

INSTALLATION INSTRUCTIONS

PRESS FITTINGS

Compatible with Milwaukee®
M12™ and M18™ Press Tools

IMPORTANT

Be sure to read instructions thoroughly before beginning installation. Be sure to wear proper eye protection while installing.

Material of manufacture: Copper UNS C12200, Brass UNS C37700, and Brass UNS C46500

Sealing O-ring is made of EPDM.

Applications: potable water systems, process water systems, hydronic heating systems, and compressed air.

Maximum Operating pressure of: 1,380 kPa (200 psi)

Operating temperatures: 0 °C–93 °C (32 °F–200 °F)

Complies with: IAPMO/ANSI/CAN Z1117

ASME B16.51

NSF/ANSI/CAN 61

NSF/ANSI/CAN 372

TOOLS & SUPPLIES NEEDED

Tubing
Cutter



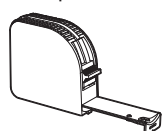
Pencil



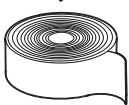
Deburring
Tools



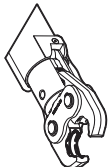
Measuring
Tape



Emery Cloth

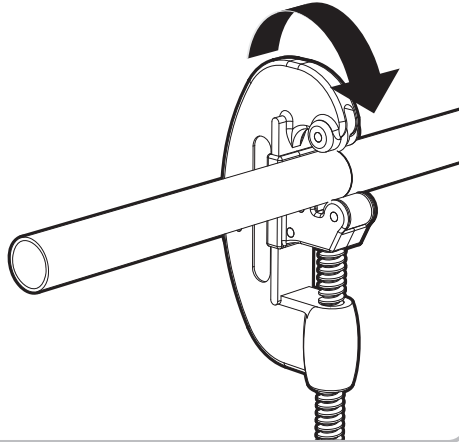


Copper
Press Tool



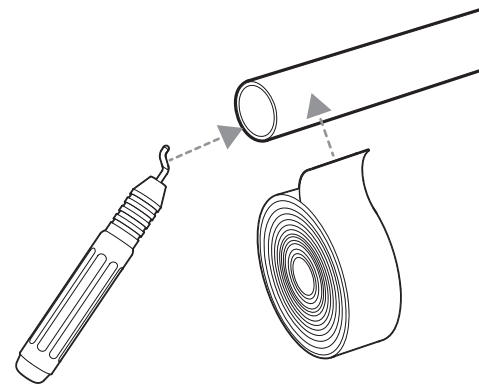
CUT TUBING TO LENGTH

- 1 Cut tube square using a tubing cutter or fine tooth saw.



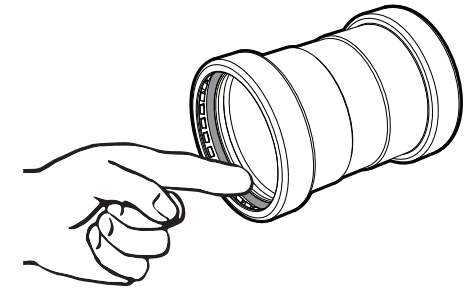
DEBURR CUT EDGE

- 2 Deburr inside and outside edges of cut tube. Clean outside surface of tube using Emory Cloth or similar method.



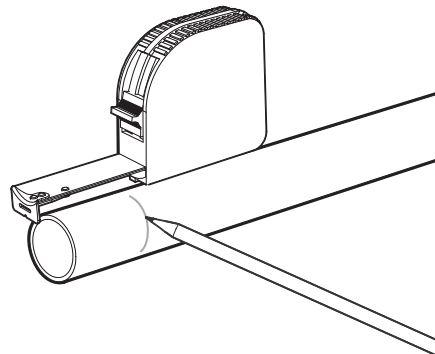
INSPECT FITTING

- 3 Verify that the sealing element is in place and undamaged.



