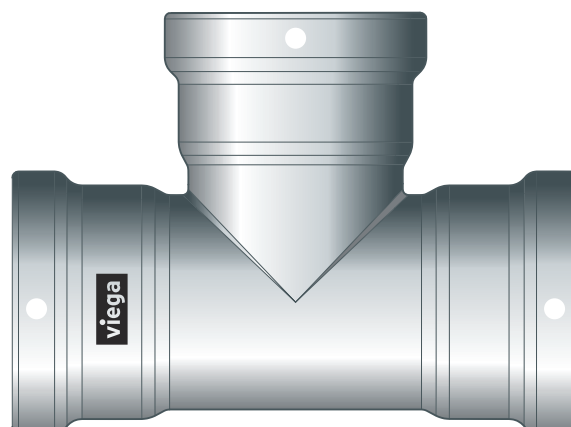


# Instructions for Use

## Megapress S XL



Press connector system made of non-alloy steel for thick-walled steel pipes

**System**  
Megapress S XL

**Year built (from)**  
10/2017

**viega**

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# 1 About these instructions for use

Trade mark rights exist for this document; for further information, go to [viega.com/legal](http://viega.com/legal).

## 1.1 Target groups

The information in this manual is directed at heating and sanitary professionals and trained personnel.

Individuals without the abovementioned training or qualification are not permitted to mount, install and, if required, maintain this product. This restriction does not extend to possible operating instructions.

The installation of Viega products must take place in accordance with the general rules of engineering and the Viega instructions for use.

## 1.2 Labelling of notes

Warning and advisory texts are set aside from the remainder of the text and are labelled with the relevant pictographs.



### **DANGER!**

This symbol warns of possible life-threatening injury.



### **WARNING!**

This symbol warns of possible serious injury.



### **CAUTION!**

This symbol warns of possible injury.



### **NOTICE!**

This symbol warns of possible damage to property.



This symbol gives additional information and hints.

## 1.3 About this translated version

This instruction for use contains important information about the choice of product or system, assembly and commissioning as well as intended use and, if required, maintenance measures. The information about the products, their properties and application technology are based on the current standards in Europe (e.g. EN) and/or in Germany (e.g. DIN/DVGW).

Some passages in the text may refer to technical codes in Europe/Germany. These should serve as recommendations in the absence of corresponding national regulations. The relevant national laws, standards, regulations, directives and other technical provisions take priority over the German/European directives specified in this manual: The information herein is not binding for other countries and regions; as said above, they should be understood as a recommendation.



## 2 Product information



### These instructions for use contain videos

Some assembly and action steps are shown using the example of a piping system other than the one described here, but are equally applicable.

### 2.1 Standards and regulations

The following standards and regulations apply to Germany / Europe. National regulations can be found on the website specific to your country at [viega.com.au/standards](http://viega.com.au/standards).

#### Regulations from section: Application areas

Scope / Notice	Regulations applicable in Germany
No application for fuel gases	DVGW G 260
Planning, setup, operation and maintenance of fire extinguishing systems ■ Wet	DIN 14462
Sprinkler systems depending on the sealing element ■ Wet ■ Wet / dry with FKM sealing element ■ Dry with FKM sealing element	VdS CEA 4001

#### Regulations from section: Media

Scope / Notice	Regulations applicable in Germany
Suitability for heating water for pump hot water heating systems	VDI-Richtlinie 2035, Sheet 1 and Sheet 2

## Regulations from section: Pipes

Scope / Notice	Regulations applicable in Germany
Pipe overview lightweight	AS 1074-1989
Pipe overview medium and heavy	AS 1074-1989
Pipe overview according to US standard	ASTM A53, ASTM A106B and ASME B36.10M
External protective coatings (galvanisation) for steel pipes	AS 4792
Fixing distance between the pipe clamps	VdS CEA 4001

## Regulations from section: Sealing elements

Scope / Notice	Regulations applicable in Germany
Area of application of the FKM sealing element ■ Heating	DIN EN 12828

## Regulations from section: Storage

Scope / Notice	Regulations applicable in Germany
Requirements for material storage	DIN EN 806-4, Chapter 4.2

## Regulations from section: Notes on mounting

Scope / Notice	Regulations applicable in Germany
Requirements and notes for fire extinguisher and sprinkler systems	VdS-Anerkennung G 414021
Permissible pressures, nominal widths and application conditions	VdS 2100-26-2: 2012-04, Table A. 1
Fixing distances Fire risk classes	VdS CEA 4001, Section 15.2
Minimum pipe wall thickness and maximum pipe wall thickness	VdS CEA 4001, table 15.01
External protective coatings (galvanisation) for steel pipes	DIN EN 10240

## Regulations from section: Establishing a flange connection

Scope / Notice	Regulations applicable in Germany
Qualification of personnel for the assembly of flange connections	VDI-Richtlinie 2290
Determination of tightening torques	DIN EN 1591-1

## Regulations from section: Leakage test

Scope / Notice	Regulations applicable in Germany
Test on a system that is finished but not yet covered	DIN EN 806-4
Leakage test for water installations	ZVSHK-Merkblatt: "Dichtheitsprüfungen von Trinkwasserinstallationen mit Druckluft, Inertgas oder Wasser"
Pressure test in sprinkler units	VdS CEA 4001, Chapter 17
Requirements for filling and top-up water	VDI 2035

## 2.2 Intended use



Agree the use of the system for areas of application and media other than those described with Viega.



The expression "SC-Contur" appearing in the instructions for use means "Smart Connect Feature".

## 2.2.1 Areas of application

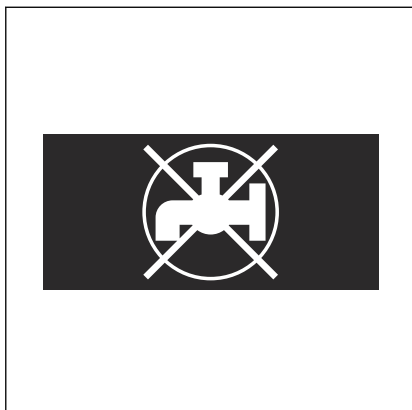


Fig. 1: "Non-potable water"

The system is intended for use in industrial, heating and cooling systems and is a replacement for welded, threaded and rolled-groove connections for new installations and repairs. The system is not suitable for use in potable water installations. For this reason, the press connectors are labelled with a black symbol "Not potable water".



Components listed in the catalogue with a 5-digit article number do not have the "No potable water" symbol but are still not suitable for use in potable-water installations.

Do not use the piping system for fuel gases, see ↗ 'Regulations from section: Application areas' on page 5.

The press connector system is designed for nominal pressure PN 16.

Use is possible in the following areas among others:

- Closed heating and cooling circuits
- Industrial units
- Sprinkler systems, see ↗ 'Regulations from section: Application areas' on page 5
  - Wet
  - wet/dry
  - Dry
- Fire extinguishing systems, see ↗ 'Regulations from section: Application areas' on page 5
  - Wet
- Compressed air systems
- Systems for technical gases (on request)

For information on areas of application of the sealing elements, see ↗ Chapter 2.3.4 'Sealing elements' on page 15.

## 2.2.2 Media

The system is suitable for the following media, amongst others:

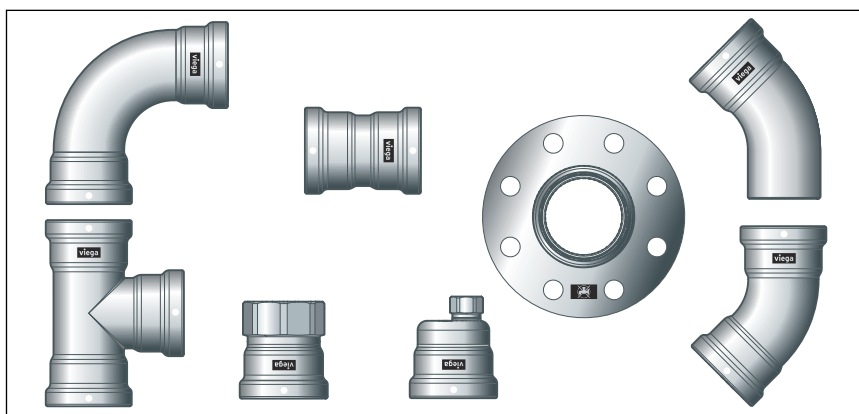
For the applicable directives, see ↗ 'Regulations from section: Media' on page 5.

- Heating water for closed pump hot water heating systems
- Compressed air (dry) in compliance with the specification of the sealing elements being used
- Anti-freeze, cooling brines up to a concentration of 50 %
- technical gases (on request)

## 2.3 Product description

### 2.3.1 Overview

The piping system consists of press connectors for thick-walled steel pipes and the corresponding press tools.



**Fig. 2: Megapress S XL press connectors**

The system components are available in the following dimensions:  
D2½ (DN65 - 73.0 mm and 76.1 mm), D3 (DN80), D4 (DN100)

### 2.3.2 Pipes

Megapress S XL press connectors may be used with the following steel pipes:

- Black
- Galvanised
- Industrially painted
- Powder coated

The steel pipes must correspond to the applicable regulations, see  
🔗 *'Regulations from section: Pipes' on page 6*



If the pipe has been coated, the maximum external diameter mentioned in the table must not be exceeded.

