



# **MrPEX<sup>®</sup> Manual Press Tool #8230895**

**Operation and Adjustment Manual**  
(February 2009)

## **Index**

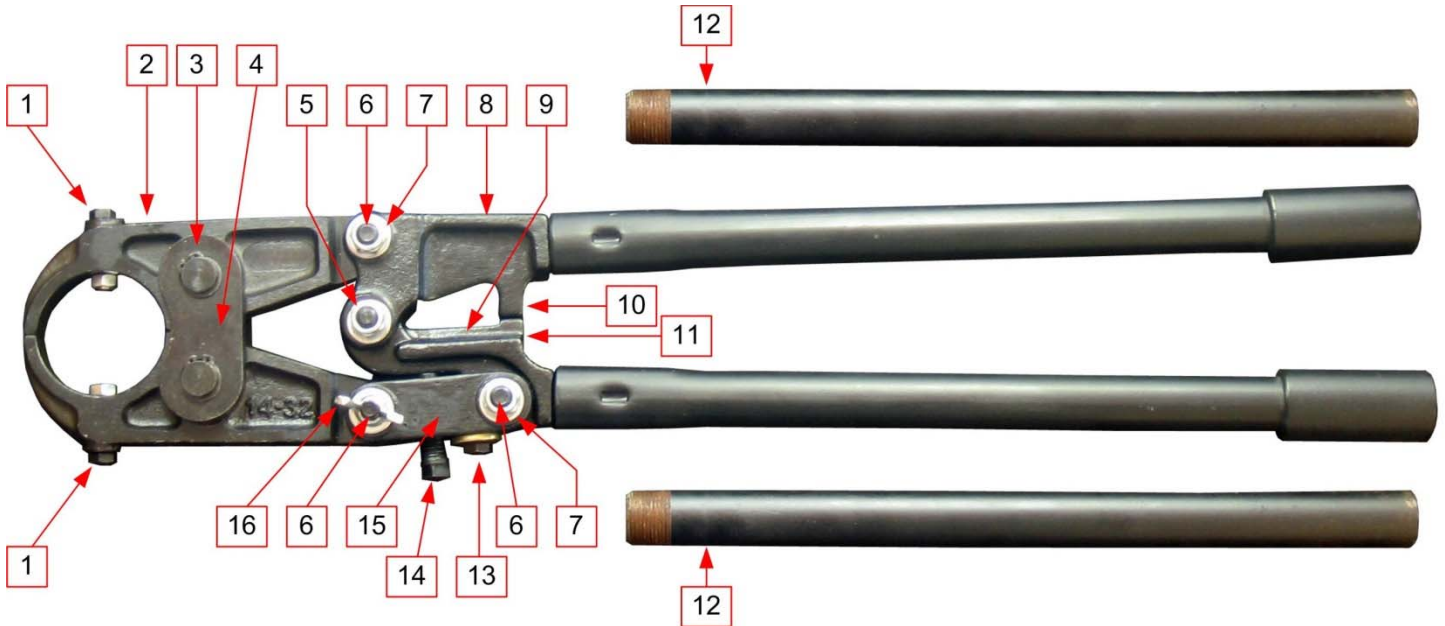
|  |            |
|--|------------|
| <b>Section 1. Tool overview.....</b>                                     | <b>P-3</b> |
| <b>Section 2. Inserts.....</b>   | <b>P-3</b> |
| <b>Section 3. Preparation before use.....</b>                            | <b>P-3</b> |
| <b>Step 1. Choose correct inserts.....</b>                               | <b>P-3</b> |
| <b>Step 2. Mount appropriate insert in tool.....</b>                     | <b>P-4</b> |
| <b>Step 3. Press tool adjustment.....</b>                                | <b>P-5</b> |
| <b>Section 4. Cautions and parameters for press tool adjustment.....</b> | <b>P-6</b> |
| <b>Section 5. Assembly of pipe and press fitting.....</b>                | <b>P-7</b> |
| <b>Section 6. Making the press .....</b>                                 | <b>P-8</b> |
| <b>Section 7. Press tool wear and final rejection.....</b>               | <b>P-9</b> |
| <b>Section 8. Care and maintenance.....</b>                              | <b>P-9</b> |

