



PRESS FITTINGS M-profile 12-108



Product information



Accepterad
monteringsanvisning
2021:1

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Information on Altech press fittings, M profile

Altech press fittings are used for drinking water, heating and gas installations. Available in the following materials: copper, chrome-plated copper, galvanized steel and acid-proof stainless steel.

Copper/copper alloys:

For drinking water and heating and for oil-free compressed air with O-ring, standard, EPDM (black). Press fittings for gas have an O-ring, HNBR (yellow).

Chrome plated copper:

Perfect for visible piping in bathrooms, for example, with all the properties of copper. With O-ring, standard, EPDM (black).

Galvanized steel:

This material is suitable for heating systems and oilfree compressed air systems with O-rings, standard, EPDM (black).

Acid-proof stainless AISI 316/SIS 2348:

Outstanding corrosion resistance properties. This material is highly suitable for drinking water installations and in industrial applications.



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Manufacturer's declaration:

This product has been manufactured in conformance with the type approval with the decision for production control and the documents on which the type approval was based.

Altech press fittings
Type approval No.: 1533/1534/1535

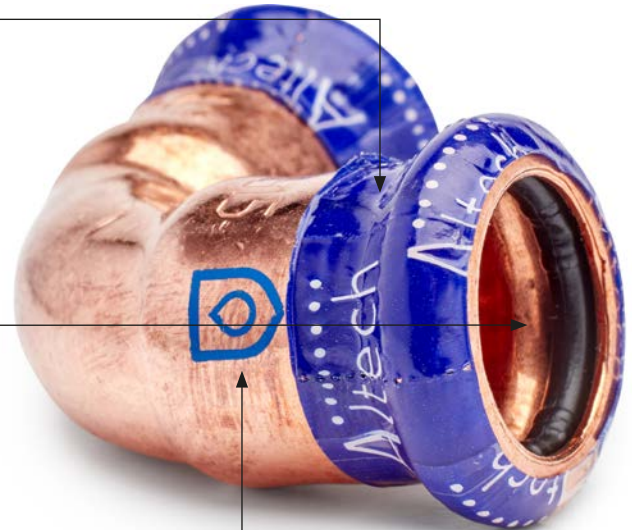


Pressing indicator

The pressing indicator ensures that it can be easily seen if a fitting has been pressed.

Leak indicator

The O-ring is thinner at 3 points; these are deformations that indicate leaks when the fitting has not been pressed. On pressure testing, at a pressure of less than 3 bar the leak indicator shows if a fitting is not pressed.



Symbols for leak indicator.



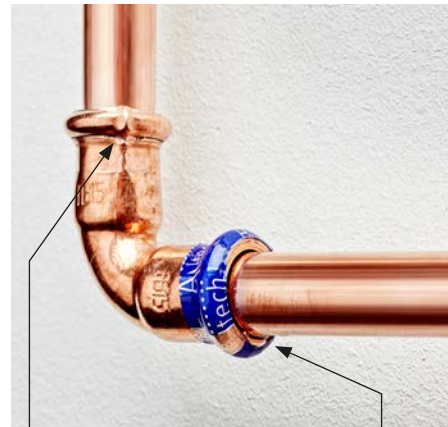
Symbol for leak indicator, galvanized steel.



Symbol for leak indicator, copper and stainless steel.



Pressing



Pressed

Unpressed



Altech M-profile press fittings must be pressed using M-profile press jaws or collars. Follow the recommendation from the manufacturer of the pressing tool regarding service and calibration. A service or calibration certificate must be available for inspection on request. Note that the specification for the press tool differs between the different manufacturers. The machine must have a minimum pressing force of 19 kN for dimensions of 12–28 mm for copper and 12–22 mm for stainless steel and galvanized steel. Above these dimensions and up to dimension 54 mm, the pressing force must be at least 32 kN. For dimensions 76,1–108 mm a pressing force of 45 kN is usually required. Support sleeves shall not be used on hard or semi-hard copper pipe fabricated in accordance with EN 1057. Support sleeves must be used on annealed (soft) and thin-walled copper pipe fabricated in accordance with EN 1057.

Press fittings, copper

- Wide range of press fittings in dimensions of 12–108 mm.
- The press fitting O-ring is equipped with a leak and pressing indicator, see page 4.
- Kiwa type approval No.: 1535.

Dimensions	12, 15, 18, 22, 28, 35, 42, 54, 76.1, 88.9, 108	Press profile	12–35 mm: M jaw 42–54 mm: press collar recommended 76.1–108 mm: press collar
Material	Copper/copper alloys	Max. temperature, continuous/short-term	Drinking water: 95/110 °C Heating water: 110/110 °C Compressed air: 30/60 °C Refrigerant: -20/-30 °C
O-ring	EPDM (black)	Max. pressure, continuous/short-term	12–54 mm Drinking water/compressed air/refrigerant: 10/16 bar Heating water: 6/16 bar 76.1–108 mm Drinking water/compressed air/refrigerant: 10/10 bar Heating water: 6/10 bar



90° bend 1 collar	
Item No.	Dimension
1189484	12
1189485	15
1189486	18
1189487	22
1189488	28
1189489	35
1189490	42
1189491	54
1189492	76,1
1189493	88,9
1189494	108



S-bend 1 collar	
Item No.	Dimension
1189512	15
1189513	22



90° bend 2 collar	
Item No.	Dimension
1189495	12
1189496	15
1189497	18
1189498	22
1189499	28
1189500	35
1189501	42
1189502	54
1189503	76,1
1189504	88,9
1189505	108



Straight slip coupling	
Item No.	Dimension
1182953	12
1182877	15
1182878	18
1182879	22
1182880	28
1182881	35
1182882	42
1182883	54
1182884	76,1
1182885	88,9



45° bend 1 collar	
Item No.	Dimension
1189462	12
1189463	15
1189464	18
1189465	22
1189466	28
1189467	35
1189468	42
1189469	54
1189470	76,1
1189471	88,9
1189472	108



Reducer 1 collar	
Item No.	Dimension
1752676	15 x 12
1752678	18 x 12
1752679	18 x 15
1752680	22 x 15
1752681	22 x 18
1752682	28 x 15
1752683	28 x 18
1752684	28 x 22
1752685	35 x 22
1752686	35 x 28
1752687	42 x 22
1752688	42 x 28
1752689	42 x 35
1752690	54 x 28
1752691	54 x 35
1752692	54 x 42
1752693	76,1 x 54
1752694	88,9 x 54
1752695	88,9 x 76,1
1752696	108 x 76,1
1752697	108 x 88,9



45° bend 2 collar	
Item No.	Dimension
1189473	12
1189474	15
1189475	18
1189476	22
1189477	28
1189478	35
1189479	42
1189480	54
1189481	76,1
1189482	88,9
1189483	108