## Pipe overview

### Megapress S XL – Australian standard – lightweight pipe series

Thread size [inch]	Nominal diameter [DN]	Nominal external diameter [mm]	Min. external diameter incl. coating [mm]	Max. external diameter incl. coating [mm]	Wall thickness for press connectors Lightweight [mm]	Wall thickness for press-in branch connector [mm]	Press-in branch connector Rp $\frac{3}{4}$ [Article number]
2½	65	76.1	75.2	76.0	3.2	2.6–4.5	731182
3	80	88.9	87.9	88.7	3.2	2.6–5.0	731199
4	100	114.3	113.0	113.9	3.6	2.6–5.4	731205

### Megapress S XL – Australian standard – medium and heavy pipe series

Thread size [inch]	Nominal diameter [DN]	Nominal external diameter [mm]	Min. external diameter incl. coating [mm]	Max. external diameter incl. coating [mm]	Wall thickness for press connectors Medium [mm]	Wall thickness for press connectors Heavy [mm]	Wall thickness for press-in branch connector [mm]	Press-in branch connector Rp $\frac{3}{4}$ [Article number]
2½	65	76.1	75.4	76.6	3.6	4.5	2.6–4.5	731182
3	80	88.9	88.1	89.5	4.0	5.0	2.6–5.0	731199
4	100	114.3	113.3	114.9	4.5	5.4	2.6–5.4	731205
5	125	139.7	138.7	140.6	–	–	2.9–5.4	731212
6	150	165.1	164.1	166.1	–	–	2.9–5.4	731229

### Megapress S XL – pipes according to US standard

Thread size [inch]	Nominal diameter [DN]	Nominal external diameter [mm]	Schedule No.	Wall thickness for press connector [mm]	Wall thickness for press-in branch connector [mm]	Press-in branch connector Rp $\frac{3}{4}$ [Article number]
2½	65	73.0	5	2.11	–	–
2½	65	73.0	10	3.05	3.05	26810*
2½	65	73.0	40	5.16	5.16	26840*
3	80	88.9	5	2.11	–	–
3	80	88.9	10	3.05	3.05	731199
3	80	88.9	40	5.49	–	–
4	100	114.3	5	2.11	–	–

Thread size [inch]	Nominal diameter [DN]	Nominal external diameter [mm]	Schedule No.	Wall thickness for press connector [mm]	Wall thickness for press-in branch connector [mm]	Press-in branch connector Rp ¾ [Article number]
4	100	114.3	10	3.05	3.05	731205
4	100	114.3	40	6.02	–	–
5	125	141.3	10	–	3.40	731212
6	150	168.3	10	–	3.40	731229

\*DN65 (73.0 mm) with FPT ¾ for pipes according to ASTM A53

## Laying and fixing pipes

Only pipe clamps with chloride-free sound insulating inlays should be used to secure the pipes.

Observe the general rules of fixing technology:

- Do not use fixed pipelines as a support for other pipelines and components.
- Do not use pipe hooks.
- Observe the expansion direction: Plan fixed and gliding points.

## Distance between the pipe clamps

D [mm]	Nominal diameter [inch]	Fixing distance between the pipe clamps [m] <sup>1)</sup>	Fixing distance between the pipe clamps [m] <sup>2)</sup>
73.0 76.1	2½	5.50	4.00
88.9	3	6.00	4.00
114.3	4	6.00	4.00

<sup>1)</sup> acc. to manufacturer's information

<sup>2)</sup> according to VdS, see ↗ 'Regulations from section: Pipes' on page 6

## Length expansion

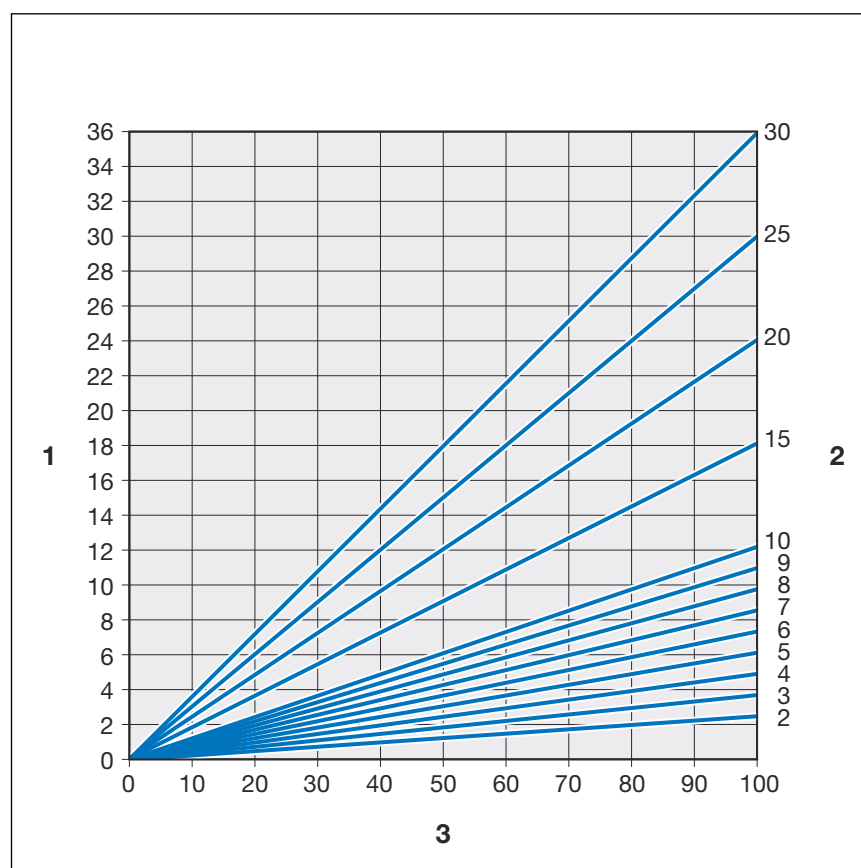
Pipelines expand with heat. Heat expansion is dependent on the material. Changes in length lead to tension within the installation. These tensions must be compensated for with suitable measures.

The following are effective:

- Fixed and gliding points
- Expansion equalisation joints (expansion bends)
- Compensators

### Heat expansion co-efficients of various pipe materials

Material	Heat expansion co-efficient $\alpha$ [mm/mK]	Example: Length extension with pipe length $L = 20$ m and $\Delta\theta = 50$ K [mm]
Steel	0.0120	12.0



**Fig. 3: Length expansion steel pipes**

1 - Length expansion  $\rightarrow \Delta l$  [mm]

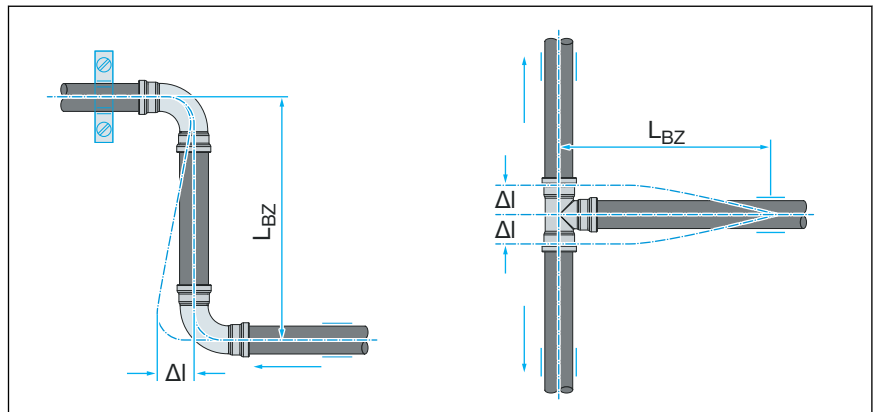
2 - Pipe length  $\rightarrow l_0$  [m]

3 - Temperature difference  $\rightarrow \Delta\theta$  [K]

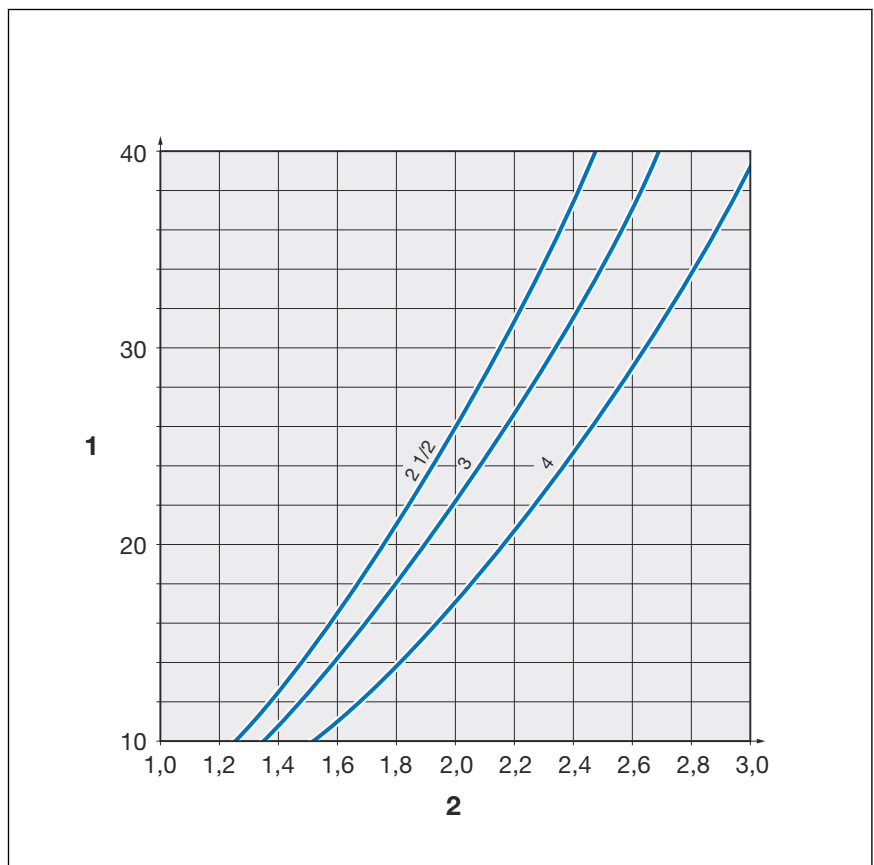
The length expansion  $\Delta l$  can be taken from the diagram or can be calculated using the following formula:

$$\Delta l = \alpha \text{ [mm/mK]} \times L \text{ [m]} \times \Delta\theta \text{ [K]}$$