## **Mr PEX® Manual Press tool #8230895**

Mr PEX® Systems provides a manual press tool kit #8230895. This kit includes; tool, handle extensions (for easier completion of  $\frac{3}{4}$ " and 1"), and  $\frac{1}{2}$ ",  $\frac{3}{4}$ ", and 1" inserts. These inserts #8230896 (1/2"), #8230897 (5/8"), #8230898 (3/4"), and #8230899 (1") are also sold separately. This tool handles Mr PEX® Press Fitting sizes  $\frac{1}{2}$ ",  $\frac{5}{8}$ ",  $\frac{3}{4}$ ", and 1". This manual will get you familiar with the tool, and show you how to use and adjust it.

## Section 1. Tool overview

This picture identifies each part/component of the #895 press tool.



Parts:

1: Insert mounting screw (M6×25), 2: Press tool body, 3: Jaw hinge, 4: Connection block, 5: Hinge pin #1 (M8), 6: Hinge pin #2 (M8), 7: Nut (M8), 8: Right handle block, 9: Left handle block, 10: Contact point on right handle, 11: Contact point on left handle, 12: Handle extensions, 13: Lock screw (M6×12), 14: Adjusting screw, 15: Connection arm, 16: Wing Nut (M8).

## Section 2. Inserts

The tool kit #895 comes with  $\frac{1}{2}$ ",  $\frac{3}{4}$ ", and 1" insert. Replacement inserts are sold separately. #896 ( $\frac{1}{2}$ " ), #897 ( $\frac{5}{8}$ " ), #898 ( $\frac{3}{4}$ " ), and #899 (1").



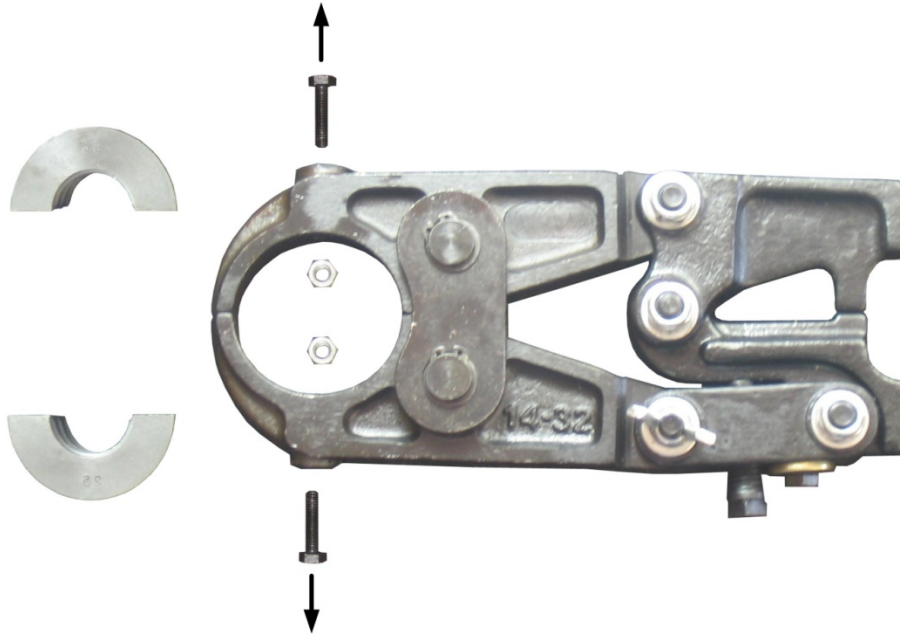
## Section 3. Preparation before use

### Step 1. Choose correct inserts

Select appropriate insert; #896 ( $\frac{1}{2}$ " ), #897 ( $\frac{5}{8}$ " ), #898 ( $\frac{3}{4}$ " ), or #899 (1").