Reducer 2 collar	
Item No.	Dimension
1752698	15 x 12
1752677	16 x 15
1752699	22 x 15
1752700	28 x 15
1752701	28 x 22
1752702	35 x 28
1752703	42 x 35
1752704	54 x 42



Double collar	
Item No.	Dimension
1182866	12
1182867	15
1182868	18
1182869	22
1182870	28
1182871	35
1182872	42
1182873	54
1182874	76,1
1182875	88,9
1182876	108



End cap	
Item No.	Dimension
1757786	12
1757787	15
1757788	18
1757789	22
1757790	28
1757791	35
1757792	42
1757794	54
1757793	76,1
1757795	88,9



Tee	
Item No.	Dimension
1185603	12
1185604	15
1185605	18
1185606	22
1185607	28
1185608	35
1185609	42
1185610	54
1185611	76,1
1185612	88,9
1185613	108



Reducing tee	
Item No.	Dimension
1185614	12 x 15 x 12
1185615	15 x 12 x 12
1185616	15 x 12 x 15
1185617	15 x 15 x 12
1185618	15 x 22 x 15
1185619	18 x 12 x 18
1185620	18 x 15 x 15
1185621	18 x 15 x 18
1185622	18 x 18 x 15
1185623	22 x 12 x 22
1185624	22 x 15 x 15
1185626	22 x 15 x 18
1185625	22 x 15 x 22
1185627	22 x 18 x 15
1185628	22 x 18 x 18
1185629	22 x 18 x 22
1185630	22 x 22 x 15
1185680	22 x 22 x 18
1185631	22 x 28 x 22
1185632	28 x 15 x 22
1185633	28 x 15 x 28
1185635	28 x 18 x 28
1185636	28 x 22 x 22
1185637	28 x 22 x 28
1185638	28 x 28 x 15
1185639	28 x 28 x 22
1185640	35 x 15 x 35
1185642	35 x 22 x 28
1185641	35 x 22 x 35
1185643	35 x 28 x 28
1185644	35 x 28 x 35
1185645	42 x 15 x 42
1185646	42 x 22 x 42
1185647	42 x 28 x 42
1185648	42 x 35 x 42
1185649	54 x 22 x 54
1185650	58 x 28 x 54
1185651	54 x 35 x 54
1185652	54 x 42 x 54
1185653	76,1 x 54 x 76,1
1185654	88,9 x 54 x 88,9
1185655	88,9 x 76,1 x 88,9



Tee with female thread branch

Item No.	Dimension
1185656	12 x G15 x 12
1185657	15 x G15 x 15
1185658	22 x G15 x 22
1185659	22 x G20 x 22
1185660	28 x G15 x 28
1185661	28 x G20 x 28
1185662	35 x G15 x 35
1185663	42 x G15 x 42
1185664	54 x G15 x 54



Adapter nipple male thread

Item No.	Dimension
1770234	R15 x 12
1770235	R15 x 15
1770237	R15 x 22
1770238	R20 x 18
1770240	R20 x 22
1770241	R25 x 28
1770242	R32 x 35
1770243	R40 x 42
1771118	R50 x 54



Adapter collar male thread

Item No.	Dimension
1855373	12 x R10
1855374	12 x R15
1855375	15 x R10
1855376	15 x R15
1855377	15 x R20
1855379	18 x R15
1855380	18 x R20
1855381	22 x R15
1855382	22 x R20
1855383	22 x R25
1855384	28 x R20
1855388	28 x R25
1855389	28 x R32
1855391	35 x R25
1855392	35 x R32
1855393	42 x R32
1855401	42 x R40
1855402	54 x R50
1855403	76,1 x R65



Adapter nipple female thread

Item No.	Dimension
1770420	12 x G15
1770421	15 x G15
1855358	18 x G15
1770423	18 x G20
1770422	22 x G15
1770424	22 x G20
1855362	28 x G20
1770425	28 x G25
1770426	35 x G32
1770427	42 x G40
1770428	54 x G50



Union male thread

Item No.	Dimension
1855328	15 x R15
1855330	22 x R15
1855331	22 x R20
1855332	28 x R25
1855333	35 x R32
1855334	42 x R40
1855335	54 x R50



Adapter collar female thread

Item No.	Dimension
1855338	12 x G10
1855340	12 x G15
1855339	15 x G10
1855341	15 x G15
1855343	15 x G20
1855344	18 x G20
1855342	22 x G15
1855346	22 x G20
1855348	22 x G25
1855347	28 x G20
1855349	28 x G25
1855351	28 x G32
1855350	35 x G25
1855353	35 x G32
1855354	42 x G32
1855355	42 x G40
1855356	54 x G50



Union female thread

Item No.	Dimension
1855322	22 x G20
1855327	22 x G25
1855324	28 x G25
1855326	35 x G32
1855323	42 x G40
1855325	54 x G50




Flat face coupling with union nut

Item No.	Dimension
1855321	28 x G32



Wall plate elbow female thread

Item No.	Dimension
1855336	15 x G15




90° elbow male thread

Item No.	Dimension
1189506	12 x R15
1189507	15 x R15
1189508	22 x R20
1189509	28 x R25
1189510	35 x R32
1189511	54 x R50



90° elbow female thread

Item No.	Dimension
1189514	15 x G15
1189515	22 x G20
1189516	28 x G25
1189517	35 x G32
1189518	42 x G40
1189519	54 x G50






Press flange, flange according to EN 1092-1

Item No.	Dimension
1753431	76,1 x DN65
1753433	76,1 x DN80
1753436	88,9 x DN80
1753432	108 x DN100



Altech press O-ring

Viton (green)	EPDM (black)	Viton (red)
		
For solar heating systems, steam and hot water 0–160 °C (peaks at max. 200 °C).	For drinking water, heating and oil-free compressed air (less than 5 mg/m).	For compressed air with residual oil (more than 5 mg/m) and specific petroleum fluids.

See page 25 for further information.

Press fittings, chrome plated copper

- Wide range of press fittings in dimensions of 12–18 mm.
- The press fitting O-ring is equipped with a leak and pressing indicator, see page 4.
- Kiwa type approval No.: 1535.