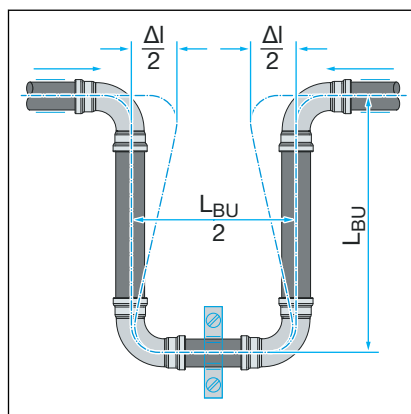


**Fig. 4: Z-shaped and T-shaped expansion bends**

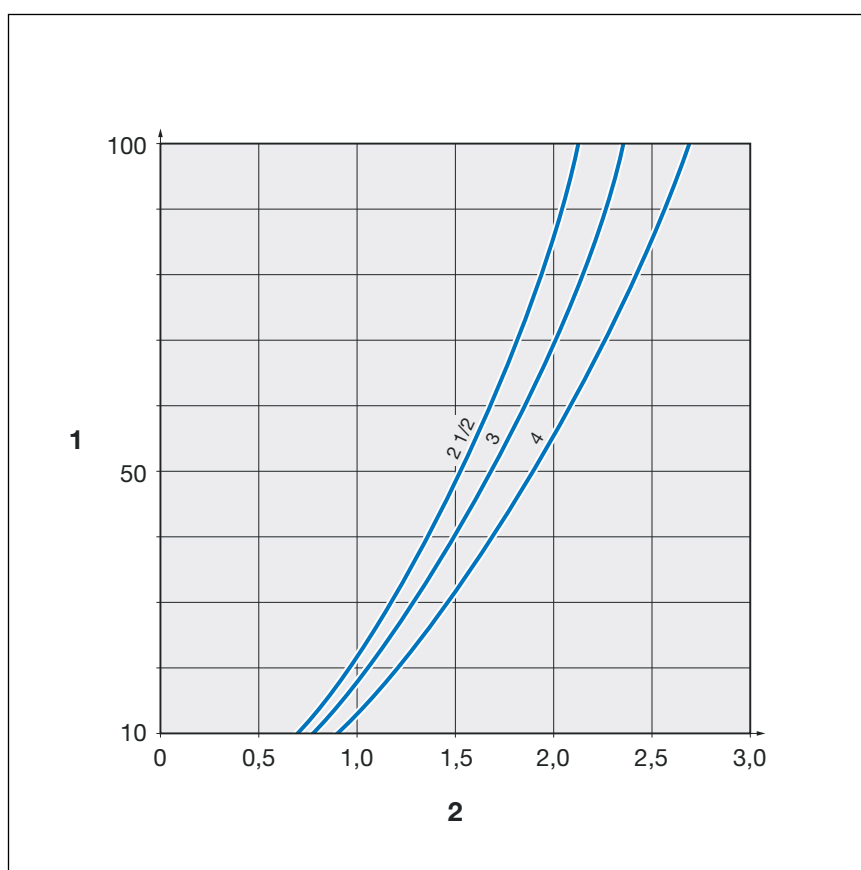


**Fig. 5: Z- and T-shaped expansion bends for Megapress S XL 2 1/2 to 4 inches**

- 1 - Expansion compensation  $\rightarrow \Delta l$  [mm]  
 2 - Pipe bend length  $\rightarrow L_{BZ}$  [m]



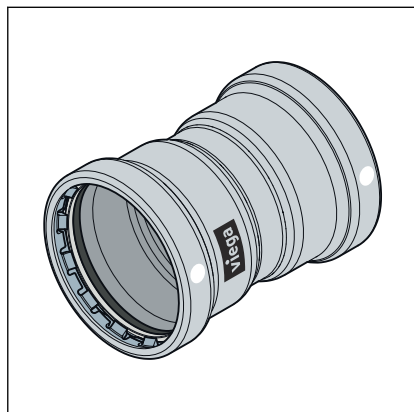
**Fig. 6: U-shaped expansion bend**



**Fig. 7: U-shaped expansion bend for Megapress S XL 2 1/2 to 4 inches**

- 1 - Expansion compensation  $\Delta l$  [mm]  
 2 - Pipe bend length  $L_{BZ}$  [m]

### 2.3.3 Press connectors

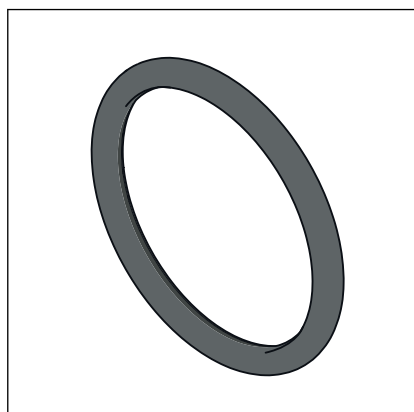


**Fig. 8: Megapress S XL press connectors**

The Megapress S XL press connectors consist of non-alloy steel (material 1.0308) and have an external 3–5 µm zinc-nickel coating. There is a cutting ring, a separator ring, and a round sealing element with increased cross section in the bead of the press connector. The cutting ring cuts into the pipe during pressing and ensures a force-fit connection.

During installation, and later during the pressing, the separator ring protects the sealing element from damage from the cutting ring.

### 2.3.4 Sealing elements



**Fig. 9: FKM round sealing element**

Megapress S XL press connectors are factory-fitted with FKM sealing elements. Thanks to the increased line thickness, even seal pipe surfaces with slightly uneven surfaces are sealed off.

If the collector type (flat / vacuum tube collector) has not yet been determined at the time of laying the connection pipe to the solar-energy installation, Viega recommends using FKM sealing elements in the press connectors.

#### Area of use of the FKM sealing element

Area of application	Heating	Solar installations	Compressed air	Technical gases
Use	Pump hot water heating system	Solar circuit	all pipeline sections	all pipeline sections
Operating temperature [T <sub>max.</sub> ]	-5 °C–140 °C	1)	60 °C	—
Operating pressure [P <sub>max.</sub> ]	1.6 MPa (16 bar)	0.6 MPa (6 bar)	1.6 MPa (16 bar)	—
Comments	pursuant to the applicable regulations <sup>2)</sup> T <sub>max.</sub> : 105 °C	—	<sup>3)</sup> dry	1) 3)

<sup>1)</sup> Consultation with Viega required.

<sup>2)</sup> see  'Regulations from section: Sealing elements' on page 6

<sup>3)</sup> See also document "Areas of application for metal installation systems" on the Viega website



The sealing materials of the press connector system are subject to thermal ageing, which depends on the media temperature and the service life. The higher the media temperature, the faster the thermal ageing of the sealing material progresses. In the case of special operating conditions such as industrial heat recovery systems, it is necessary to compare the specifications of the equipment manufacturer with the specifications of the press connector system.

Before using the press connector system outside the described areas of application or if in doubt about the correct material selection, please contact Viega.

## 2.3.5 Technical data

Observe the following operating conditions for the installation of the system:

Operating temperature [ $T_{\max}$ ]	140 °C
Operating pressure [ $P_{\max}$ ]	1.6 MPa (1600 kPa, 16 bar)*

\*For chilled water, closed circuit and pump hot water heating system:

- A maximum pressure of 2100 kPa ist permissible at temperature up to 105 °C

## 2.3.6 Markings on components

### Markings on press connectors

The press connectors are marked with a coloured dot. The dot identifies the SC-Contur where the test medium would escape in the case of an inadvertently unpressed connection.

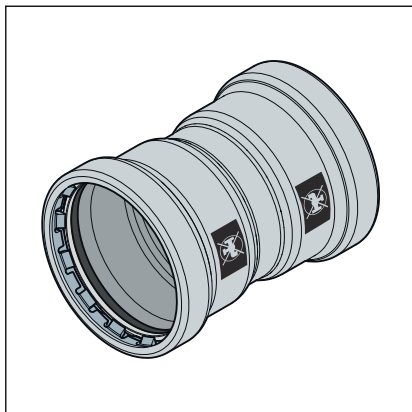


Fig. 10: White dot and print "Not suitable for potable water!"

The white dot indicates that the press connection is equipped with the FKM round sealing element and with the SC-Contur.

The black rectangle serves as a warning "Not suitable for potable water!".

