

B-Press Installation Instructions

To install >B< Press, a Rothenberger Romax mechanical tool with compatible sized jaw to fit each size fitting is required. When pressure is exerted through the press tool a permanent joint is made and the fitting cannot be disassembled or re-used. The >B< Press profile has the advantage of a 3 Point Press making it more secure, through two presses either side of the bead and one press crimping the O-ring.



1. Cut the pipe

We recommend you use a Rothenberger pipe cutter. It is important to ensure that the pipe is cut completely square. Tube ends should be clean and free from scratches not less than the socket length.



5. Ensure pipe is inserted up to the tube stop

To assemble the joint, the tube must be inserted into the fitting up to the tube stop. (Use the mark on the tube which was made earlier as reference.) The pressing operation should only be undertaken when the tube reaches the tube stop. When inserting turn the tube slightly to ease the tube over the O-ring.



2. Remove burrs

Make sure that the internal and external tube end is free from burrs or sharp edges by using a deburring tool to prevent damage to the O-ring. Then wipe the tube end clean to avoid damaging the O-ring on tube insertion.



6. Complete the joint with the compression tool

Ensure that the correct size jaw for the fitting is inserted into the tool. The jaws must be placed square on the fitting. Depress the trigger/button to begin the compression cycle of the tool. This is complete when the mouth of the fitting is fully enclosed by the jaws. Now release the jaws from around the fitting. (For further information refer to complete Romax instructions.)



3. Ensure the O-ring is seated and lubricated

Before inserting the copper tube ensure that the O-ring is seated correctly, free from damage and lubricated. If not lubricated a small amount of water can be used to provide lubrication.

NOTE: >B< Press joint is complete after one complete compression cycle of the tool Do not crimp any >B< Press fitting more than once.



4. Mark insertion depth

The tube must be fully inserted into the fitting until it reaches the tube stop in order to make a perfect joint. Marking insertion depth will ensure that any tube movement is detected, which is especially important if the joints are to be pressed at a later time.

NOTE: As repair couplings do not have a tube stop, both ends of the tube must meet in the middle of the fitting.

Tube Size	Insertion Depth
15	17
18	22
20	22
25	23
32	25
40	31
50	39

Important

It is important to keep the fitting free of any dust or dirt and to ensure the O-ring stays lubricated and protected from damage. Select the correct size of tube and fitting for the job. Ensure that both are clean and free from damage and imperfections.