Dimensions	12, 15, 18	Press profile	12–18 mm M jaw
Material	Chrome plated copper	Max. temperature, continuous/short-term	Drinking water: 95/110 °C Heating water: 110/110 °C Compressed air: 30/60 °C Refrigerant: -20/-30 °C
O-ring	EPDM (black)	Max. pressure, continuous/short-term	Drinking water/compressed air/refrigerant: 10/16 bar Heating water: 6/16 bar







Chrome plated copper pipe in press dimensions in accordance with EN 1057

Item No.	Dimension	Length
8564684	10 x 0,8	2 m
8564680	12 x 1,0	2 m
8564681	15 x 1,0	2 m
8564686	18 x 1,0	2 m
8564688	22 x 1,0	2 m
8564685	10 x 0,8	2,75 m
8564682	12 x 1,0	2,75 m
8564683	15 x 1,0	2,75 m
8564687	18 x 1,0	2,75 m
8564689	22 x 1,0	2,75 m


90° bend 1 collar

Item No.	Dimension	
1189458	12	
1189459	15	


90° bend 2 collar

Item No.	Dimension	
1189461	12	
1189460	15	


45° bend 1 collar

Item No.	Dimension	
1189454	12	
1189455	15	


45° bend 2 collar

Item No.	Dimension	
1189456	12	
1189457	15	


S-bend 1 collar

Item No.	Dimension	
1753434	15	


Straight slip coupling

Item No.	Dimension	
1182865	15	


Reducer 1 collar

Item No.	Dimension	
1752673	15 x 12	


Reducer 2 collar

Item No.	Dimension	
1752674	15 x 12	


Double collar

Item No.	Dimension	
1182864	12	
1182863	15	

Tee


Item No.	Dimension	
1185598	12	
1185599	15	

Reducing tee

Item No.	Dimension	
1185601	15 x 12 x 15	
1185602	15 x 12 x 12	
1185600	15 x 15 x 12	


Adapter collar male thread

Item No.	Dimension
1855317	12 x R10
1855417	12 x R15
1855418	15 x R15




Adapter collar female thread

Item No.	Dimension
1855313	12 x G15
1855314	15 x G15




Adapter nipple male thread

Item No.	Dimension
1769692	12 x R15
1855319	15 x R10
1769693	15 x R15
1769695	18 x R15






Flat face coupling union nut

Item No.	Dimension
1855315	15 x G20



Altech press O-ring

Viton (green)	EPDM (black)	Viton (red)
		
For solar heating systems, steam and hot water 0-160 °C (peaks at max. 200 °C).	For drinking water, heating and oil-free compressed air (less than 5 mg/m).	For compressed air with residual oil (more than 5 mg/m) and specific petroleum fluids.

See page 25 for further information.


Press fittings, gas, copper

- Wide range of press fittings in dimensions of 12–54 mm, for gas installations.
- Equipped with pressing indicator, see page 4.
- Manufactured in compliance with DVGW VP 614.


Dimensions	15, 18, 22, 28, 35, 42, 54	Press profile	15–35 mm: M jaw 42–54 mm: press collar recommended
Material	Copper/copper alloys	Operating temperature	-20 °C – +70 °C
O-ring	HNBR (yellow)	Max. operating pressure	In buildings: 1 bar Outside of buildings: 5 bar




90° bend 1 collar

Item No.	Dimension	
1189530	15	
1189531	22	
1189532	28	
1189533	35	


90° bend 2 collar

Item No.	Dimension	
1189534	15	
1189535	22	
1189536	28	
1189537	35	
1189538	42	
1189539	54	


45° bend 1 collar

Item No.	Dimension	
1189520	15	
1189521	22	
1189522	28	
1189523	35	
1189524	42	
1189525	54	


45° bend 2 collar

Item No.	Dimension	
1189526	15	
1189527	22	
1189528	28	
1189529	35	


Adapter collar male thread

Item No.	Dimension	
1855409	15 x R15	
1855410	22 x R20	
1855411	28 x R25	
1855412	35 x R32	
1855407	42 x R40	
1855413	54 x R50	


Adapter collar female thread

Item No.	Dimension	
1855404	15 x G15	
1855405	22 x G20	
1855406	28 x G25	
1855414	35 x G32	
1855415	42 x G40	
1855408	54 x G50	


Reducer 1 collar

Item No.	Dimension	
1752705	22 x 15	
1752709	28 x 15	
1752708	28 x 22	
1752711	35 x 22	
1752706	35 x 28	
1752707	42 x 35	
1752710	54 x 35	


Double collar

Item No.	Dimension	
1182886	15	
1182887	22	
1182888	28	
1182889	35	
1182890	42	
1182891	54	


End cap

Item No.	Dimension	
1757796	15	

Tee

Item No.	Dimension	
1185665	15	
1185666	22	
1185667	28	
1185668	35	
1185669	42	

Reducing tee

Item No.	Dimension	
1185670	22 x 15 x 22	
1185671	28 x 15 x 28	

Altech Press O-ring

HNBR (yellow)



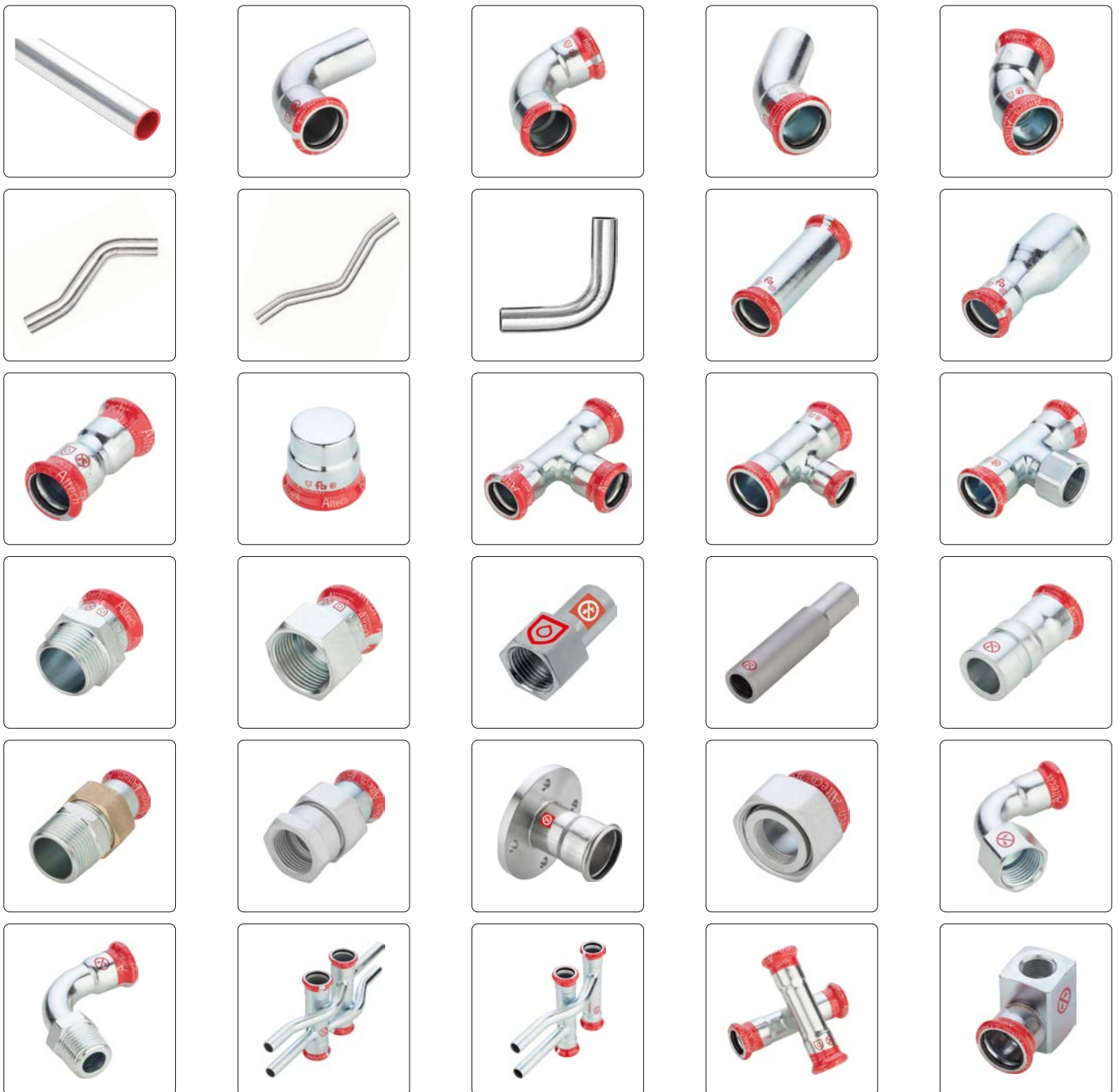
HNBR (yellow) - for gas and liquefied petroleum gas (LPG).
Manufactured in compliance with EN 549.
Temperature: between -20 and 70 °C.