The rectangle is to be found in the following places:

- On the press end of the press connector
- On the flange of the flange adapter



Components listed in the catalogue with a 5-digit article number do not have the "No potable water" symbol but are still not suitable for use in potable-water installations.

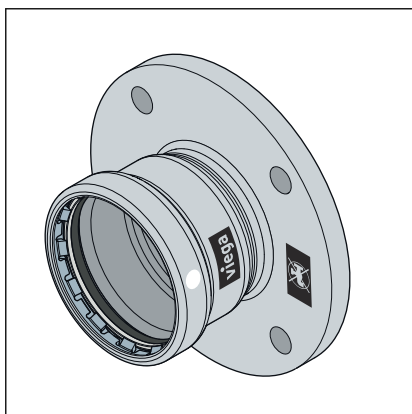


Fig. 11: White dot and print "Not suitable for potable water!"

## 2.4 Information for use

### 2.4.1 Corrosion

A zinc-nickel coating protects Megapress S XL press connectors against external corrosion, e. g. in the case of arising condensation in cooling systems.



Pipes must be equipped with suitable corrosion protection.

Pipes and press connectors must be insulated according to the general rules of engineering.

Observe the manufacturer's information.

## 3 Handling

### 3.1 Transport

Observe the following when transporting pipes:

- Do not pull the pipes over the sill. The surface could be damaged.
- Secure pipes during transportation. Pipes may become bent due to shifting.
- Do not damage the protective caps on the pipe ends and do not remove them until immediately before mounting. Damaged pipe ends must not be pressed.



In addition, observe the instructions provided by the pipe manufacturer.

### 3.2 Storage

For storage, comply with the requirements specified in the applicable regulations, see [§ 'Regulations from section: Storage' on page 6](#):

- Store components in a clean and dry place.
- Do not store the components directly on the floor.
- Where possible, store different sizes separately.  
Store small sizes on top of larger sizes if separate storage is not possible.
- Store pipes of different materials separately to prevent contact corrosion.



In addition, observe the instructions provided by the pipe manufacturer.

### 3.3 Assembly information

#### 3.3.1 Mounting instructions

System components may, in some cases, become damaged through transportation and storage.

- Only use original parts in perfect condition.
- Damaged parts must be replaced. Do not attempt to repair them.
- Store products in a clean and dry place.
- Check the installation pipes for suitable surface properties and the min./max. external diameter.

- Do not press on embossed pipe markings.
- Pipes and press connectors must be insulated pursuant to the general rules of engineering.

## Fire extinguisher and sprinkler systems

The following requirements must be observed:

- For the applicable directives, see ↗ *'Regulations from section: Notes on mounting'* on page 6
- Compliance with the data from the following table



For sprinkler systems in compliance with VdS, only black, galvanised, or powder-coated steel pipes according to the specifications for VdS approval may be used.

## Permissible pressures, nominal widths and application conditions

Permitted pressure	DN65: 1.6 MPa (16 bar) DN80: 1.25 MPa (12.5 bar) DN100: 1.0 MPa (10 bar)
Nominal widths	D 2½–4
Area of use (pipeline network)	Wet sprinkler units: ■ Piping network downstream of the alarm valve station Dry sprinkler units: ■ Piping network downstream of the alarm valve station
Fixing intervals	1)
Firefighting water additive	Generally not permitted; exceptions only with the manufacturer's permission and prior agreement of the VdS

1) see ↗ *'Regulations from section: Notes on mounting'* on page 6

## Pipe wall thicknesses

DN [inch]	Minimum pipe wall thickness [mm] <sup>1)</sup>	Maximum pipe wall thicknesses [mm]
D 2½ (DN 65)	2.6	4.5
D 3 (DN 80)	2.9	5.0
D 4 (DN 100)	3.2	5.4

The following fire hazard classes are covered by Megapress S XL:

- Fire hazard class LH (light hazard)
- Fire hazard class OH 1–4 (ordinary hazard)

- Fire hazard class HHP 1–4 (extra hazard, production risks)
- Fire hazard class HHS 1–4 (extra hazard, storage risks)

See ↗ *'Regulations from section: Notes on mounting'* on page 6.



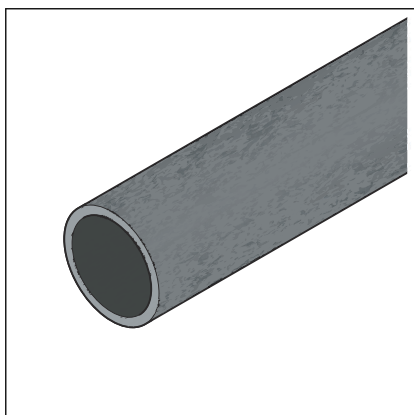
## Preparation of the pipes

As long as they are free from dirt, smooth, firm, even and undamaged, the following pipe surfaces are suitable for the production of press connections without further treatment:

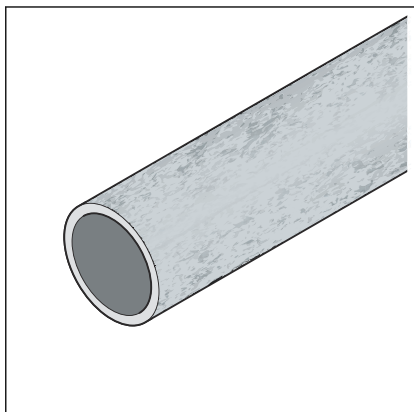


### NOTICE!

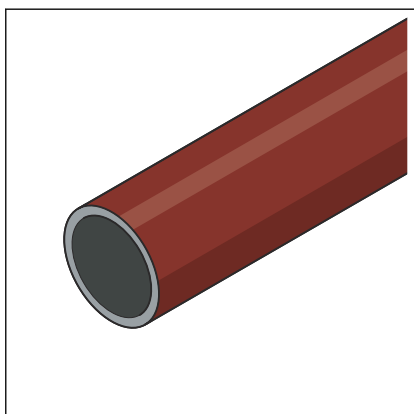
Always check the quality of the pipe surface on the complete pipe circumference. For permanently installed existing pipes, for example, Viega recommends the use of a mirror to be able to check the surface quality on the complete pipe circumference.



Black uncoated pipes



Galvanised pipes, for galvanisation see ↗ *Chapter 2.1 'Standards and regulations' on page 5* (maximum external diameter in acc. with ↗ *Chapter 2.3.2 'Pipes' on page 9*)

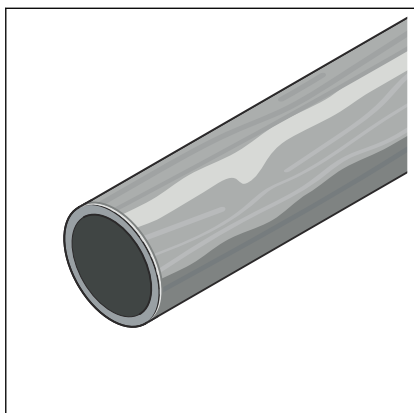


Industrially painted or powder-coated pipes (maximum external diameter in acc. with ↗ *Chapter 2.3.2 'Pipes' on page 9*)

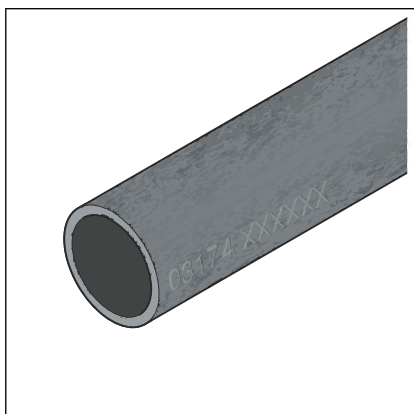
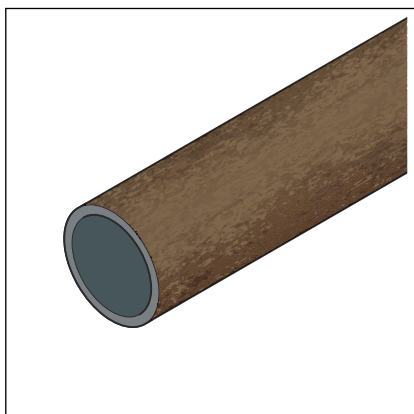
Pipe surfaces must be treated around the press connection if they exhibit the following characteristics:

Uneven, manually applied layers of paint

Exceeding the maximum external diameter due to coating that has been applied → *Chapter 2.3.2 'Pipes' on page 9*



Bumps, damage, grooves, corrosion or loose adhesions



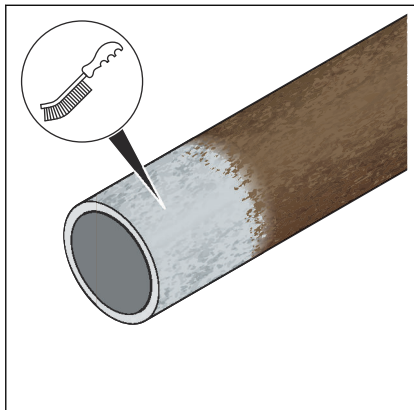
### NOTICE! Leaky press connection

Pressings on the embossed pipe marking may cause leaking.

