

>B< Steel Gas



>B< Steel Gas fittings are specialized carbon steel press fittings specifically engineered to connect carbon steel pipes. These fittings offer a flame-free installation process and range from sizes 1/2" to 2".

- **H** = HNBR colour identification on the fitting for quick application recognition.
- Stainless grip ring for additional strength.
- Suitable for various applications.
- Unpressed joint indicator.
- Quick and easy to install, saving on labor costs.
- Compatible with Carbon Steel Tubes for Schedule 10 and Schedule 40.
- Manufactured using high quality materials to applicable standards.
- Approved by IAPMO.
- Maximum working pressure 200 psi.
- Maximum working temperature 180°F.
- No welding consumables required.
- Comprehensive range of fittings - sizes from 1/2" to 2".
- 15-year limited warranty.

Approved Applications*

Type of service	Comments	Pressure (psi)	Temp (°F)
Oils/Fuels/Lubricants			
Heating Fuel Oil		125	Up to 100 °F
Diesel Fuel		125	Up to 100 °F
Engine Oil		125	Ambient
Gear Oil		125	Ambient
Mineral Oil		200	Ambient
Lube Oil	Petroleum based	200	Up to 150 °F
Hydraulic Oil		125	Ambient
Natural Gas	Primarily methane	125	-40°F to 180 °F
Transmission Fluid		125	Ambient
Propane		125	-40°F to 180 °F
Butane		125	-40°F to 180 °F
Gases			
Vacuum	Maximum differential pressure	Max 29.2 inches of Mercury	Up to 160 °F
Nitrogen - N ₂		200	Up to 140 °F
Argon - Ar		200	Up to 140 °F
Carbon dioxide - CO ₂	Dry CO ₂	200	Up to 140 °F
Acetylene	Up to 350psi test pressure	20	Ambient
Compressed Air		200	Up to 140 °F

Product Components

- Carbon Steel Body
- Zinc & Nickel Coating
- 420 Stainless Steel Grip Ring
- 420 Stainless Steel Separator Ring
- Yellow HNBR O-Ring

Tool	Attachments	Sizes (in)
Viega Pressgun 6	Standard Series Jaws	1/2" - 1"
	V2 Actuator and Rings	1 1/4" - 2"
RIDGID RP 330/340/350/351	Standard Series Jaws	1/2" - 1"
	V2 Actuator and Rings	1 1/4" - 2"
RIDGID RP 342-XL	Standard Series Jaws	1/2" - 1"
	V2 Actuator and Rings	1 1/4" - 2"
Milwaukee M18 Force Logic	M18 IPS-P Jaws	1/2" - 1"
	M18 IPS-Pr1 Rings + Ring Jaw 1	1 1/4" - 2"
Milwaukee M18 Long Throw	M18 IPS-P Jaws	1/2" - 1"
	M18 IPS-Pr1 Rings + Ring Jaw 1	1 1/4" - 2"

Certificates - HNBR	
IAPMO	ANSI LC 4a/CSA 6.32a

Standards and Codes Compliance - HNBR	
ASME	B31 Code for Pressure Pipe; Standards B31.1, B31.3 and B31.9
IAPMO	Uniform Mechanical Code (UMC), Uniform Plumbing Code (UPC)
NFPA	54 and 58

Tube Compatibility*	
ASTM A53	Schedule 10 and Schedule 40
ASTM A135	
ASTM A106	
ASTM A795	

*Federal, state and local regulations, codes of practice and bylaws governing the installation must be adhered, during the selection of the tubes and fittings for different applications.



>B< Steel Installation Process

To install >B< Steel, a press tool, actuator and compatible sized jaw or press ring to fit each size fitting is required. When force is exerted through the press tool a permanent joint is made and the fitting cannot be disassembled or reused.

1/2" to 1" - Jaws



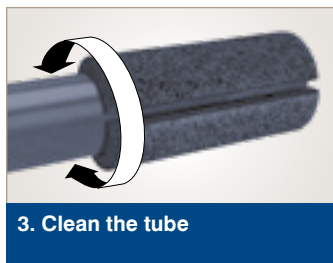
1. Cut tube to length

- It is important to ensure that the tube is cut completely square.
- Tube ends should be clean and free from scratches no less than the socket length.



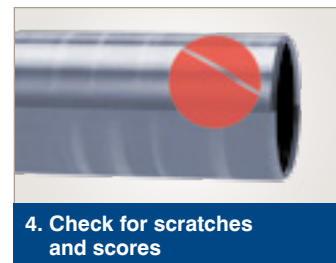
2. Deburr

- Make sure that the internal and external tube end is free from burrs or sharp edges by using a half round file or deburring tool.
- Then wipe the tube end clean to avoid damaging the seal on tube insertion.



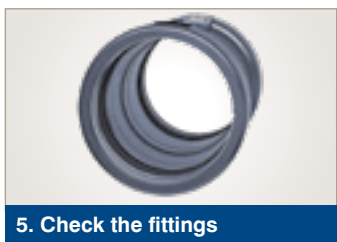
3. Clean the tube

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



4. Check for scratches and scores

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



5. Check the fittings

- Before inserting the tube check seal for correct placement, damage or any ingress of debris.
- To prevent this occurring we recommend the fittings are retained in packaging up to the point of use.



6. Mark the 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.
- The depth marking must be visible on the pressed fitting.



7. Align jaw & Press

- 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.
- Depress and hold the start button on the press tool to complete the pressing cycle.
- Pressing is complete when the jaws are fully closed.



8. Joint completion

- Remove the label to indicate the joint is pressed and complete.

For sizes 1 1/4" to 2" (Slings) follow points 7a-7c

1 1/4" to 2" - Slings



7a. Fit the pressing ring

- Using the appropriate size pressing ring, open the pressing ring, locate on the fitting bead and close the pressing ring.



7b. Engage the actuator and check insertion depth

- With the actuator fitted in the press tool open the actuator and locate the actuator onto the aperture of the pressing ring.
- Check for any tube movement prior to pressing.



7c. Press the joint

- Depress and hold the trigger of the tool until the press cycle of the tool is automatically completed. Keep hands clear of the press actuator and press ring until the cycle is completed.
- Do not repress the fitting.

Important

It is important to keep the fitting free of any dust or dirt, and to ensure the seal 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. When using a press tool always wear ear and eye protection.