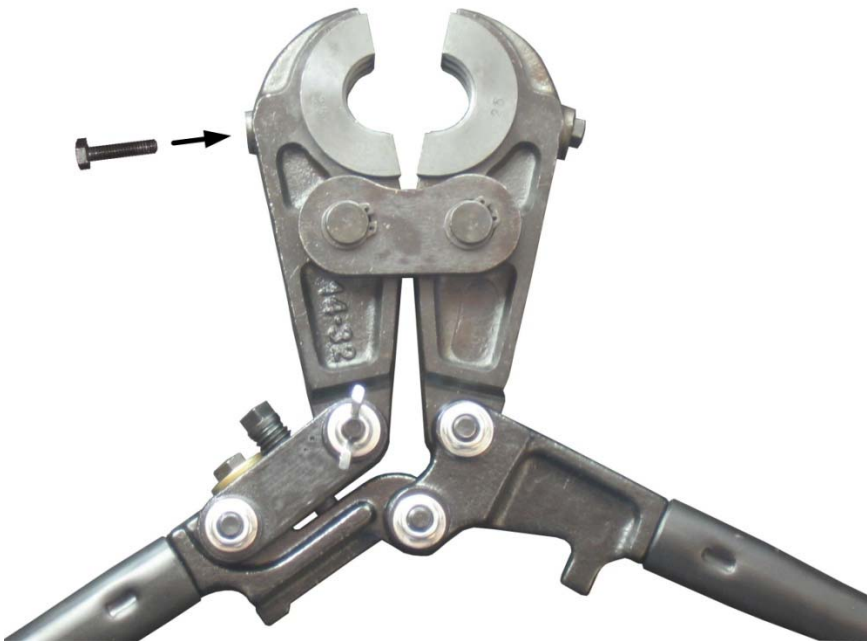
**Step2. Mount appropriate insert in tool**

A) Remove the two "Insert mounting screws" (Part No.1,M6×25).



B) Position the two inserts in the press tool head, tighten with "Insert mounting screws" (Part No.1,M6×25).

**Note: Do not over-tighten.**



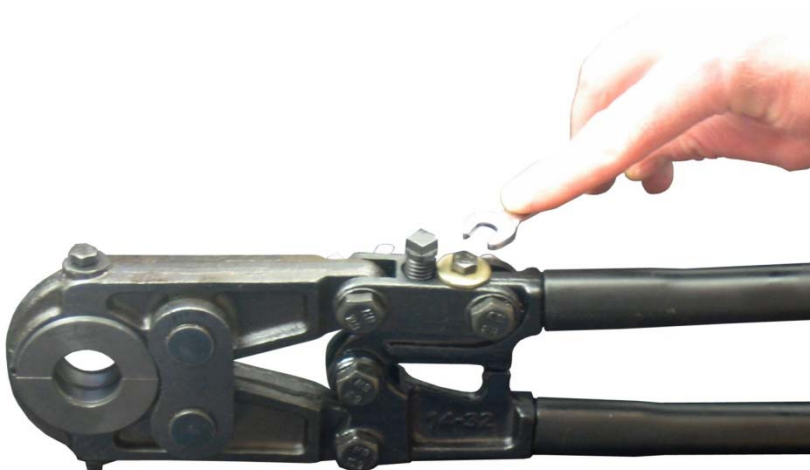
### C) Press-Force evaluation

Close the press tool without a fitting or handle extensions, the appropriate Press-Force to fully close the press tool with inserts should be about 33 pd f (pound force). If not, the press tool needs to be adjusted before use, please refer to "Step 3" for adjustment.