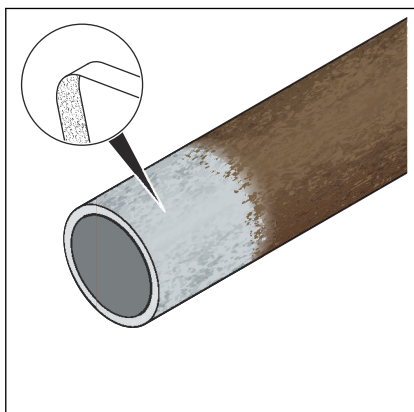
- Do not carry out pressings on the embossed pipe marking.

The following are examples of suitable tools for the work:

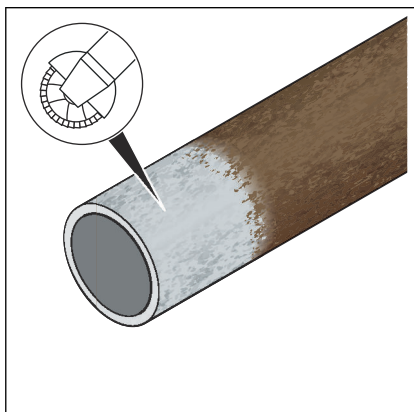
■ Wire brush



■ Cleaning fleece or sanding paper (grain > 80)



■ Angle grinder with lamella flap disc

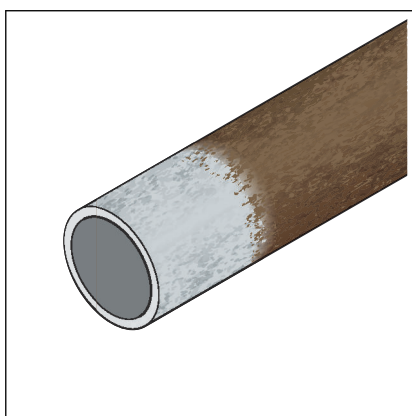


After the treatment, the quality of the pipe surface should be as shown in the following graphic:



### NOTICE!

Always check the quality of the pipe surface on the complete pipe circumference. For permanently installed existing pipes, for example, Viega recommends the use of a mirror to be able to check the surface quality on the complete pipe circumference.



The external diameter of the installation pipe must not fall below the minimum value, see [Chapter 2.3.2 'Pipes' on page 9](#).

In systems where complete corrosion protection is required (e. g. cooling systems), those parts of the previously processed pipe surface that are uncovered after pressing must subsequently be equipped with suitable corrosion protection.

## 3.3.2 Potential equalisation



### DANGER!

#### Danger due to electrical current

An electric shock can lead to burns and serious injury and even death.

Because all metallic piping systems conduct electricity, unintentional contact with a live part can lead to the whole piping system and components connected to it (e. g. radiators) becoming energised.

- Only allow electrical work to be carried out by qualified electricians.
- Always integrate the metal piping system into the potential equalisation.

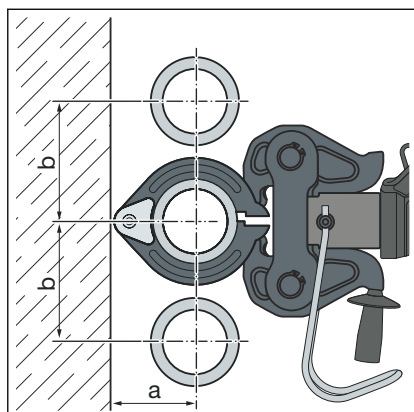


It is the fitter of the electrical system who is responsible for ensuring that the potential equalisation is tested and secured.

## 3.3.3 Space requirements and intervals

The minimum distance to welding seams and bending points must be  $3 \times D$  – however at least 100 mm.

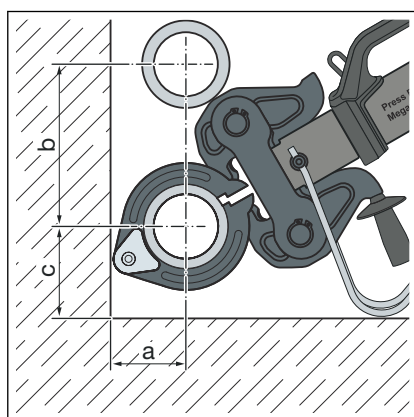
## Pressing between pipelines



### Space requirement press rings D2½–4

D	2½	3	4
a [mm]	115	120	135
b [mm]	150	170	210

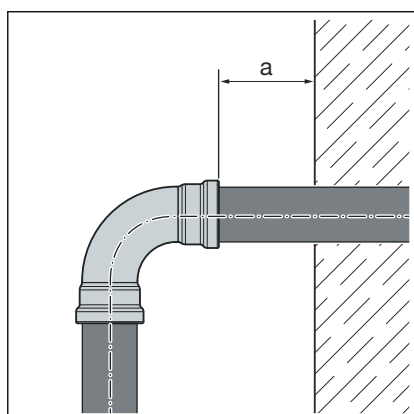
## Pressing between pipe and wall



### Space requirement press rings D2½–4

D	2½	3	4
a [mm]	115	120	135
b [mm]	150	170	210
c [mm]	100	120	140

## Wall distance



### Minimum distance with press rings D2½–4

Press machine	a <sub>min</sub> [mm]
Type 2 (PT2)	20
Type PT3-EH	
Pressgun 4E / 4B	
Pressgun 5	
Pressgun 6 Plus	

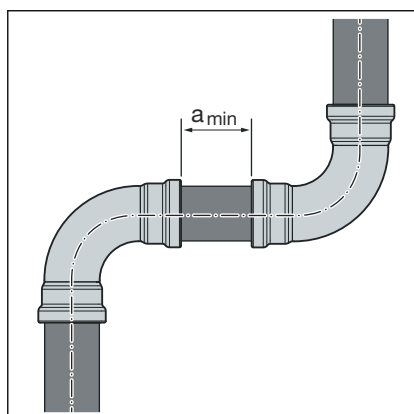
## Interval between the pressings



### NOTICE!

#### Leaking press connections due to pipes being too short!

If two press connectors are to be mounted onto a pipe at a short distance apart, the pipe must not be too short. If the pipe is not inserted up to the prescribed insertion depth in the press connector during pressing, the connection may become leaky.



### Minimum distance with press rings D2½–4

D [inch]	a <sub>min</sub> [mm]
2½	15
3	
4	

## Z dimensions

For the Z dimensions, refer to the respective product page in the online catalogue.

### 3.3.4 Required tools



#### NOTICE!

Megapress S XL press connectors may be pressed only with Megapress XL press rings. Press rings and press chains of the metal Viega press connector systems Profi-press XL, Sanpress XL, Sanpress Inox XL and Prestabo XL cannot be used.

#### Possible combinations of press machines and press jaws

Pressing force	Press machines	Press jaws	Press rings	Set
32 kN	Type 2 (PT2) PT3 EH/AH Pressgun 4E/4B Pressgun 5 Pressgun 6 Plus	DN15 to DN25 model 4299.9	DN10 to DN20 model 4296.1, with hinged adapter jaw Z1 model 2296.2	Press jaws DN15 to DN25, model 2202.31 <sup>1)</sup> Press rings D10 to DN20, model 2202.41 <sup>2)</sup>
			DN25 to DN50 model 4296.1, with hinged adapter jaw Z2 model 2296.2	Press rings DN25 to DN50, hinged adapter jaw Z2 model 2202.42
	Type 2 (PT2) PT3 EH Pressgun 4E / 4B Pressgun 5 Pressgun 6 Plus	—	DN65 to DN100 model 4296.1XL, with Pressgun Press Booster model 4296.4XL DN65 (76.1 mm) to DN100 model 4296.1XL, with Pressgun Press Booster model 4296.4XL or DN65 (73.0 mm) model 4896.1XL, with Pressgun Press Booster model 4296.4XL	Press ring DN65 and Pressgun Press Booster model 4296.2XL Press ring DN65 (76.1 mm) and Pressgun Press Booster model 4296.2XL Press rings DN80 and DN100 model 4296.5XL
24 kN	Picco Pressgun Picco Pressgun Picco 6 / 6 Plus	DN10 to DN20 model 4284.9	DN10 to DN20 model 4296.1, with hinged adapter jaw P1 model 2496.1	Picco press jaws DN10 to DN20 model 2202.21 Press rings D10 to DN20, model 2202.41 <sup>2)</sup>

<sup>1)</sup> Press jaw DN10 is not included in the set and must be ordered separately. (space saver available)

<sup>2)</sup> Hinged adapter jaw Z1 (model 2296.2) or P1 (model 2496.1) is not included in the set and must be ordered separately. (space saver available)

The following tools are required for production of a press connection:

- Pipe cutter or a fine-toothed hacksaw  
Or angle-grinder  
Or chopsaw with low cutting speed
- Deburrer or half-round file and coloured pen for marking
- Press machine with constant pressing force
- Press ring (D2½–4),
  - D2½ (73.0 mm): use model 4896.1XL
  - D2½ (76.1 mm): use model 4296.1XL
  - D3 (88.9 mm): use model 4296.1XL
  - D4 (114.3 mm): use model 4296.1XL
- Press ring (D2½–4), Press Booster with fixed hinged adapter jaw, suitable for the pipe diameter and with a suitable profile

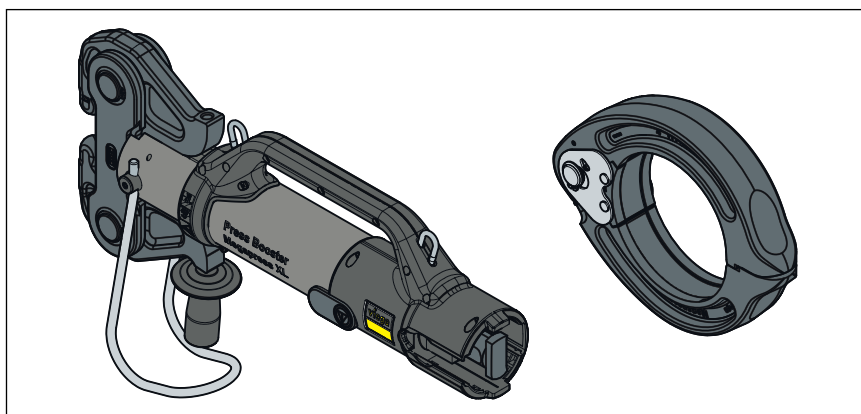


Fig. 12: Pressgun Press Booster, Megapress XL press ring



**Viega recommends the use of Viega system tools when installing the press fittings.**

The Viega system press tools have been developed and tailored specifically for the installation of Viega press connector systems.