See page 25 for further information.

Press fittings, galvanized steel

- Wide range of press fittings in dimensions of 12–108 mm.
- The press fitting O-ring is equipped with a leak and pressing indicator, see page 4.
- Kiwa type approval No.: 1534.

Dimensions	12, 15, 18, 22, 28, 35, 42, 54, 76.1, 88.9, 108	Press profile	12–35 mm: M-back 42–108 mm: press collar
Material	Galvanized steel	Max. temperature, continuous/short-term	Heating water: 110/110 °C Compressed air: 30/60 °C Refrigerant: -20/-30 °C
O-ring	EPDM (black)	Max. pressure, continuous/short-term	12–54 mm Compressed air/refrigerant: 10/16 bar Heating water: 6/16 bar 76.1–108 mm Compressed air/refrigerant: 10/10 bar Heating water: 6/10 bar



Galvanized pipe in press fitting dimensions in accordance with EN 10305-3

Item No.	Dimension	Längd
1554557	12 x 1,2	3 m
1554558	15 x 1,2	3 m
1554559	18 x 1,2	3 m
1554560	22 x 1,5	3 m
1554561	28 x 1,5	3 m
1554562	35 x 1,5	3 m
1554563	42 x 1,5	3 m
1554564	54 x 1,5	3 m
1553392	12 x 1,2	6 m
1553393	15 x 1,2	6 m
1553394	18 x 1,2	6 m
1553395	22 x 1,5	6 m
1553396	28 x 1,5	6 m
1553397	35 x 1,5	6 m
1553398	42 x 1,5	6 m
1553399	54 x 1,5	6 m
1367228	76,1 x 2,0	6 m
1367229	88,9 x 2,0	6 m
1367230	108 x 2,0	6 m



45° bend 1 collar

Item No.	Dimension
1542392	15
1542393	18
1542394	22
1542395	28
1542396	35
1542397	42
1542398	54
1542399	76,1
1542400	88,9
1542443	108



45° bend 2 collar

Item No.	Dimension
1542401	15
1542402	18
1542403	22
1542404	28
1542405	35
1542406	42
1542407	54
1542408	76,1
1542409	88,9
1542410	108



90° bend 1 collar

Item No.	Dimension
1542411	12
1542412	15
1542413	18
1542414	22
1542415	28
1542416	35
1542417	42
1542418	54
1542419	76,1
1542420	88,9
1542421	108



S bend short

Item No.	Dimension
1554411	12
1554299	15
1554300	18
1554301	22
1554302	28



S bend long

Item No.	Dimension
1554412	12



90° bend 2 collar

Item No.	Dimension
1542422	12
1542423	15
1542424	18
1542425	22
1542426	28
1542427	35
1542428	42
1542429	54
1542430	76,1
1542431	88,9
1542432	108



Slip bend 90° smooth end	
Item No.	Dimension
1554398	12
1554138	15
1554139	18
1554140	22
1554141	28
1554142	35
1554143	42
1554144	54



Straight slip coupling	
Item No.	Dimension
1541519	12
1541520	15
1541521	18
1541522	22
1541523	28
1541524	35
1541525	42
1541526	54
1541527	76,1



Reducer 1 collar	
Item No.	Dimension
1544076	15 x 12
1544077	18 x 12
1544078	18 x 15
1544079	22 x 12
1544080	22 x 15
1544081	22 x 18
1544082	28 x 15
1544083	28 x 18
1544084	28 x 22
1544085	35 x 22
1544086	35 x 28
1544087	42 x 22
1544088	42 x 28
1544089	42 x 35
1544090	54 x 18
1544091	54 x 22
1544092	54 x 28
1544093	54 x 35
1544094	54 x 42
1544095	76,1 x 42
1544096	76,1 x 54
1544097	88,9 x 54
1544098	88,9 x 76,1
1544099	108 x 76,1
1544100	108 x 88,9



Reducer 2 collar	
Item No.	Dimension
1544101	28 x 22



Double collar	
Item No.	Dimension
1541508	12
1541509	15
1541510	18
1541511	22
1541512	28
1541513	35
1541514	42
1541515	54
1541516	76,1
1541517	88,9
1541518	108



End cap	
Item No.	Dimension
1544917	15
1544918	18
1544919	22
1544920	28
1544921	35
1544922	42
1544923	54



Tee	
Item No.	Dimension
1543244	12
1543245	15
1543246	18
1543247	22
1543248	28
1543249	35
1543250	42
1543251	54
1543252	76,1
1543253	88,9
1543254	108



Reducing tee

Item No.	Dimension
1543255	12 x 15 x 12
1543256	15 x 12 x 15
1543257	15 x 18 x 15
1543258	15 x 22 x 15
1543259	18 x 12 x 18
1543260	18 x 15 x 18
1543261	18 x 22 x 18
1543262	22 x 12 x 22
1543263	22 x 15 x 22
1543264	22 x 15 x 15
1543265	22 x 18 x 22
1543266	22 x 28 x 22
1543267	28 x 15 x 28
1543268	28 x 18 x 28
1543269	28 x 22 x 28
1543270	35 x 15 x 35
1543271	35 x 18 x 35
1543272	35 x 22 x 35
1543273	35 x 28 x 35
1543274	42 x 22 x 42
1543275	42 x 28 x 42
1543276	42 x 35 x 42
1543277	54 x 22 x 54
1543278	54 x 28 x 54
1543279	54 x 35 x 54
1543280	54 x 42 x 54
1543281	76,1 x 54 x 76,1
1543282	88,9 x 28 x 88,9
1543283	88,9 x 76,1 x 88,9
1543284	108 x 76,1 x 108
1543285	108 x 88,9 x 108



