

Installation Instruction for gebopress
M Profile Press Fittings and Pipes
Made of Stainless Steel (316L)



Edition 07/2025

Subject to technical changes

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geboPress fittings shall only be installed by a qualified specialist. Existing standards, recognised rules of technology and local regulations shall be complied with.

Recommended pressing tools see table at the end of this instruction.

Before installation, make sure that the sealing ring is inserted properly in the fitting, free of dirt and of any damage and is suitable for the planned application.

Applications:

Hot and cold drinking water, heating Systems, compressed air (oil-free)

Operating temperature and operating pressure:

Water up to max. 110°C/max. 16 bar

Oil-free compressed air up to max. 5 bar/max. 60°C

Type of tubes:

stainless steel tubes in compliance with EN10312 (series 1 or series 2)

Certifications:

DE: approval for drinking water DVGW-Reg.-No.: DW-8511DN0579

CZ: approval for water and compressed air SZU no. 202/C5/2025/B-00406-25

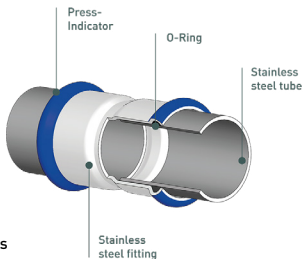
Product Storage, Transportation and Handling

1. Pipes and fittings must not be violently transported and handled to avoid product damage, especially not to be trampled or squeezed to avoid product deformation and functional degradation or loss.
2. Pipes and fittings shall not be stored in the open air, and the storage environment shall be dry. Pay attention to product protection during storage, and do not contact pipes and fittings with sand, cement mortar and other materials that will damage the sealing ring.

Construction Preparation

Before construction, it should be confirmed whether the following conditions are met:

1. The materials are complete and the construction equipment can operate normally.
2. The water, electricity and material storage site conditions at the construction site can meet the demand.
3. Installers should be trained to master the key points and precautions of construction operations.
4. The appearance and joints of pipes and fittings should be carefully inspected, and the dirt and impurities on pipes and fittings should be removed in time.



Installation Steps and Precautions

1. Cut the pipe

According to the calculated installation size, use a pipe cutter or cutting saw to cut the steel pipe rectangular 90°C (see Figure 1), and the cut must not be inclined.



Figure 1

2. Deburr

After cutting, the internal and external burrs and chips at the pipe end must be removed to avoid damage to the sealing ring and leakage when inserting into the pipe fitting body.



Figure 2

3. Check the sealing ring

Check that the sealing ring is intact and in the correct position (see Figure 2). At the same time, make sure that there is no foreign material such as sand grains on the sealing ring. If there is foreign material, it must be removed before installation.

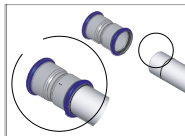


Figure 3

4. Insertion depth

Draw a line according to the insertion length (see column E in table under point 5) and ensure that it is inserted to the marked position when connecting (see Figure 3 and Figure 4).

5. Connect pipes and fittings

Insert the pipe into the fitting until the marked insertion depth position. When inserting, make sure that pipes and fittings are on the same axis. If the inserting is difficult due to the allowable dimensional tolerance of the pipe and the fitting, you can use water or soapy water to apply to the sealing ring and then insert the tube.

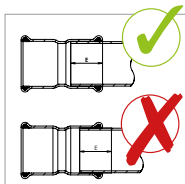


Figure 4

Note:

Minimum installation distance for fittings

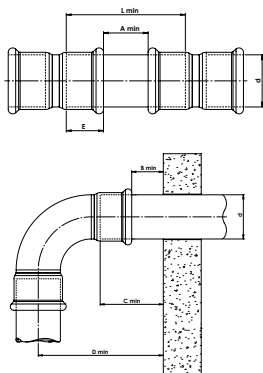
During the pressing of the connection, the fitting will deform the pipe in order to create a proper connection. Therefore a certain distance must be kept between two pipe fittings or a pipe fittings and wall entry.

Installation Steps and Precautions

Minimum installation distance for fittings

Dimension (mm)	A (mm)	L (mm)	E (mm)
15	20	62	21
18	20	62	21
22	20	64	22
28	20	68	24
35	25	79	27
42	25	89	32
54	25	99	37

Dimension (mm)	B (mm)	C (mm)	D (mm)
15	25	46	70
18	25	46	76
22	25	47	79
28	25	49	89
35	25	52	100
42	25	56	114
54	25	61	133



6. Install the pressing jaws

Appropriate tools must be used. Information and instructions from the press tool manufacturer must be observed. See table at the end of this guide for orientation of suitable pressing tools.