## 3.4 Assembly

### Permitted exchange of sealing elements



#### NOTICE!

With their material-specific qualities, sealing elements in press connectors are adapted for use with the corresponding media and/or the areas of use of the piping systems and are generally only certified for them.

The exchange of a sealing element is generally permitted. The sealing element must be exchanged for a designated spare part for the intended application ↪ *Chapter 2.3.4 'Sealing elements' on page 15*. The use of other sealing elements is not permitted.

If the round sealing element in the press connector is obviously damaged, it should be exchanged for a Viega replacement round sealing element made of the same material.

### 3.4.1 Replacing the sealing element

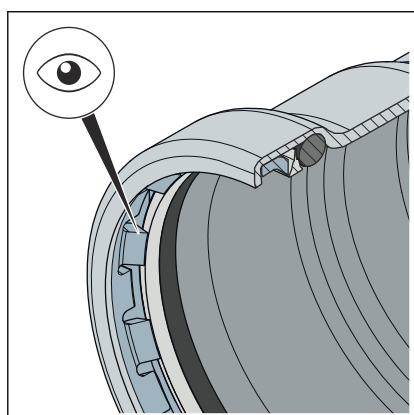


Fig. 13: Cutting ring

#### Removing the sealing element



#### CAUTION!

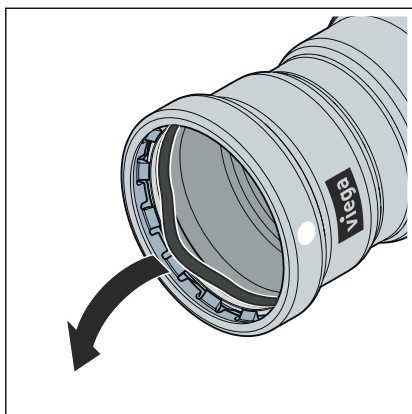
##### Risk of injury due to sharp edges

There is a sharp-edged cutting ring above the sealing element (see arrow). There is a risk of injury (cutting) when replacing the sealing element.

- Do not reach into the press connector with your bare hands.

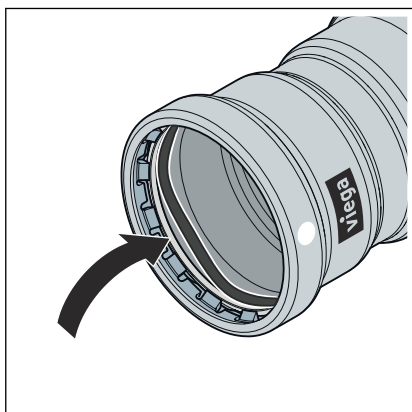


Do not use pointed or sharp-edged objects to remove the sealing element. They may damage the sealing element or the bead.



- Remove the sealing element from the bead. Proceed carefully to avoid damaging the sealing element seat.

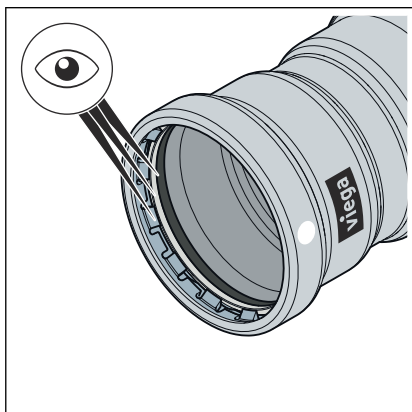
### Inserting the sealing element



- Insert a new, undamaged sealing element, model 4286XL into the bead.

Make sure that the sealing element is not damaged by the cutting ring.

- Ensure that the complete sealing element is in the bead.



- The correct sealing element is in the press connector.  
FKM = matt black
- Sealing element, separator ring and cutting ring are undamaged.
- The complete sealing element, separator ring and cutting ring are in the bead.

### 3.4.2 Cutting pipes to length



#### NOTICE!

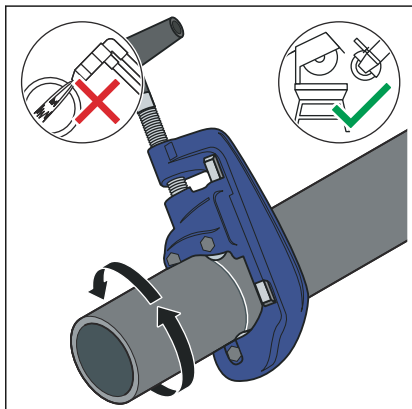
#### Leaking press connections due to damaged material!

Press connections can become leaky due to damaged pipes or sealing elements.

Observe the following instructions to avoid damage to pipes and sealing elements:

- Do not use flame cutters when cutting to length.
- Do not use grease or oils (e. g. cutting oil).

For information about tools, also see [Chapter 3.3.4 'Required tools'](#) on page 27.



- Cut the pipe at a right angle as accurately as possible using a pipe cutter, an angle grinder or a fine-toothed hacksaw to ensure a complete and even pipe insertion depth. Do not use a flame cutter.
- Avoid grooves on the pipe surface.

### 3.4.3 Deburring the pipes

The pipe ends must be thoroughly deburred internally and externally after cutting.

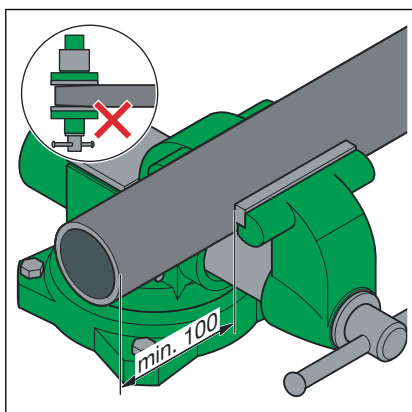
Deburring prevents the sealing element being damaged or the press connector cants when mounted. Viega recommends using a deburrer.

- D2½, 3 (model 2292.4XL)
- D 4 (half-round file)



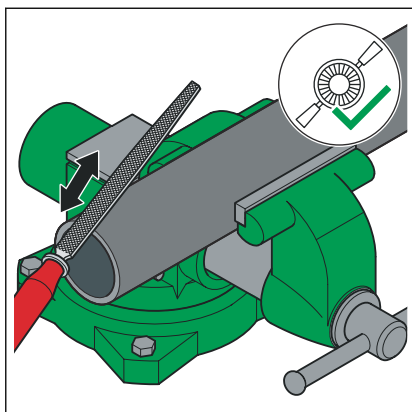
#### **NOTICE!** **Damage due to the wrong tool!**

Do not use sanding disks or similar tools when deburring. The pipes could be damaged by these.



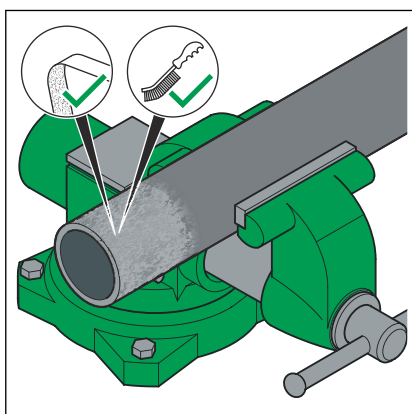
- Secure the pipe in the vice.
- When clamping, leave an interval of at least 100 mm (a) to the pipe end.

The pipe ends must not be bent or damaged.

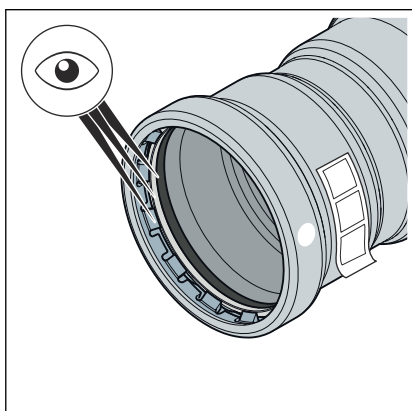


- Deburr the inside and outside of the pipe.

### 3.4.4 Pressing the connection



- With the help of a wire brush, cleaning fleece or sanding paper, remove loose dirt and rust particles from the pressing area.