Tee female thread branch

Item No.	Dimension
1543300	54 x G20 x54
1543301	54 x G25 x 54
1543302	76,1 x G20 x 76,1
1543303	88,9 x G20 x 88,9
1543304	108 x G20 x 108

Adapter collar male thread

Item No.	Dimension
1546717	12 x R10
1546718	15 x R10
1546719	15 x R15
1546720	18 x R15
1546721	18 x R20
1546722	22 x R15
1546723	22 x R20
1546724	22 x R25
1546725	28 x R20
1546726	28 x R25
1546727	35 x R25
1546728	35 x R32
1546729	42 x R40
1546730	54 x R50
1546731	76,1 x R65



Adapter collar female thread

Item No.	Dimension
1546701	15 x G15
1546702	15 x G15
1546703	18 x G15
1546704	18 x G20
1546705	22 x G15
1546706	22 x G20
1546707	28 x G15
1546708	28 x G20
1546709	28 x G25
1546710	35 x G32
1546711	42 x G40
1546712	54 x G50



Tee female thread branch


Item No.	Dimension
1543286	15 x G15 x 15
1543287	18 x G15 x 18
1543288	22 x G15 x 22
1543289	22 x G20 x 22
1543290	28 x G15 x 28
1543291	28 x G20 x 28
1543292	28 x G25 x 28
1543293	35 x G15 x 35
1543294	35 x G20 x 35
1543295	35 x G25 x 35
1543296	42 x G15 x 42
1543297	42 x G20 x 42
1543298	42 x G25 x 42
1543299	54 x G15 x 54





Adapter nipple female thread


Item No.	Dimension
1546713	G15 x 12
1554274	G15 x 15
1554276	G15 x 22
1554277	G20 x 18
1554278	G20 x 22





Adapter smooth end x weld end		
Item No.	Dimension	
1546733	28 x 33,7	
1546735	42 x 44,5	
1546736	54 x 57	
1546737	76,1 x 80	
1546738	88,9 x 95	
1546739	108 x 114,3	


Adapter collar with grooved end		
Item No.	Dimension	
1546732	54 x 60,3	

Union male thread		
Item No.	Dimension	
1546696	22 x R20	
1546697	28 x R25	
1546698	35 x R32	
1546699	42 x R40	
1546700	54 x R50	

Union female thread		
Item No.	Dimension	
1546691	22 x G20	
1546692	28 x G25	
1546693	35 x G32	
1546694	42 x G40	
1546695	54 x G20	

Press flange, flange according to EN 1092-1		
Item No.	Dimension	
1572372	76,1 x DN65	
1572373	88,9 x DN80	
1572374	108 x DN100	

Flat face coupling with union nut		
Item No.	Dimension	
1546688	22 x G25	
1546689	28 x G32	
1546690	35 x G40	

90° bend female thread		
Item No.	Dimension	
1542433	22 x G20	
1440392	28 x G15	
1542434	28 x G25	
1542435	35 x G25	

90° bend male thread		
Item No.	Dimension	
1542436	12 x R10	
1542437	15 x R15	
1542438	22 x R20	
1542439	28 x R25	
1542440	35 x R32	
1542441	42 x R40	
1542442	54 x R50	



Double

Single

Distributor

Item No.	Dimension	Type
1572380	12 x 12	Double
1572381	15 x 12	Double
1572382	15 x 15	Double
1572383	18 x 12	Double
1572384	18 x 15	Double
1572385	22 x 12	Double
1572386	22 x 15	Double
1572387	28 x 12	Double
1572388	28 x 15	Double
1572389	35 x 15	Double
1572390	12 x 12	Single
1572391	15 x 12	Single
1572392	15 x 15	Single
1572393	18 x 12	Single
1572394	18 x 15	Single
1572395	22 x 12	Single
1572396	22 x 15	Single
1572397	28 x 12	Single
1572398	28 x 15	Single

Offset cross

Item No.	Dimension
-	12 x 12
1572367	15
1572368	18 x 15
1572369	22 x 15
1572370	28 x 15
1572371	28 x 22






90° elbow female thread

Item No.	Dimension
1542454	22 x G15
1542455	28 x G15



Altech press O-ring

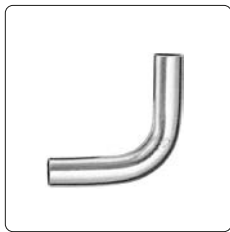
Viton (green)	EPDM (black)	Viton (red)
		
For solar heating systems, steam and hot water 0-160 °C (peaks at max. 200 °C).	For drinking water, heating and oil-free compressed air (less than 5 mg/m).	For compressed air with residual oil (more than 5 mg/m) and specific petroleum fluids.

See page 25 for further information.

Press fittings, acid-proof stainless steel – AISI 316/SIS 2348

- Wide range of press fittings in dimensions of 15–108 mm.
- The press fitting O-ring is equipped with a leak and pressing indicator, see page 4.
- Kiwa type approval No.: 1533.

Dimensions	15, 18, 22, 28, 35, 42, 54, 76,1, 88,9, 108	Press profile	15–35 mm: M-back 42–108 mm: press collar
Material	Acid-proof stainless steel - AISI 316/SIS 2348	Max. temperature, continuous/short-term	Drinking water: 95/110 °C Heating water: 110/110 °C Compressed air: 30/60 °C Refrigerant: -20/-30 °C
O-ring	EPDM (black))	Max. pressure, continuous/short-term	15–54 mm Drinking water/compressed air/refrigerant: 10/16 bar Heating water: 6/16 bar 76.1–108 mm Drinking water/compressed air/refrigerant: 10/10 bar Heating water: 6/10 bar



Acid-proof stainless steel pipe
AISI 1316L in press dimensions in
accordance with EN 10217-7 and EN 10312

Item No.	Dimension	Längd
1456560	15 x 1,0	6 m
1456561	18 x 1,0	6 m
1456562	22 x 1,2	6 m
1456563	28 x 1,2	6 m
1456564	35 x 1,5	6 m
1456565	42 x 1,5	6 m
1456566	54 x 1,5	6 m
1456567	76,1 x 2,0	6 m
1456568	88,9 x 2,0	6 m
1456569	108 x 2,0	6 m



45° bend 2 collar

Item No.	Dimension
1440404	15
1440405	22
1440406	28
1440407	35
1440408	42
1440409	54
1440410	76,1
1440411	88,9
1440412	108



