



1. Cut the tube to length

- Use a rotary tube cutter.
- Ensure that the tube is cut square.
- Check the tube has retained its shape and is damage free.



2. Deburr and remove all external sharp edges

- Deburr the tube both internally and externally.
- Where possible angle the tube downwards to prevent filings entering the tube.
- Use a pencil type deburrer on internal tube edges.
- Make sure the internal and external surfaces of the tube ends are smooth and free from burrs or sharp edges.

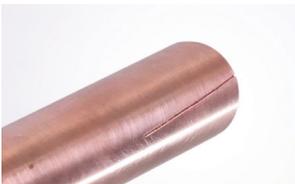


3. Use a pencil type deburrer on internal edges



4. Clean the tube end

- Thoroughly clean the tube end using ROTHENBERGER Rovlies or similar cleaning pad in a rotating action.
- Tube ends must be free from scratches, oxidation, dirt and debris.



5. Check for defects

- If deep scratches are still visible, cut the tube back to a clean section.



6. Ensure the O-ring is seated

- Check the fitting is the correct size for the tube.
- Check the O-rings are present and correctly seated.
- A small additional amount of Conex Bänninger press fitting lubricant may be used to aid tube insertion.



7a. Mark insertion depth on tube using depth gauge

- Insert tube into correct socket in depth gauge.
- Check window to see the tube is fully inserted.
- Mark the insertion depth on the tube.



7b. Alternatively insert tube to tube stop and mark

- The tube must be fully inserted into the fitting until it reaches the tube stop.
- To reduce the risk of dislodging the O-ring rotate the tube (if possible) while slipping it into the fitting.
- Mark the insertion depth on the tube.



7b. Check the depth mark

- Remove the tube and align with fitting socket, check that the depth mark is correctly positioned.
- The insertion depth mark is used as a reference prior to pressing the joint.



8. Insert the tube fully into the fitting. Ensure tube is fully inserted prior to pressing

- Insert the tube fully into the fitting up to the tube stop.
- To reduce the risk of dislodging the O-ring rotate the tube (if possible) while slipping it into the fitting.
- Prior to pressing ensure the tube has not moved out from the fitting socket.
- Use the insertion depth mark as a guide.



9. Align jaws squarely on the fitting

- Ensure pipework is correctly aligned prior to pressing.
- Ensure the correct size jaw is inserted into the tool.
- The jaws must be placed squarely on the fitting locating the groove on the bead.
- The bead on the fitting should fit centrally in the groove of the jaw.



10. Complete the joint with the approved tool. Press once only

- Depress and hold the button to complete the pressing cycle.
- Pressing is complete when the jaws are fully closed and the piston retracts.
- Complete the press cycle once only – do not repress.
- Release the jaws from the pressing.



11. Mark the completed joint

- Mark the completed joint after pressing.
- This enable joints to be inspected easily before testing and insulating the pipework.



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**Note:** Only ROTHENBERGER tools and jaws are approved for use with >B< MaxiPro fittings.