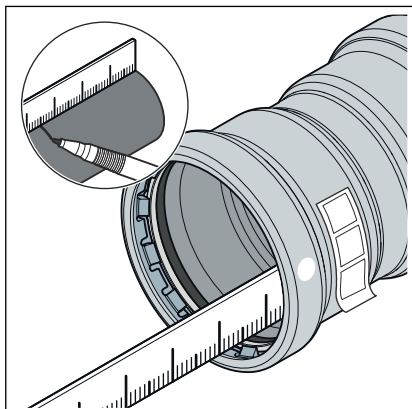


Requirements:

- The pipe end is not bent or damaged.
- The pipe is deburred.
- The correct sealing element is in the press connector.  
FKM = matt black

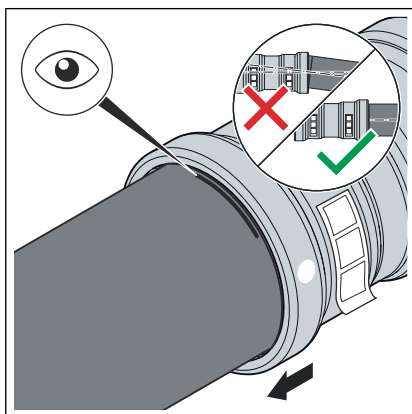
- Sealing element, separator ring and cutting ring are undamaged.
- The complete sealing element, separator ring and cutting ring are in the bead.

- Measure and mark the insertion depth.



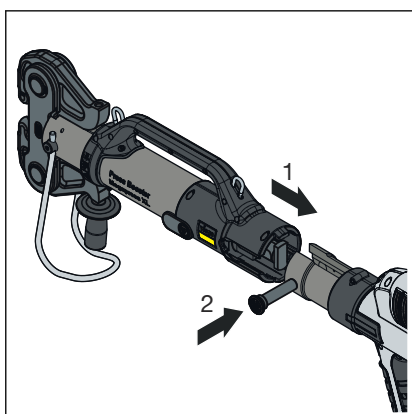
D [inch]	Insertion depth [mm]
2 ½	46
3	59
4	80

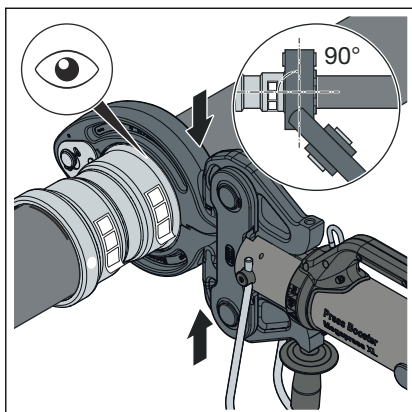
- Push the press connector up to the marked insertion depth on the pipe. Do not twist the press connector.



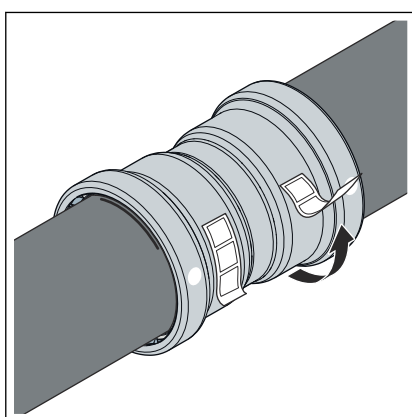
- Place the Pressgun Press Booster into the press machine and push the retaining pin in until it clicks into place.

**INFO! Observe the press tool instruction manual.**





- Place the XL press ring on the press connector. Observe the proper fit of the press ring.
- Position the hinged adapter jaw of the Pressgun Press Booster on the recesses of the press ring.
- **Carry out two pressings.**  
If necessary, carry out a reset stroke.
- Open the hinged adapter jaw and remove the press ring.



- Remove the check label.  
□ The connection is marked as having been pressed.

### 3.4.5 Flange connections

In the press connector system shown, flange connections are possible in the dimensions 2½ to 4 inches.

The assembly of flange connections may only be carried out by qualified personnel. Personnel can be qualified to assemble flange connections on the basis of applicable directives, for example; see [§ 'Regulations from section: Establishing a flange connection' on page 7.](#)

- A corresponding training section on proper flange connection assembly in vocational training (of staff/specialist personnel) with qualified completion as well as successful regular application are considered as sufficient proof.
- Other employees without the appropriate technical training (e.g. operating personnel) who are to install flange connections must be provided with technical knowledge through training measures (theoretical and practical); this must be documented.

#### washers

The advantages of using hardened washers are:

- Defined friction surface during assembly.
- Defined unevenness in calculation and thus reduction of the scattering of the tightening torque, whereby a greater hexagon screw force can be achieved mathematically.

## Flange types

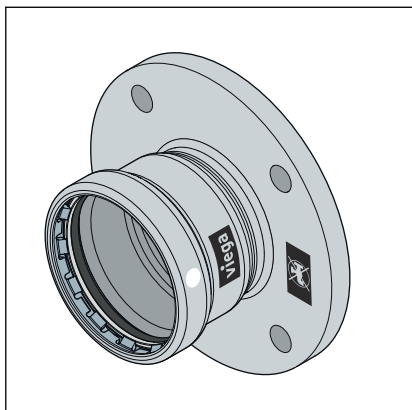


Fig. 14: Fixed flange 4259.1XL

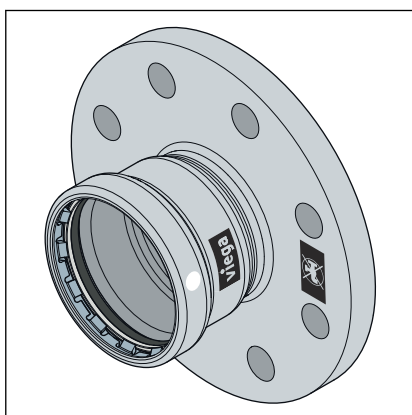
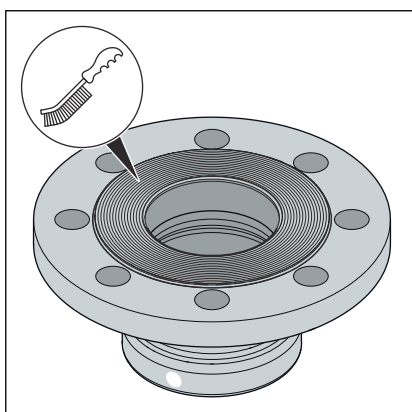


Fig. 15: Fixed flange 4259XL / 4259.6XL

## Establishing a flange connection



### Fixed flange

- Steel 1.0308 with an external galvanic zinc-nickel coating
- Megapress S XL press connection
- Model 4259.1XL PN 6: 2½, 3 and 4 inch
- Model 4259XL PN 10/16: 2½, 3 and 4 inch
- Model 4259.6XL PN 25/40: 2½, 3 and 4 inch

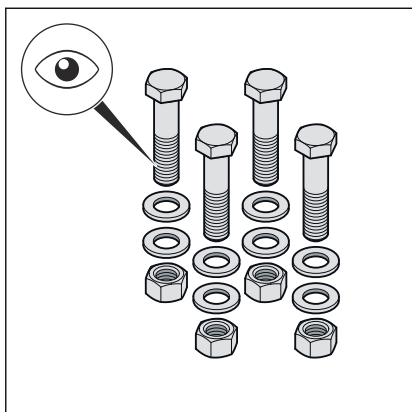



Always make the flange connection first and then the press connection.

- If necessary, remove any temporary coatings on the flange sealing surfaces without leaving any residue before assembly, using cleaning agents and a suitable wire brush.

**NOTICE!** When replacing gaskets, make sure to remove the old gasket completely from the flange sealing surface without damaging the flange sealing surface.

- Ensure that the flange sealing surfaces are clean, undamaged and even. In particular, there must not be any radial surface damage such as grooves or impact marks.

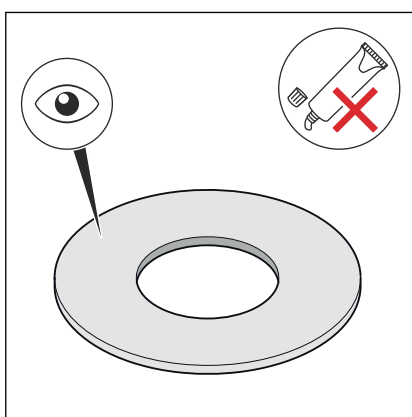


► The hexagon screws, nuts and washers must be clean and undamaged and comply with the specifications for minimum hexagon screw length and strength class, see  **'Required tightening torques' on page 39.**

► The hexagon screw and nuts must be clean and undamaged.

**INFO! Viega recommends using mounting set model 2259.7, consisting of hexagon screws, nuts and washers.**

► During disassembly, replace removed hexagon screws, nuts and washers with new ones if damaged.



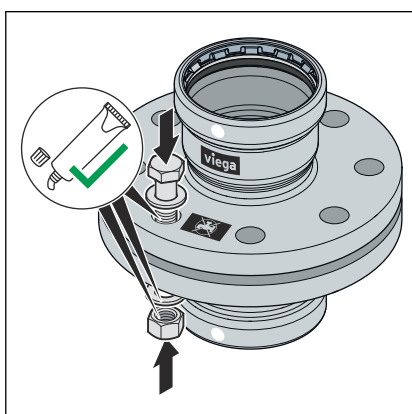
► The gasket must be clean, undamaged and dry. Do not use adhesives and assembly pastes for gaskets.

**INFO! Viega recommends using the seal model 2259.9 from AFM 34/2.**

► Do not reuse used seals.

► Do not use gaskets with kinks as they pose a safety risk.