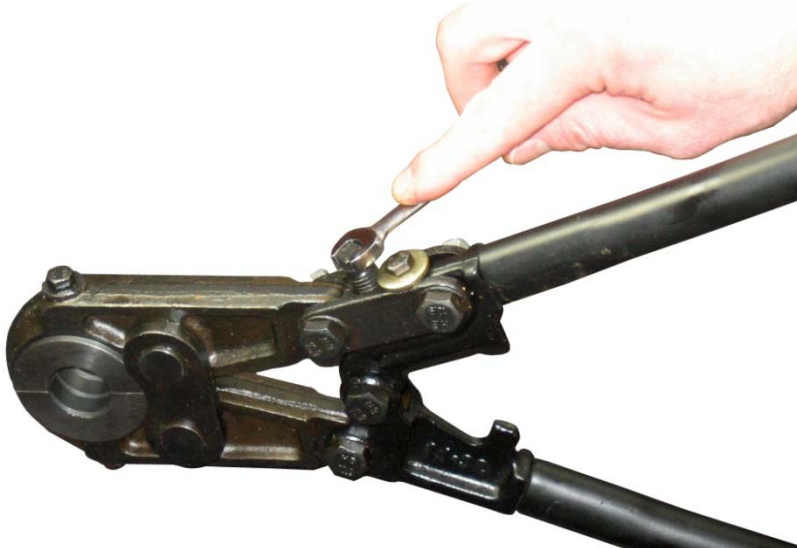


### Step 3. Press tool Adjustment

A) Open the press tool and loosen the "locking screw"(Part No. 13) counter-clockwise about 3 turns.

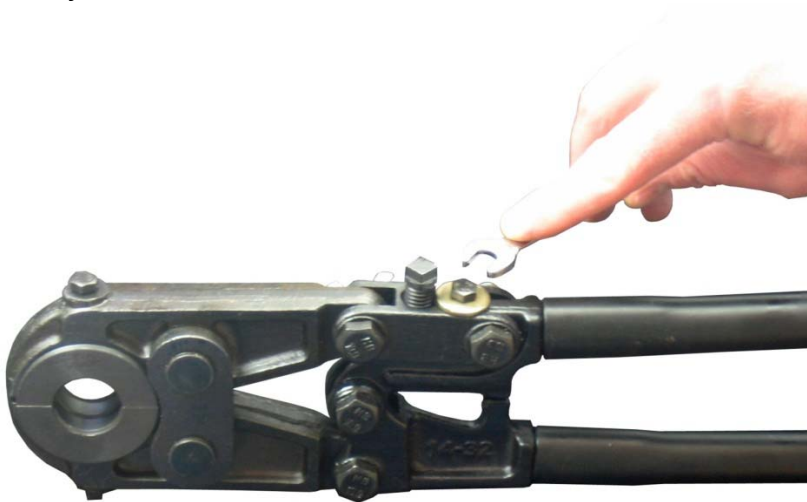


B) To adjust Press-Force, turn the "adjusting screw" (Part No.14.) clockwise to increase the press-force, and counter-clockwise to decrease the press-force. Start with about 1/4 turn, and repeat this process until the Press-Force is about 33 pd f (pound force).



**Note: The adjustment screw (Part No. 14) does not need be touched again once the Press-Force reaches 33 pd f (pound force).**

C) Close the pressing tool and lock the setting by tightening the locking screw( Part No. 13). The adjustment is now finished.



D) If handle-extensions (Part No.12) are needed, they should not be mounted until after adjustment is completed. Handle extensions are not necessary for fittings up to 5/8". Handle extensions are only needed for 3/4" and 1" fittings.

#### **Section 4. Cautions and parameters for press tool adjustment**

(1) Adjustment should be made when:

- New press tool is used.
- Press tool jaws do not fully close.
- Changing inserts.
- User finds that Press-Force seems to have changed.
- Closed press tool can be opened freely without using any force.
- Fittings leaks after pressing.

(2) For brand new tool, re-check Press-Force again after about 60 presses and adjust as necessary.

(3) After adjustment, refer to table below for required force to complete press fittings for different sizes.

1/2" = 44 pd f (pound force).

5/8" = 70 pd f (pound force).

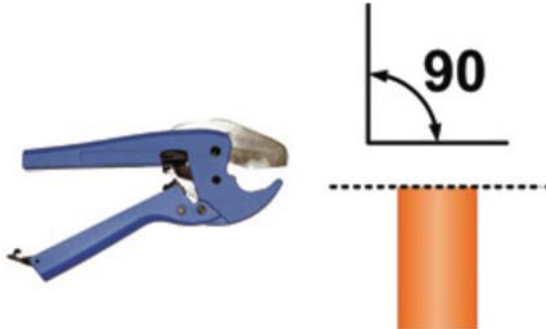
3/4" = 88 pd f (pound force).

1" = 99 pd f (pound force).