7. Press

Confirm that the groove of the pressing jaw is placed on the protruding part of the pipe fitting and is perpendicular to the pipeline (see Figures 5 - 6) and start the pressing operation (see manual of jaw and pressing machine producer). After the pressing cycle is completed, loosen the jaws, confirm whether the pressing is in place, and tear off the indicator film.

Note:

- 7.1** The threaded fittings should be screwed first and then pressed, so as to prevent the pressed pipe fittings from loosening due to threading, causing leakage.
- 7.2** The vertical pipeline without positioning support should be connected to the overhead pipeline after the pressing is completed on the ground, avoiding the vertical pipeline falling under the action of gravity and leakage caused by insufficient pressing.
- 7.3** After a certain number of press cycles (see manual of pressing jaw/pressing machine manufacturer) the pressing jaws/pressing machines have to be calibrated in order to provide a proper, safe and leakage-free connection

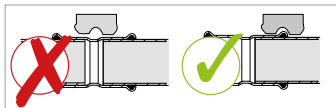


Figure 5

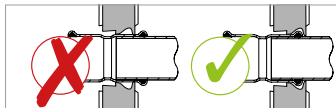


Figure 6

Installation Steps and Precautions

8. Check press condition

- 8.1** After pressing, be sure to tear off the indicator film on the pressing part. The purpose of the indicator film provided by the manufacturer is to indicate whether the pipe fittings have been pressed, and tearing off the indicator film means that these pipe fittings have been pressed.
- 8.2** Check for abnormal press deformation caused by misalignment of the pressing jaws or pressing ring with the end of the fitting. If any problem that affects the function of the pipe fitting is found, the problematic part should be removed and replaced with new pipe fittings to avoid affecting the subsequent use.

9. Pressure test

Before initial operation of the installation, a pressure test must be carried out (observe local requirements).

Summary of Installation Precautions

1. Installers are not allowed to construct without training and certification.
2. Deformed steel pipes and fittings shall not be used.
3. If there are burrs on the cut of the steel pipe, do not assemble it.
4. Do not assemble the sealing ring without checking it before intubation.
5. Steel pipes that are not drawn lines (marking the insertion position) shall not be assembled.
6. Vertical pipelines without positioning support shall not be assembled without pre-pressing.
7. Threaded fittings shall not be pressed without being screwed in advance.
8. Do not press without checking the insertion position before pressing.
9. Tear off indicator film of all press connections before pressure test.

Analysis of Common Application Problems

No.	Problems	Analysis	Suggestions
1	Unqualified pressing	Irregular construction or tool wear causes unqualified clamping, which may cause leakage.	When pressing each time, confirm whether the jaw is intact and operate in strict accordance with the construction specifications.
2	Pipeline deformation	Pipeline deformation due to improper transportation or storage.	It is recommended to follow the „Product Storage, Transportation and Handling“ requirements in this Installation Instruction.
3	Vertical pipeline falls off during pressure test	The vertical pipeline without positioning support slides down due to the action of gravity before pressing, resulting in insufficient pressing.	The vertical pipeline without positioning support should be connected to the overhead pipeline after the pressing is completed on the ground, and check whether the drawn line position meets the requirements before pressing.
4	Steel pipes slip during pressure test	1. No line is drawn on the steel pipe before inserting the pipe fitting, and the insertion length is insufficient, resulting in slippage under pressure. 2. No press leads to slippage under pressure.	According to the insertion length, draw a line on the end of the pipe, check whether the insertion is in place when pressing and tear off the indicator film after pressing.

Recommended pressing tools including pressure information

The Brand of Pressing Machine	Model	Pressing Forces	Size
NOVOPRESS	EC0202-AC0202	32KN	12-54 mm
	EC0203-AC0203		
KLAUKE	AC0203XL	32KN	12-54 mm, PN16
	AC0202XL		
	MAP219L	19KN	15-35 mm
RIDGID	UAP432CL	32KN	15-54mm, PN16
	RP380	35KN	12-54 mm, PN16
REMS	Akku-Press 22V	32KN	12-54 mm
ROTHENBERGER	Pressmaschine ROMAX 4000 CAS	32KN	12-54 mm, PN16
	Pressmaschine ROMAX 4000 AMPShare	32KN	12-54 mm, PN16

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