90° bend 1 collar

Item No.	Dimension
1440413	15
1440414	22
1440415	28
1440416	35
1440417	42
1440418	54
1440419	76,1
1440420	88,9
1440421	108



S bend short

Item No.	Dimension
1456551	15
1456552	18
1456553	22
1456554	28



90° slip bend

Item No.	Dimension
1456380	15
1456382	22
1456383	28
1456384	35
1456385	42
1456386	54



90° bend 2 collar

Item No.	Dimension
1440422	15
1440423	18
1440424	22
1440425	28
1440426	35
1440427	42
1440428	54
1440429	76,1
1440430	88,9
1440431	108



Straight slip coupling

Item No.	Dimension
1439162	15
1439163	22
1439164	28
1439165	35
1439166	42
1439167	54
1439168	76,1




45° bend 1 collar


Item No.	Dimension
1440395	15
1440396	22
1440397	28
1440398	35
1440399	42
1440400	54
1440401	76,1
1440402	88,9
1440403	108



Double collar	
Item No.	Dimension
1439152	15
1439153	18
1439154	22
1439155	28
1439156	35
1439157	42
1439158	54
1439159	76,1
1439160	88,9
1439161	108




Tee	
Item No.	Dimension
1441458	15
1441459	18
1441460	22
1441461	28
1441462	35
1441463	42
1441464	54
1441465	76,1
1441466	88,9
1441467	108




Reducer 1 collar	
Item No.	Dimension
1442382	18 x 15
1442383	22 x 15
1442384	22 x 18
1442385	28 x 15
1442386	28 x 18
1442387	28 x 22
1442388	35 x 22
1442389	35 x 28
1442390	42 x 28
1442391	42 x 35
1442392	54 x 15
1442393	54 x 22
1442394	54 x 28
1442395	54 x 35
1442396	54 x 42
1442397	76,1 x 42
1442398	76,1 x 54
1442399	88,9 x 54
1442400	88,9 x 76,1
1442401	108 x 76,1
1442402	108 x 88,9




Reducing tee	
Item No.	Dimension
1441468	22 x 15 x 22
1441469	28 x 15 x 28
1441470	28 x 22 x 28
1441471	35 x 15 x 35
1441472	35 x 22 x 35
1441473	35 x 28 x 35
1441474	42 x 22 x 42
1441475	42 x 28 x 42
1441476	42 x 35 x 42
1441477	54 x 22 x 54
1441478	54 x 28 x 54
1441479	54 x 35 x 54
1441480	76,1 x 22 x 76,1
1441481	76,1 x 28 x 76,1
1441482	76,1 x 35 x 76,1
1441483	76,1 x 42 x 76,1
1441484	76,1 x 54 x 76,1
1441485	88,9 x 54 x 88,9
1441486	108 x 76,1 x 108



End cap	
Item No.	Dimension
1443478	15
1443479	22
1443480	28
1443481	35
1443482	42
1443483	54
1443519	76,1
1443520	88,9
1443521	108



Tee female thread branch	
Item No.	Dimension
1441487	15 x G15 x 15
1441488	22 x G15 x 22
1441489	28 x G15 x 28
1441490	35 x G15 x 35
1441491	35 x G20 x 35
1441492	42 x G15 x 42
1441493	54 x G15 x 54
1441494	54 x G20 x 54
1441495	76,1 x G20 x 76,1
1441496	76,1 x G50 x 76,1




Adapter collar male thread

Item No.	Dimension
1445744	15 x R15
1445745	15 x R20
1445746	18 x R15
1445747	18 x R20
1445748	22 x R15
1445749	22 x R20
1445750	22 x R25
1445751	28 x R20
1445752	28 x R25
1445753	28 x R32
1445754	35 x R25
1445755	35 x R32
1445756	42 x R40
1445757	54 x R50
1445758	76,1 x R65
1445759	88,9 x R80




Adapter collar female thread

Item No.	Dimension
1445736	15 x G15
1445737	15 x G20
1445738	22 x G20
1445739	22 x G25
1445740	28 x G25
1445741	35 x G32
1445742	42 x G40
1445743	54 x G50




Union male thread

Item No.	Dimension
1545800	15 x R15
1545801	22 x R20
1545802	28 x R25
1545803	54 x R50



Press flange, flange according to EN 1092-1

Item No.	Dimension
1446733	54 x DN50
1446731	76,1 x DN65
1446732	88,9 x DN80
1446734	108 x DN100




Flat face coupling with union nut

Item No.	Dimension
1445735	22 x G25




Wall plate elbow female thread

Item No.	Dimension
1446735	22 x G20
1458260	15 x G15






Elbow female thread

Art nr	Dimension
1440432	28 x G15



Altech press O-ring

Viton (green)	EPDM (black)	Viton (red)
		
For solar heating systems, steam and hot water 0-160 °C (peaks at max. 200 °C).	For drinking water, heating and oil-free compressed air (less than 5 mg/m).	For compressed air with residual oil (more than 5 mg/m) and specific petroleum fluids.

See page 25 for further information.

O-rings



EPDM (black) – standard ring for drinking water, heat and oil-free compressed air (less than 5 mg/ m³). Temperature: between -20 °C and 110 °C. Manufactured in accordance with EN 681-1. Class 1–4 in accordance with ISO 8573.

Item No.	Dimension	Copper, chrome plated copper	Stainless steel	Galvanized steel
1770283	12	✓	✓	✓
1770284	15	✓	✓	✓
1770285	18	✓	✓	✓
1770286	22	✓	✓	✓
1770287	28	✓	✓	✓
1770289	35	✓	✓	✓
1770290	42	✓	—	—
1770291	54	✓	—	—
1456570	42	—	✓	✓
1456571	54	—	✓	✓
1739788	76,1	✓	✓	✓
1739789	88,9	✓	✓	✓
1739790	108	✓	—	—
1447845	108	—	✓	✓



Viton (green) – for solar heating systems, steam and hot water requiring high temperatures. Temperature: between 0 and 160 °C, with peaks at 200 °C. Class 5 in accordance with ISO 8573.

Item No.	Dimension	Copper, chrome plated copper	Stainless steel	Galvanized steel
1770292	12	✓	✓	✓
1770293	15	✓	✓	✓
1770294	18	✓	✓	✓
1770295	22	✓	✓	✓
1770297	28	✓	✓	✓
1770298	35	✓	✓	✓
1770299	42	✓	—	—
1770300	54	✓	—	—
1456572	42	—	✓	✓
1456573	54	—	✓	✓
1739791	76,1	✓	✓	✓
1739792	88,9	✓	✓	✓
1739793	108	✓	—	—
1447871	108	—	✓	✓



Viton (red) – for compressed air with residual oil (more than 5 mg/m³) and specific petroleum fluids. Max. temperature: 60 °C. Class 7 in accordance with ISO 8573.