► Ensure that gaskets are free from faults and defects and that the manufacturer's specifications are complied with.



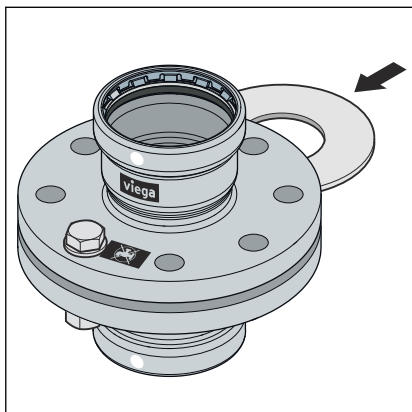
► Lubricate the following flange elements with suitable lubricant:

- Hexagon screw thread
- Washer
- Nut support

**NOTICE! Observe the manufacturer's information on the application and temperature range of the lubricant.**



## Install and centre the sealing element

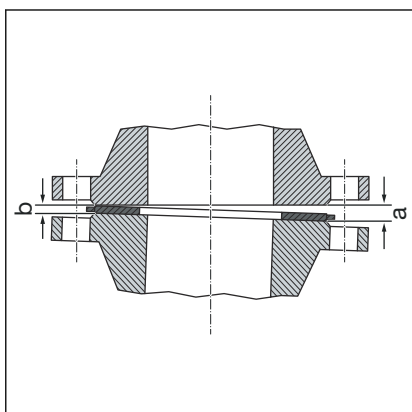


The correct assembly of flange connections requires parallel aligned flange blades without an offset centre that allow the sealing element to be inserted in the correct position without damage.

- Press the sealing surfaces far enough apart so that the seal can be inserted without force and without damage.

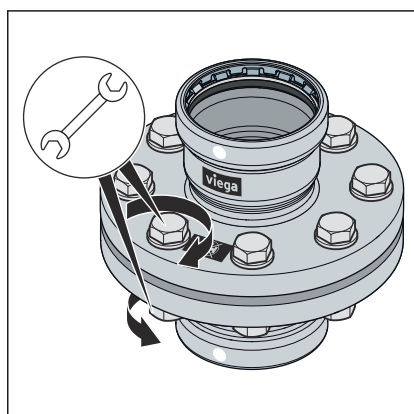
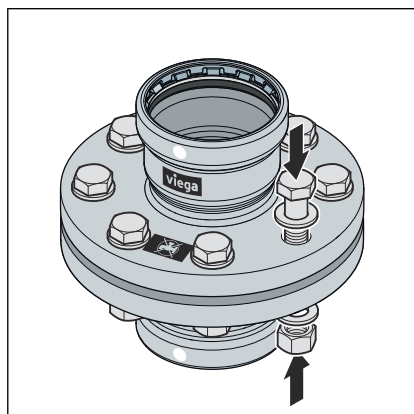
The gap (out-of-parallelism of the sealing surfaces) before tightening the hexagon screws is not critical if the permissible gap is not exceeded.

DN	Permissible gap a-b [mm]
15–25	0.4
32–50	0.6



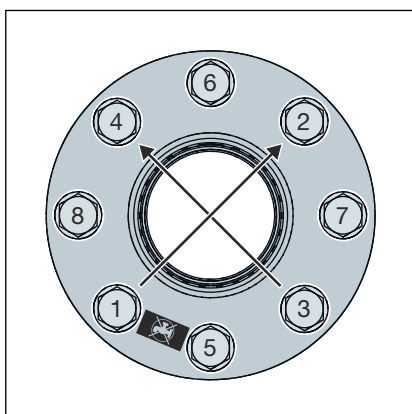
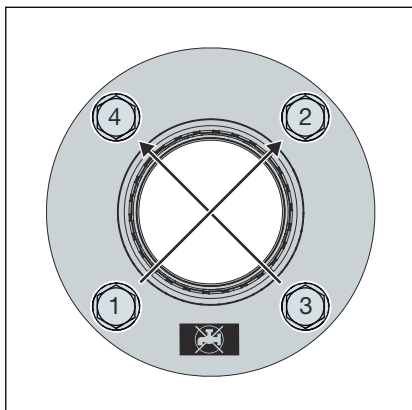
- Remove the gap from the gaping side (a).
- In case of doubt, tighten the flanges without inserting a seal by tightening the hexagon screws to achieve parallelism and a sealing surface distance of approx. 10 % of the nominal torque.
- ⏏ The gap is not permissible if the flange position cannot be achieved without great effort.

## Systematics for tightening hexagon screws



- The order in which the hexagon screws and nuts are tightened has a significant influence on the force distribution acting on the seal (surface pressure). Incorrect tightening leads to a high dispersion of the pretensioning forces and can result in the required minimum surface pressure not being reached and even in leaks.
- After tightening the nut, at least two but no more than five threads should protrude from the end of the hexagon screw.
- Prepare the hexagon screws by hand, observing the following:
  - Install the hexagon screws so that all the hexagon screw heads are on one flange side.
  - For horizontally arranged flanges, insert the hexagon screws from above.
  - Replace stiff hexagon screws with easy-running ones.
- The simultaneous use of several tightening tools is possible.

## Suit order




- Tighten all hexagon screws crosswise with 30 % of the nominal tightening torque.
- Tighten all hexagon screws as described in step 1 with 60 % of the nominal tightening torque.
- Tighten all hexagon screws as described in step 1 with 100 % of the nominal tightening torque.
- Tighten all hexagon screws again with the full nominal tightening torque. Repeat this process until the nuts can no longer be turned when the full tightening torque is applied.

## Required tightening torques

### Tightening torques for Megapress S XL flange adapters PN 6

Model	DN	Article number	Thread	Min. req. tightening torque [Nm]	Max. perm. tightening torque [Nm]	Hexagon screw length [mm]	Strength class
4259.1XL	65*	751 890 <sup>1</sup>	M12	36	82	50	8.8
	80	751 906 <sup>2</sup>	M16	145	202	60	
	100	751 913 <sup>2</sup>		165	202		

The specifications for meeting the requirements of tightness class L0,01 (TA Luft) were calculated according to the applicable standard and apply exclusively when using Viega articles; see also  'Regulations from section: Establishing a flange connection' on page 7.

\*Additional load reduced to 4x internal pressure force.

<sup>1</sup> For use with mounting set article number 651251

<sup>2</sup> For use with mounting set article number 651268

### Tightening torques for Megapress S XL flange adapters PN 10/16

Model	DN	Article number	Thread	Min. req. tightening torque [Nm]	Max. perm. tightening torque [Nm]	Hexagon screw length [mm]	Strength class
4259XL	65	751 869 <sup>1</sup>	M16	124	141	70	8.8
	80	751 876 <sup>1</sup>		138	166		
	100	751 863 <sup>1</sup>		160	163		

The specifications for meeting the requirements of tightness class L0,01 (TA Luft) were calculated according to the applicable standard and apply exclusively when using Viega articles; see also [🔗 'Regulations from section: Establishing a flange connection' on page 7.](#)

<sup>1</sup> For use with mounting set article number 494087

### Tightening torques for Megapress S XL flange adapters PN 25/40

Model	DN	Article number	Thread	Min. req. tightening torque [Nm]	Max. perm. tightening torque [Nm]	Hexagon screw length [mm]	Strength class
4259.6XL	65	770 921 <sup>1</sup>	M16	89	181	70	8.8
	80	770 938 <sup>1</sup>		89	205		
	100	770 945	M20	207	252		

The specifications for meeting the requirements of tightness class L0,01 (TA Luft) were calculated according to the applicable standard and apply exclusively when using Viega articles; see also [🔗 'Regulations from section: Establishing a flange connection' on page 7.](#)

<sup>1</sup> For use with mounting set article number 494087

### Disconnecting the flange adapter

Before starting to disassemble an existing flange connection, get approval and a work permit from the responsible company, if necessary, observing the following:

- The system section must be depressurised and completely flushed.
- Secure built-in or attached parts that are not held separately before loosening the flange connection. This also applies to fastening systems such as spring hangers and supports.
- Start loosening hexagon screws or nuts on the side facing away from the body, loosen the remaining hexagon screws slightly and only disassemble completely when you have ensured that the piping system does not present a risk. If a pipeline is under tension, there is a risk of the pipeline rupturing.
- Loosen the hexagon screws or nuts crosswise in at least two passes.
- Close open ends of strands with dummy plugs.
- Transport disassembled pipelines only in closed condition.
- When replacing gaskets, make sure to remove the old gasket completely from the flange sealing surface without damaging the flange sealing surface.

### 3.4.6 Leakage test

The installer must perform a leakage test before commissioning.

The installer must perform a leakage test (load and leakage test) before commissioning.

Carry out this test on a system that is finished but not covered yet.

Observe the applicable regulations, see ↗ *'Regulations from section: Leakage test' on page 7.*

Also carry out the leak test for non-potable water installations in accordance with the applicable guidelines, see ↗ *'Regulations from section: Leakage test' on page 7.*

Document the result.



To prevent corrosion after the leakage test has been performed with water, the system must remain full.

For the filling and top-up water, comply with the requirements specified in the applicable regulations, see ↗ *'Regulations from section: Leakage test' on page 7.*

## 3.5 Disposal

Separate the product and packaging materials (e. g. paper, metal, plastic or non-ferrous metals) and dispose of in accordance with valid national legal requirements.



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