.

Where stainless steel pipeline systems are constructed exclusively from XPress Stainless Gas fittings and stainless steel System tube from our XPress range, the resulting installation will be deemed an XPress Stainless Gas System and as such qualify for a 30-year guarantee against all manufacturing defects.

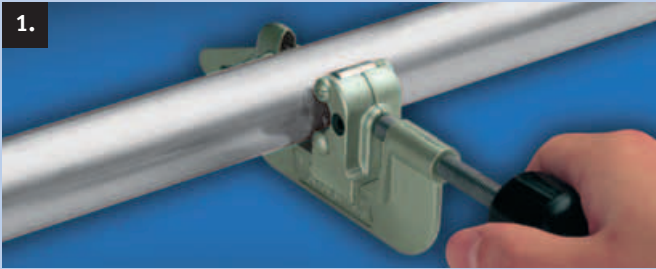
All guarantees are subject to the use of Yorkshire Fittings approved Novopress tools, jaws and slings and the application of good installation practice.

# Installation instructions

Select the correct size of tube and fitting for the job. Ensure that both are clean, in good condition and free from damage and imperfections.

## Preliminaries

1. Cut the tube using a rotary tube cutter, taking care to ensure the tube is cut square.



2. Deburr both the internal and external tube ends, then wipe clean of all swarf and debris to avoid damage to the 'O' ring upon tube insertion.



3. Using a S110 depth gauge or ruler, mark the insertion depth of the fitting onto the tube (see table 1).



4. Ensure the yellow 'O' ring is seated correctly within the fitting socket.

**Note:** Yorkshire Fittings only approves tools by Novopress for the installation of XPress Stainless Gas fittings.

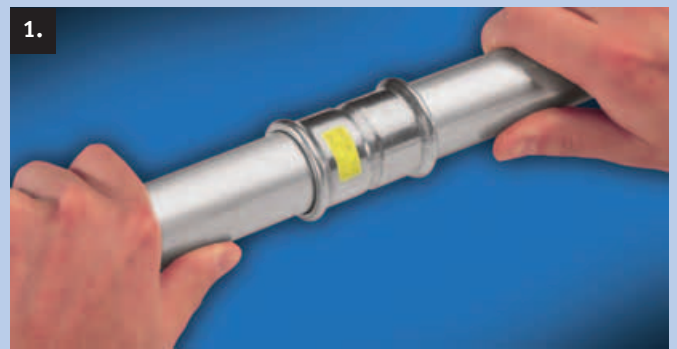


Table 1 – XPress Stainless Gas fitting socket depths

Size	Socket depth
15mm	20mm
22mm	21mm
28mm	23mm
35mm	26mm
42mm	30mm
54mm	35mm

## Jointing 15mm to 35mm sizes

1. Assemble the joint using the mark on the tube as a guide to ensure the tube is inserted until it meets the tube stop.



2. Insert the correct sized jaws into the press tool and place them over the bead at the mouth of the fitting, maintaining a 90° angle between the tube and jaws.



3. Press the trigger or button to commence the tool's compression cycle, which is complete when the jaws fully enclose the mouth of the fittings. Release the jaws.





## Jointing 42mm to 54mm sizes

Sling jaws must be used when assembling fitting of sizes 42mm and above.

1. Assemble the joint using the mark on the tube as a guide to ensure the tube is inserted until it meets the tube stop.



2. Open the appropriate sling jaw by depressing the spring loaded pin, and position it over the fitting.



3. Ensure the groove of the sling corresponds to the bead on the fitting and that the support plate on the sling fits over the tube side of the joint.



4. Turn the catch mechanism toward the locking pin, depress the pin and push the catch into the pin until the mechanism engages. Revolve the sling around the fitting to the desired pressing position.



5. Attach the appropriate adaptor to the press tool and close the breach bolt. Attach the adaptor by depressing the jaw levers and inserting the claws as far as possible into the grooves of the sling.