Item No.	Dimension	Copper, chrome plated copper	Stainless steel	Galvanized steel
1771022	12	✓	—	—
1771023	15	✓	✓	✓
1771024	18	✓	✓	✓
1771025	22	✓	✓	✓
1771026	28	✓	✓	✓
1771027	35	✓	✓	✓
1771028	42	✓	—	—
1771029	54	✓	—	—
1771060	42	—	✓	✓
1771061	54	—	✓	✓
1739794	76,1	✓	✓	✓
1739795	88,9	✓	✓	✓
1739796	108	✓	—	—
1447872	108	—	✓	✓



HNBR (yellow) – for gas and liquefied petroleum gas (LPG). Manufactured in accordance with EN 549. Temperature: between -20 and 70 °C.

Item No.	Dimension	Koppar
1739797	12	✓
1739798	15	✓
1739799	22	✓
1739800	28	✓
1739801	35	✓
1739802	42	✓
1739803	54	✓

Item No.	Application	Pressure	Temperature range	Short-term max. temp.	EN standard	ISO 8573
EPDM black	Hot and cold drinking water	16 bar	Up to +110 °C	+130 °C	EN 681-1	Class 1–4
EPDM black	Compressed air	16 bar	—	—	—	Class 6
HNBR yellow	Gas and liquefied natural gas (LNG)	5 bar	-20–70 °C	—	EN 549	—
Viton green	Steam	1 bar	Up to +120 °C	+160 °C	—	Class 5
Viton green	Hot water	6 bar	Up to +160 °C	+200 °C	—	—
Viton red	Oils	10 bar	Up to +60 °C	—	—	—
Viton red	Compressed air	10 bar	Up to +60 °C	—	—	Class 7

Technical description

Altech press fittings comprise a complete system with press fittings for quickly and reliably connecting copper, stainless steel and galvanized pipes. The pipes must be intended for press fittings and manufactured in accordance with the correct standard for the specific material type. Stainless steel is governed by EN 10217-7 and EN 10312, copper by EN 1057 and galvanized steel by EN 10305-3. Press fittings are available in dimensions of 12–108 mm in copper/galvanized steel, 12–15 mm in chrome plated copper and 15–108 mm in acid-proof stainless steel.

Temperature and pressure			
For continuous operation	Copper, chrome plated copper	Acid-proof stainless steel	Galvanized steel
Drinking water	95 °C/10 bar	95 °C/10 bar	—
Heating water	110 °C/6 bar	110 °C/6 bar	110 °C/6 bar
Compressed air	30 °C/10 bar	30 °C/10 bar	30 °C/10 bar
Refrigerant	-20 °C/10 bar	-20 °C/10 bar	-20 °C/10 bar

Technical data				
	Altech press fitting Copper, chrome plated copper	Altech press fitting Acid-proof Stainless steel	Altech press fitting Galvanized steel	Altech press fitting Copper, gas
Dimension	12–108	15–108	12–108	15–54
Material	Copper/copper alloys	AISI 316/SIS 2348 Acid-proof stainless steel	Galvanized steel	Copper/copper alloys
O-ring standard, material	EPDM	EPDM	EPDM	HNBR
O-ring standard, colour	Black	Black	Black	Yellow
Press profile	M	M	M	M
Max. temperature with Viton O-ring (green)	160 °C	160 °C	160 °C	—

Application				
	Altech press fitting Copper, chrome plated copper	Altech press fitting Acid-proof Stainless steel	Altech press fitting Galvanized steel	Altech press fitting Copper, gas
Gas	✓	✓	✓	✓
Drinking water	✓	✓	—	—
Heating/refrigerant	✓	✓	✓	—
Oil-free compressed air	✓	✓	✓	✓
Solar heating systems	✓ O-ring Viton (green)	✓ O-ring Viton (green)	—	—
Petroleum	✓ O-ring Viton (red)	✓ O-ring Viton (red)	✓ O-ring Viton (red)	—
Firefighting	✓	✓	✓	—

Application areas for gas installations			
	Copper/copper alloy gas connections	Copper/copper alloy gas connections (yellow O-ring HNBR)	Max. pressure, bar
Compressed air	✓	✓	16
Dry ice	—	✓	16
N ₂	✓	✓	16
Argon	✓	✓	10
Corgon	✓	✓	16
Vacuum	✓	✓	10
Oxygen	✓	—	10
Natural gas and LPG	—	✓	5

Considerations before installation

- A special profile on the O-ring enables the fitting to indicate a leak if it is not pressed.
- The O-ring profile does not affect the final result, as the ring is compressed on pressing and seals against the pipe.
- Altech press fittings must be pressed using approved machines and press jaws.
- The machine must have a minimum pressing force of 19 kN for dimensions of 12–28 mm for copper and 12–22 mm for stainless steel and galvanized steel. Above these dimensions and up to dimension 54 mm, the pressing force must be at least 32 kN. Special machines are required for dimensions 76.1–108 mm and a pressing force of 45 kN is usually required. These are specified in a list of approved machines. The list is available at Dahl.se.
- Follow the recommendation from the manufacturer of the pressing tool regarding service and calibration. A service or calibration certificate must be available for inspection on request. Note that the specification for the press tool differs between the different manufacturers.



Altech M-profile press fittings must be pressed using type M press jaws or press collars.

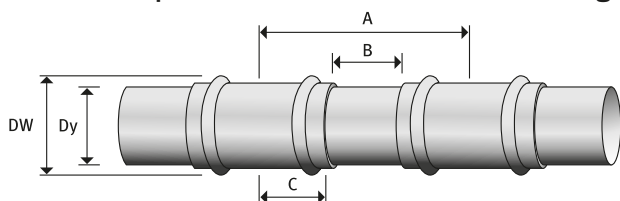
- Copper can be pressed using press jaws up to 54 mm, but it is recommended to use press collars for dimensions of 42–54 mm. Press collars must always be used for dimensions of 76.1–108 mm.
- Stainless steel and galvanized steel must be pressed with press collars for dimensions of 42 mm to 108 mm in order to ensure complete pressing and leak-tightness.



Support sleeves must be used when pressing annealed (soft) and thin-walled copper pipes fabricated in accordance with EN 1057.

- Altech press fittings must be stress-relieved in systems with large temperature fluctuations.
- The rules for anchoring on contraction and expansion in copper pipes apply in all cases.

