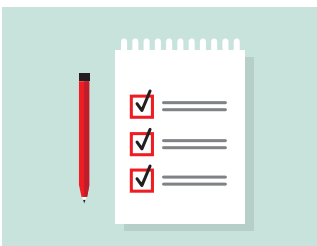


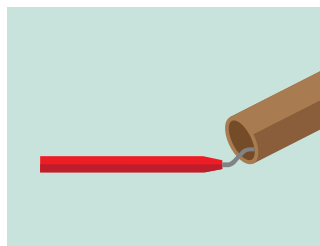
Top tips for a perfect installation

>B< MaxiPro



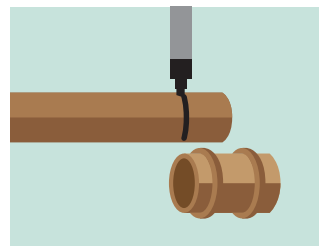
1. Installation requirements

- Only tube listed in the tube compatibility table, section 16.9 of the >B< MaxiPro Technical Manual should be used with >B< MaxiPro fittings.
- Joints should only be made on an unstressed pipework assembly.
- The minimum distance to joints, pressed, brazed and joints to be brazed as defined in the >B< MaxiPro Technical Manual must be followed at all times.



2. Tube Preparation

- Time and care must be taken to prepare the tube ends. They must be clean and free from oxidization, dirt and debris.
- A rotary tube cutter must be used to cut the tube square.
- Deburred both internally and externally to remove burrs and sharp edges.
- Surface scratches and markings on the tube within the socket length can provide a leak path for refrigerant. Any such markings must either be removed through polishing or the affected area cut off.



3. Marking and Inserting Tube

- Before inserting tube the O-ring must be checked and seated correctly in the fitting.
- Tube must be marked with the insertion depth. This can be done by either using the fitting or the >B< MaxiPro depth gauge.



4. Pressing the Fitting

- Check that the tube is fully inserted prior to pressing. Use the insertion depth mark as a guide.
- Ensure you have the correct size jaw and are using an approved tool.
- Align the jaw squarely on the fitting and complete one full press cycle on the tool – do not repress.

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1

Tube Preparation



Step 1 – Cut the tube to length

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

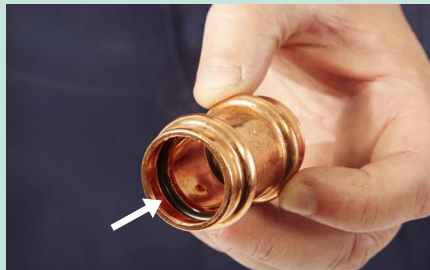


Step 2 – Deburr and remove all sharp edges externally

- Angle the tube downwards to prevent filings entering the tube.
- Make sure the external surface of the tube end is smooth and free from burrs or sharp edges.

2

Marking and Inserting Tube



Step 1 – 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.
- Check the O-rings are clean and free from debris.
- Additional >B< MaxiPro lubrication may be used to aid tube insertion.

Option A



Step 2 – Mark insertion depth

- 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 or fitting (if possible) while slipping it into the fitting.
- Mark the insertion depth on the tube.

3

Pressing the Fitting



Step 1 – 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 bead on the fitting should fit centrally in the groove of the jaw.
- The jaws must be placed squarely on the fitting locating the groove on the bead.



Step 2 – Complete the joint with approved tool – press once only

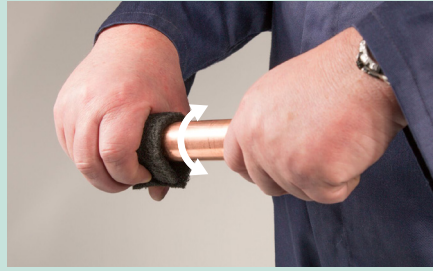
- Depress and hold the button to complete the pressing cycle.
- Pressing is complete when the jaws are fully closed and the piston retracts.
- Complete the press cycle once only – do not repress.

It is vital to follow all installation steps shown overleaf.
Shortcuts will void warranty and are likely to lead to leaks.



Step 3 – Use a pencil type deburrer on internal edges

- Make sure the internal surface of the tube end is smooth and free from burrs or sharp edges.



Step 4 – Thoroughly clean the tube ends and remove scratches

- Remove light scratches using Rothenberger Rovlies or similar cleaning pad to polish the tubing. Cleaning should be done radially to avoid creating scratches along the tube.
- Tube ends must be free from scratches, oxidation, dirt and debris.



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



Step 3 – 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.



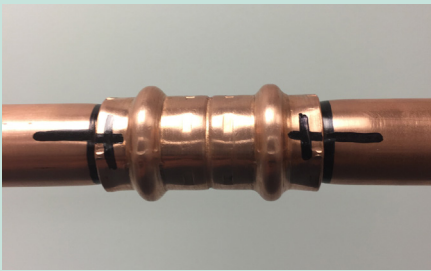
Option B Alternatively to Step 2 & 3 use depth gauge

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



Step 4 – Insert the tube fully into the fitting up to the tube stop

- To reduce the risk of dislodging the O-ring rotate the tube or fitting (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.



Step 3 – Mark Completed Joint

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

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