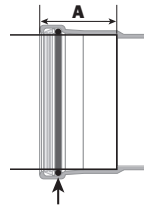


Determine Insertion Depth

IMPORTANT: See tables to determine the correct insertion depth for a given XLC product configuration before proceeding with **Installation Step 4**.

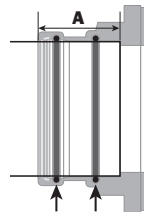
XLC Fittings: Single O-Ring Design

TUBING SIZE	— A —	
1/2"	3/4"	
3/4"	7/8"	
1"	15/16"	
1 1/4"	1"	
1 1/2"	1 1/4"	
2"	1 9/16"	
XLC Connections	Brass	Copper
2 1/2"	1 9/16"	1 11/16"
3"	1 3/4"	2"
4"	2 1/8"	2 5/16"



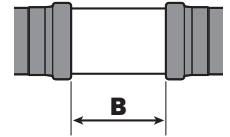
XLC Ball Valves: Double O-Ring Design

TUBING SIZE	— A —	
XLC Connections		
2 1/2"	1 7/8"	
3"	2 3/16"	
4"	2 1/2"	

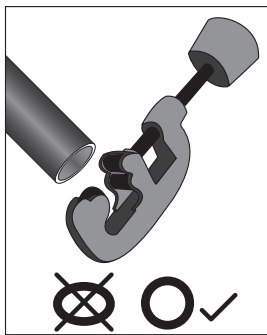


Minimum Distances

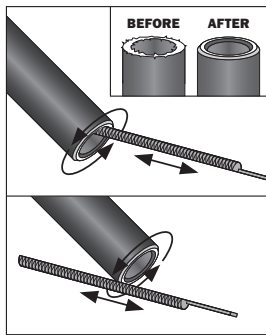
IMPORTANT: A minimum distance is required between Press connections. Failure to provide the required distance may distort the tubing, resulting in an ineffective seal.



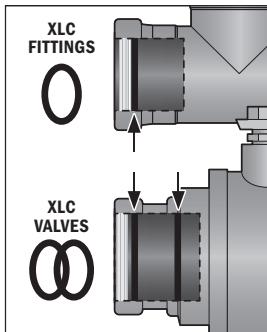
TUBING SIZE	— B —	
1/2"	1/2"	
3/4"	1/2"	
1"	1/2"	
1 1/4"	1/2"	
1 1/2"	5/8"	
2"	3/4"	
XLC Connections		
2 1/2"	3/4"	
3"	3/4"	
4"	3/4"	



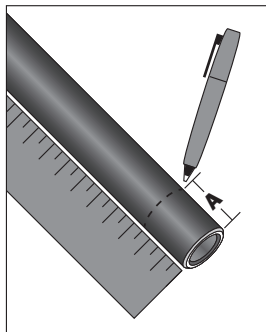
1 CUT TUBING



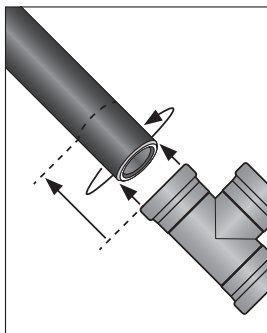
2 DEBURR & CHAMFER



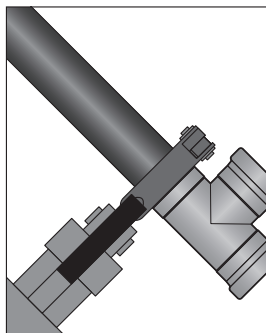
3 INSPECT



4 MEASURE



5 INSERT



6 PRESS FITTING/VALVE

Installation Steps

Compatible with popular press fit tools. This product is designed for use with Type K, L, and M hard copper tubing that complies with ASTM B88 standard. See product specifications for pressure and temperature limits.

IMPORTANT: Follow all federal/national, state and local codes when installing, testing or performing work on systems. If you have any questions or comments, please contact us.

Step 1 – Cut Tubing: Select clean, undamaged copper tube and cut to the desired length. Cut the tube end square using a tube cutter or fine-toothed saw. Ensure that the cut is straight and the tubing remains round. Do not press onto damaged, scratched, gouged, or otherwise compromised tubing. Do not crimp over etched print streams on tubing. Failure to follow these instructions may affect the performance of the joint.

Step 2 – Deburr & Chamfer: Using a half-round file or deburring tool, deburr the inner and outer diameters of the tube to remove any copper shavings or filings. A smooth transition chamfer is required to ease tube insertion past the seal.

Properly preparing both diameters of the tubing will result in a smooth fit with the press product and will mitigate flow restriction issues. Failure to properly deburr and chamfer the tubing may result in damage to the product's O-ring.

Clean the tube end of all contamination. Ensure the surface is smooth and free from scratches. DO NOT use sandpaper or emery cloth.

Step 3 – Inspect: Check the fitting to make sure that the seal is in place and is free of oil or grease. Use only original Webstone® EPDM O-rings specified for use in Pro-Connect XLC products, contact Technical Services at the number below if a replacement O-ring is required.

Step 4 – Measure: Refer to section at top of page to determine the XLC product design type and appropriate insertion depth. Measuring from the cut, mark the approximate insertion depth appropriate for the XLC product.

Step 5 – Insert: Position the XLC product on tubing and insert, ensuring it is aligned in a straight fashion, and slowly turn until the product meets the line drawn in Step 4. **If any resistance occurs further preparation of the tubing is required. Attempting to force a fit can dislodge or damage internal components.** Water may be used as a lubricant if desired, HOWEVER NO OTHER LUBRICANTS MAY BE USED.

Step 6 – Press Fitting/Valve: Verify that the tubing is fully inserted to the mark. When installing a flange, bolt the flange end in place before pressing the fitting to the tubing.

1/2–2" Sizes: Place the jaw of the tool at a right angle to the product and center the jaw on the ring in the connection.

2½–4" Sizes: Place the proper size XLC ring on the product end. The XLC ring must be properly aligned on the fitting.

Complete the connection in accordance with the tool and jaw manufacturer's instructions.

Leak Testing: Unpressed connections are located by pressurizing the system with air or water. When testing with compressed air the proper maximum pressure is 15 psi. When testing with water the successful maximum is 50 psi using potable water. Following a successful leak test, the system may be pressure tested up to 250 max psi for valves (300 psi max for fittings) if required by local code or product specifications. Leak testing with air can be dangerous at high pressures. System testing should be completed in accordance with requirements or codes of any federal/state/local governing body having jurisdiction over the installation. Pressure testing should not exceed the maximum pressure rating as noted on the product.