Minimum permitted distance between fittings



Pipe diameter [Dy] (mm)	Outside diameter pressed [DW] (mm)	Min. spacing [B] (mm)	Insertion depth [C] (mm)
12	18,30 (+/- 0,2)	10	17
15	21,85 (+/- 0,2)	10	20
18	24,65 (+/- 0,2)	10	20
22	30,10 (+/- 0,65)	10	23
28	36,00 (+/- 0,65)	10	23
35	42,50 (+/- 0,3)	20	26
42	51,00 (+/- 0,3)	25	30
54	62,90 (+/- 0,3)	30	35
76,1	90,5 (+/- 0,6)	50	45
88,9	104,5 (+/- 0,6)	50	55
108	125,6 (+/- 0,6)	50	65

Material thickness of copper pipe

Press fitting dimension (mm)	Min. material thickness of copper pipe (mm)
12	1,0
15	1,0
18	1,0
22	1,0
28	1,0
35	1,2
42	1,5
54	1,5
76,1	2,0
88,9	2,0
108	2,0

Chemical compatibility guide

Remarks

- This guide on chemical resistance has been compiled to help the pipe system designer select chemically resistant materials.
- The provided information is intended only as a guideline. Material selection can be affected by many factors.
- Careful consideration must be given to temperature, pressure and chemical concentrations before a final material selection can be made.
- The chemical resistance of elastomers can differ from that of metals. They are therefore assigned separate columns in the classification table.

Material classification

A = Outstanding

B = Good – the material is slightly affected but is still suitable

C = Adequate – a certain degree of reaction occurs, but the material is still suitable

D = Large effect – not recommended

X = No conclusive data

- Fluids other than water cannot be used for food applications, as press fitting systems are not suitable for these substances due to the risk of blockage at joints.

Please contact us at 020-55 11 00 or tk@altech.nu for technical support.

Fluids	Fitting				O-ring		
	Copper	Copper alloys	AISI 316	Carbon steel	EPDM (black)	HNBR (yellow)	Viton (red)
Acetone 100 %	A	A	A	A	A	D	D
Acetylene	D	D	A	A	A	A	A
Ammonia, dry	C	C	A	A	A	A	D
Ammonium phosphate 10%	D	D	C	X	A	A	A
Ammonium chloride 1%	X	D	A	D	A	A	A
Ammonium nitrate 10+50%	D	D	A	D	A	A	A
Ammonium sulphate 10%	D	D	C	C	A	A	D
Aniline	D	D	A	A	B	D	C
Aqua regia, nitric acid	X	D	A	D	C	D	B
Benzene	A	A	A	A	D	D	A
Boric acid 5%	D	D	A	D	A	A	A
Butane	A	A	A	A	D	A	A
Butanol	C	C	A	A	A	A	A
Calcium hydroxide <= 10 °C	D	D	C	B	A	A	A
Calcium hypochlorite	D	D	D	D	A	C	A
Caustic soda 50%	X	A	A	D	A	B	C
Chlorine (dry)	D	D	B	B	A	B	A
Carbon dioxide	A	A	A	C	B	A	A
Citric acid 5%	D	D	A	D	A	A	A
Compressed air	A	A	A	B	D	A	A
Copper chloride	D	D	D	D	A	A	A
Copper nitrate	D	D	A	D	A	A	A
Copper sulphate 10%	D	D	A	D	A	A	A
Ethane	A	A	A	A	D	A	A
Ethylene glycol	A	A	A	B	A	A	A
Ethylene oxide	X	A	A	X	C	D	D
Formaldehyde	X	A	A	D	A	B	A
Fuel oil	A	A	A	X	D	A	A
Gear oil	A	A	A	B	D	A	A
Hexane	X	A	A	A	D	A	A
Hydrochloric acid 37 %	D	D	D	D	C	D	A
Hydrogen peroxide 10%	D	D	A	D	C	D	B
Iron chloride, dissolved in water	D	D	D	D	A	A	A
Iron sulphate	D	D	C	D	A	A	A
Kerosene	A	A	A	B	D	A	A
Linseed oil	A	A	A	A	A	A	A
Lubricating oils	A	A	A	A	D	A	A
Magnesium hydroxide 100 °C	X	A	C	B	A	B	A
Magnesium chloride 20%	A	A	A	B	A	A	A
Magnesium sulphate < 40%	A	A	A	B	A	A	A

A: Outstanding

B: Good – the material is slightly affected but is still suitable

C: Adequate – certain degree of reaction but still suitable

D: Large effect – not recommended

X: No data

Fluids	Fitting				O-ring		
	Copper	Copper alloys	AISI 316	Carbon steel	EPDM (black)	HNBR (yellow)	Viton (red)
Machine oil	A	A	A	B	D	A	A
Methane A	A	A	A	D	A	A	A
Methanol	A	A	A	B	A	B	D
Mineral oil	A	A	A	A	D	A	A
Motor oil	A	A	A	B	D	A	A
Naphtha	A	A	A	A	D	B	A
Naphthalene	X	A	A	A	D	D	A
Nickel chloride 10+30%	X	D	C	D	A	A	A
Nickel sulphate	A	D	A	D	A	A	A
Nitric acid 20%	D	D	A	D	A	D	B
Paraffin	A	A	A	B	D	A	A
Petrol	A	A	A	A	D	B	A
Phosphoric acid, concentrated	D	D	A	D	A	D	A
Potassium hydroxide 50 °C	X	D	C	D	A	B	D
Potassium chloride	A	X	A	D	A	A	A
Potassium sulphate 10%	A	A	A	B	A	A	A
Propane (liquid)	A	A	A	A	D	A	A
Propylene glycol	C	C	A	B	A	C	A
Seawater C	A	B	D	A	A	A	A
Sodium bicarbonate	A	A	A	C	A	A	A
Sodium phosphate	C	C	C	D	A	A	A
Sodium hypochlorite < 20% < 25 °C	D	D	A	D	A	B	A
Sodium nitrate 40%	C	A	A	C	A	B	A
Sodium sulphate 10%	A	A	A	B	A	A	A
Sulphur dioxide (dry)	A	A	C	B	A	D	B
Sulphuric acid 10% 60 °C	D	D	D	D	B	C	A
Sulphuric acid 100%, wet	D	D	C	D	C	X	B
Sulphuric acid, fuming	D	D	D	D	D	X	B
Tannin	X	A	A	D	A	A	A
Tartaric acid 10% 100 °C	C	A	A	D	B	A	A
Toluene 20 °C	A	A	A	C	D	D	B
Trichloroethylene	A	A	C	B	D	D	A
Turpentine	A	A	C	B	D	A	B
Water <= 100 °C	A	A	A	C	A	A	A
Water, deionised	A	B	A	A	A	A	A
Water, distilled	A	A	A	X	A	B	A
Zinc chloride	X	D	A	X	A	B	A
Zinc sulphate %	A	D	A	X	A	A	A

A: Outstanding

B: Good – the material is slightly affected but is still suitable

C: Adequate – certain degree of reaction but still suitable

D: Large effect – not recommended

X: No data

Distribueras av SGDS Gruppen AB
För teknisk support, kontakta oss på
020- 55 11 00 eller tk@altech.nu

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