TRUPRESS INSTALLATION PROCEDURES 15MM-108MM

Pre-Installation Checks

1. Verify that the press tool (machine + jaws/chain) is approved by the manufacturer for TruPress fittings. Using non-approved tools can void the warranty/performance.
2. Check that the working pressure/temperature of the system does not exceed the ratings for the specific fitting size/media.
3. Inspect components for damage: pipes should be free of dents, scratches, rust; fittings should have intact sealing rings.

Preparation of Pipe & Fitting

1. Cut the stainless-steel pipe square at the desired length using appropriate tools for stainless steel.
2. Deburr inside and outside of the pipe end to remove sharp edges or slag; this ensures proper insertion and sealing.
3. Clean the pipe end and fitting interior of dust, oil, or debris.
4. On the pipe end, mark the correct insertion depth (as per the TruPress Depth Insertion Table) so you can verify full insertion.
5. Check that the sealing ring inside the fitting is present, clean and undamaged.

Assembly & Pressing Procedure

1. Insert the pipe fully into the fitting until it reaches the insertion mark. Ensure it is fully seated.
2. Ensure alignment: the pipe/fitting should be straight (not twisted) and the sealing ring properly seated.
3. Position the pressing tool's jaws or chain around the fitting's press profile (TruPress uses a "M-shaped" profile toroidal chamber) and verify the correct tool profile for that diameter.
4. Activate the press cycle until completion — do not release early. The tool should complete the full pressing cycle.
5. After pressing, visually inspect the joint to confirm the press profile (often a visible deformation or mark) and that there is uniform compression all around. (Download Novapress app and link the tool using Bluetooth. The app will compile data for each crimp)

Post-Installation: Testing & Commissioning

1. Before covering, insulating, or operating the line, perform a pressure test in accordance with local regulations and the manufacturer's recommendations (e.g., hydrostatic or pneumatic). The rated maximum working pressure is 232 psi for water/air systems.
2. Check all joints for visible leaks or deformation after the pressure test.

Support, Fixing & Expansion Considerations

1. Ensure pipe supports, clamps, and hangers are correctly installed — per TruPress installation instructions.
2. Avoid galvanic corrosion: if the stainless steel piping is in contact with dissimilar metals.
3. Proper spacing for tubing supports should be every 8' or less. Additional supports may be required where multiple fittings are installed in close proximity to prevent sagging. Additional support for valves and accessories are recommended.

Installation Notes:

- Always mark the insertion depth on the pipe before pressing.
- After pressing, the marking must remain visible next to the fitting.
- The insertion depth deviation must not exceed ±10%.

Depth of Insertion Table

PIPE OD (MM)	INSERTION DEPTH A (IN.)
15	13/16
22	13/16
28	7/8
42	1-3/16
54	1-3/8
76.1	2-3/16
88.9	2-3/8
108	2-15/16

INSTALLATION PROCEDURE (Continued)

Cutting & Bending:

- The pipe(s) should be cut to length using pipe cutters that are suitable for the material in use. Alternatively, fine-tooth hacksaws or suitable electric saws may be used. The cut must be square to avoid a negative impact on the mechanical resistance between the fitting and pipe. After cutting and deburring, the pipe ends must be cleaned or freed from chips or debris.

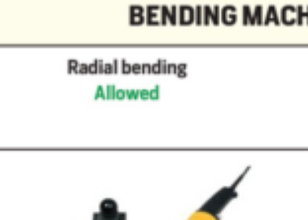
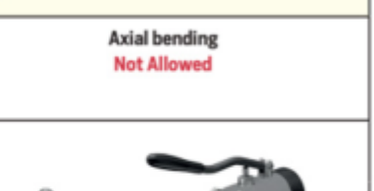
Not permitted: Tools that cause tarnishing during the cutting process

- Oil-cooled saws
- Flame cutting
- Grinders/Abrasive blades

To avoid damaging the sealing ring when inserting the pipe into the press fitting, the pipe must be carefully deburred, both inside and outside.

- Cutting the pipe to length

- Deburring the pipe

15mm & 22mm tube size can be bent up to 90° using a radial bender

BENDING MACHINES		
DN	Radial bending Allowed	Axial bending Not Allowed
15 mm 22 mm