6. Commence the pressing operation by depressing the button on the press-fit tool for at least two seconds. The weight of the tool must be supported during this operation. No side-to-side or up-and-down load should be applied, and an angle of 90° between the tube and press-fit tool should be maintained throughout the process.



7. When the pressing operation has been completed, the adaptor should be disengaged by depressing the jaw levers, and the slings removed from the fitting.



8. Check the socket depth marks to determine if creep has occurred during the jointing process. If the joint has been subject to creep, the fitting must be removed and replaced.



## Health and Safety

1. We recommend that eye protection be worn when operating all press-fit tools.
2. Do not activate a press-fit tool without a fitting in the jaw.

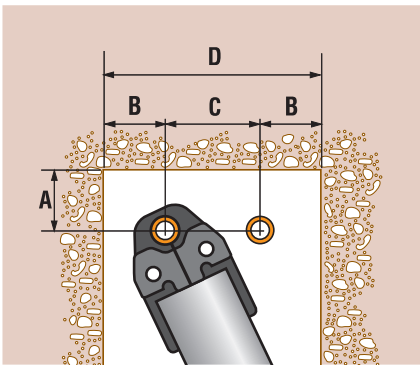
### Lubrication



The use of S135 Dri-Slide lubricant is essential when jointing large sized fittings. The pressing profile groove (1) of the sling jaws should be cleaned and lubricated after every 50 joints for 42mm and 54mm sizes. Dri-slide should also be applied between the main sling arms (2) and the moving segments; and along the pivot pins (3) between the arms.

Note: Dri-Slide lubricant should not come into contact with the 'O' ring, so it is important to wipe clean any excess lubricant.

### Spacing of fittings



When designing an XPress System, take care to ensure all joints can be made effectively with sufficient room for the tool to operate (see table below). In addition, minimum gaps should be left between fittings. For sizes 15mm to 35mm this gap should be 10mm, for sizes 42mm

and 54mm this gap should be 20mm.

On installations larger than 28mm where fittings are closer than 100mm, all joints should be assembled before pressing commences.

Pipework clearance				
Size	A	B	C	D
15mm	25mm	28mm	75mm	131mm
22mm	31mm	35mm	80mm	150mm
28mm	31mm	35mm	80mm	150mm
35mm	31mm	44mm	80mm	170mm
42mm	75mm	75mm	115mm	265mm
54mm	85mm	85mm	120mm	290mm

## System tube

### Stainless steel 316 System tube

Stainless steel 316 System tube is available in 6m straight lengths in a range of sizes from 15mm to 108mm. In sizes from 15mm to 54mm the tube is manufactured from BS 316 S31/DIN 1.4401 stainless steel strip conforming to BS10088 Part 2 and thanks to its thin-walled geometry, is stiff, lightweight and truly easy to handle.

Note: XPress Stainless Gas Fittings are not suitable for use with Stainless steel tube to BS 4127: 1994.

Stainless steel tube specification		
Outside diameter	Wall thickness	
	316 System tube	DVGW GW541
15mm	0.6mm	1.0mm
22mm	0.6mm	1.2mm
28mm	0.8mm	1.2mm
35mm	1.0mm	1.5mm
42mm	1.0mm	1.5mm
54mm	1.0mm	1.5mm

### The perfect commercial partnership



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### For further information, please contact your appropriate sales office

**Head office sales**  
Tel: 0113 270 6945  
0113 272 5380  
Fax: 0113 270 5644  
0113 272 5385

**Northern Ireland**  
Tel: 028 9070 6990  
Fax: 028 9070 6999

**Export**  
Tel: +44 (0) 113 270 1104  
Fax: +44 (0) 113 271 6250

info@yorkshirefittings.co.uk  
Yorkshire Fittings Limited,  
Haigh Park Road, Stourton,  
Leeds, West Yorkshire,  
LS10 1RT, England

Registered Company  
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