**Note: The forces listed above are for pressing fittings 1/2" and 5/8" without handle extensions, and for pressing fittings 3/4" and 1" with handle extensions.**

## Section 5. Assembly of pipe and press fitting

A) Start by making a square cut at the end of the tube using a suitable tubing cutter.



B) Ream the tubing using the appropriate reaming tool. Insert reamer into the pipe and turn it until the inside edge of the pipe is chamfered.

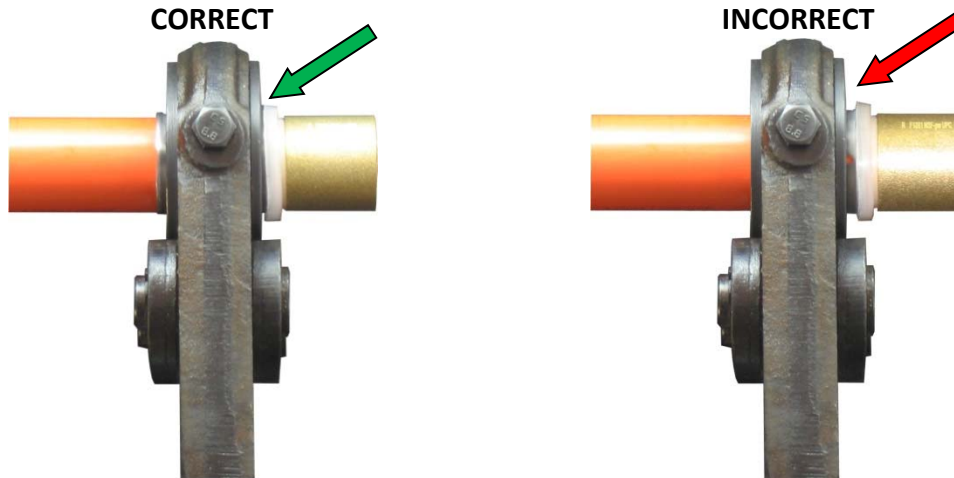


C) Slide the press fitting onto the pipe until you can see the tubing in the witness hole at the end of the sleeve.



## Section 6. Making the press

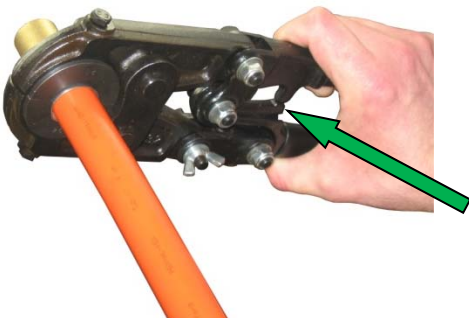
A) Position the tool jaw on the press sleeve directly up against the plastic ring/shoulder.



B) Complete the press by closing the press tool completely.



C) The touching points (Part No. 10 and 11) must be in contact.



## Section 7. Press tool wear and final rejection

Over time with heavy use, the press tool components/parts will wear, affecting the Press-Force. If the tool cannot be adjusted to reach the required Press-Force of about 33 pd f (pound force), or the press jaws do not completely close anymore, the press tool should be discarded.

This press tool has successfully gone through 5000 test cycles. During this test, all necessary adjustments were made on the press tool, but without replacing any of the press tool parts/components.

## Section 8. Care and maintenance

A) When the tool is not in use, it should be stored in either of the following ways:

- With inserts mounted; leave tool open. Remove the handle extensions and protect the threads.
- With inserts removed; close the tool. Remove the handle extensions and protect the threads.

B) The press tool should be maintained periodically by cleaning and adding lubrication oil to pins or screws at the following specified locations at least once every month.



C) Keep inserts clean.

D) Make sure the threads on handle extensions are kept clean and free from damage. An anti-corrosion agent (such as WD40) should be sprayed onto the threads periodically.

E) Adjustment screws and pins should be periodically taken off, cleaned and lubricated.

Should you have any questions regarding our press tools, please feel free to direct any questions to us via e-mail at [info@mrpexsystems.com](mailto:info@mrpexsystems.com) or call us at 1-800-716-3406.