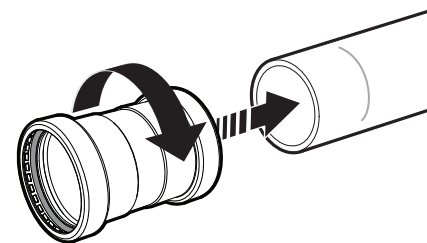
MEASURE INSERTION DEPTH

- 4 Measure and mark the proper insertion depth of the fitting, using the tables in this document.



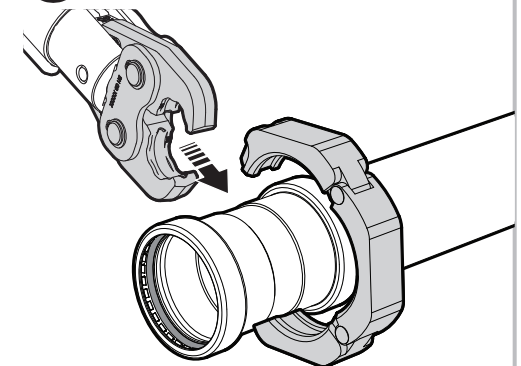
POSITION FITTING

- 5 Position the Press Fitting onto the tube while rotating slightly. Slide onto tube until you reach marked insertion depth.



PRESS FITTING

- 6 Position the collar of the press tool onto the fitting and press into place.



PRESS FITTING INSERTION DEPTH	
Nominal Size (in)	Minimum Insertion Depth
1/2"	1-3/16" (21mm)
3/4"	1" (26mm)
1"	1" (26mm)
1-1/4"	1-1/8" (28mm)
1-1/2"	1-1/2" (38mm)
2"	1-5/8" (42mm)
2-1/2"	2-3/16" (55mm)
3"	2-7/16" (63mm)
4"	2-7/8" (74mm)

MINIMUM DISTANCE BETWEEN TWO PRESS FITTINGS	
Nominal Size (in)	Minimum Clearance
1/2"	1/8" (3mm)
3/4"	1/8" (3mm)
1"	1/8" (3mm)
1-1/4"	1/2" (13mm)
1-1/2"	11/16" (18mm)
2"	7/8" (22mm)
2-1/2"	11/16" (18mm)
3"	11/16" (18mm)
4"	11/16" (18mm)

DISTANCES FOR ADDING PRESS FITTINGS IN LINE WITH EXISTING FITTINGS		
Nominal Size (in)	Minimum Distance from Soldered	Minimum Distance from Brazed
1/2"	3/8" (10mm)	1-1/2" (38mm)
3/4"	3/8" (10mm)	1-15/16" (50mm)
1"	9/16" (14mm)	2-1/2" (63mm)
1-1/4"	9/16" (14mm)	3" (76mm)
1-1/2"	3/4" (19mm)	3-7/16" (88mm)
2"	7/8" (22mm)	4-1/2" (114mm)
2-1/2"	3/8" (10mm)	5-1/2" (139mm)
3"	3/8" (10mm)	6-1/2" (165mm)
4"	3/8" (10mm)	8-1/2" (216mm)

DISTANCES FOR SOLDERING OR BRAZING IN LINE WITH EXISTING PRESS FITTINGS		
Nominal Size (in)	Soldering Minimum Distance	Brazing Minimum Distance
1/2"	2-1/4" (57mm)	5-1/2" (139mm)
3/4"	3" (76mm)	7-3/4" (197mm)
1"	3-3/4" (95mm)	10" (254mm)
1-1/4"	4-1/2" (114mm)	12-1/4" (311mm)
1-1/2"	5-1/4" (133mm)	14-1/2" (368mm)
2"	6-3/4" (172mm)	19" (482mm)
2-1/2"	8-1/4" (210mm)	23-1/2" (597mm)
3"	9-3/4" (248mm)	28" (711mm)
4"	12-3/4" (324mm)	37" (940mm)

