



Developed specifically for very high chloride environments commonly found with seawater, chemical, cleaning and bore water applications.



profile



15 to 54mm



Press a 28mm fitting onto the stainless tube in under 9 seconds. Join done.

### Faster to Install

Blucher Press-Fit offers large time savings compared to welding, threading, grooving or glueing.

### Safer to Use

- We train your team onsite.
- Simple tool operation.
- Lightweight battery tools.
- No flames or hot work permits.
- No heavy gas tanks.
- No hazardous fumes.
- Less risk.

### Experience Counts

- We were the first to supply press-fit stainless in Australia & New Zealand.
- We work with consultants & installers on specialised complex projects regularly.

### Quality to Install

- Approved to Australian & International standards.
- **Material traced from coil to tube & fittings (3.1 certs).**
- Greater resistance & tolerance to chlorides for cleaning chemicals, saltwater and bore waters.

### Reliable Design

- Suits a wide range of applications.
- Permanent high strength with the original 'M' press join profile.
- Consistent low profile join look & quality each time.

### Environmental Choice

- Long service life.
- Closed loop material (completely recycled to make more stainless).
- Efficient and waste free install.
- Green Star project experience.

# Installing Press-Fit

DUPLEX

## Start to install quicker...

Blucher Press-Fit is installed easily & quickly using a Press Tool to form a permanent 'M' profile pressed joint between tube and fitting.

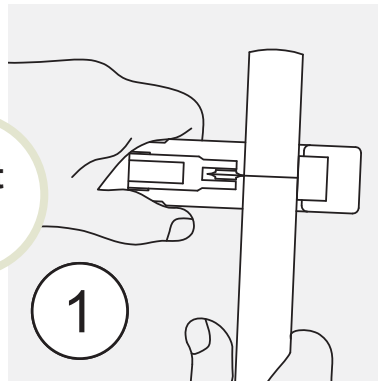


Start here

## Check for suitability...

Both the piping material (eg 2205 stainless steel) and the elastomer (eg rubber ring seal) must be checked if suitable for the possible fluids and exterior environments.

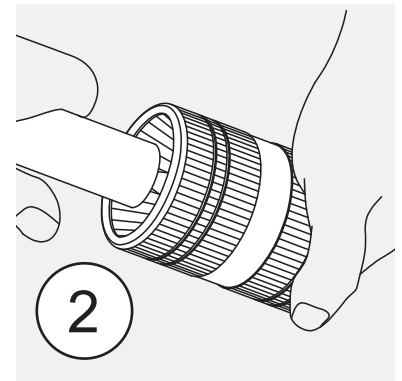
If in doubt, ask us!



## Cut to Length

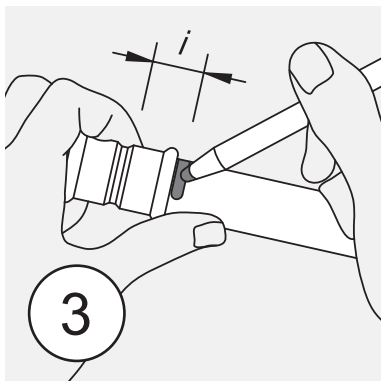
Cut the tube at right angles using a tube cutter or fine tooth saw.

**Note:** Using the same cutting tool on different metals can lead to corrosion (eg steel then stainless).



## Deburr Tube

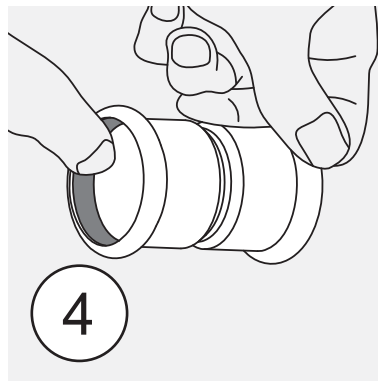
Deburr both inside & outside edges of tube to prevent damage to the ring seal of the fitting.



## Mark the Insertion Depth "i"

Measure or use a depth gauge to mark the insertion depth (socket depth) onto the tube end.

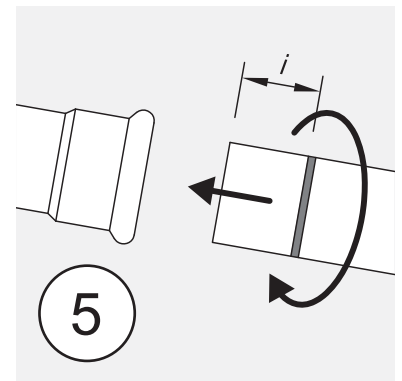
This is a visual quality control mark to ensure the tube is fully inserted.



## Inspect Fitting & Ring Seals

Check that the rubber ring seal is:

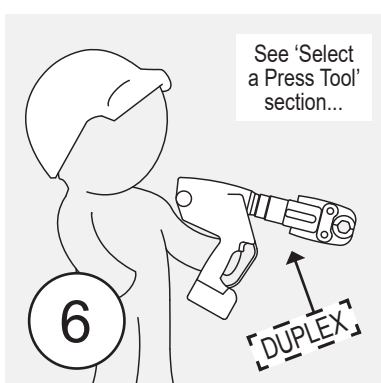
- The correct material type (colour) of seal is used.
- The seal is not damaged.
- Both fitting & seal are free of debris.



## Join the Tube & Fitting

Insert the tube into the fitting press socket, turning slightly until it reaches the previously marked insertion depth.

Soapy water can be used if joining is difficult.



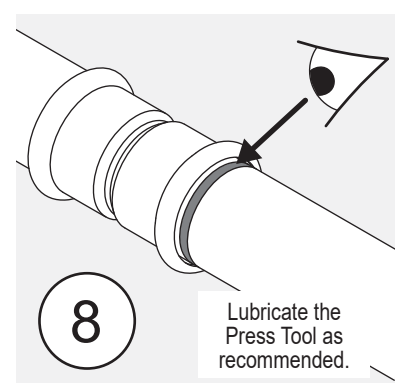
## Press Tool Selection

Select the correct press tool, jaw & collar marked with DUPLEX to suit the fitting dimension.



## Press the Join

Open the press tool jaw, align with the press socket and start the Press Tool to join the fitting & tube.

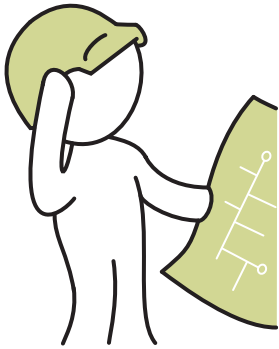


## Check & Complete

Visually inspect the pressed fitting & that the insertion mark is aligned with the end of the socket.

# Select a Press Tool

Read with 'Using the Press Tools' section.



## The right tool for the job...

Our fleet of tools are designed to install Blucher Press-Fit quickly & consistently without the need for welding or threading to form a permanent joint.

**Start here**

Our trained Sales Executives can meet onsite for Press Tool training to meet your OH&S requirements and we maintain records of attendees.

**DUPLEX**

## Duplex Tools for Duplex Stainless

Ensure the jaw, collar & press cylinder is marked with DUPLEX. These are specially engineered to withstand the pressures needed to press 2205 stainless.

## The 'M' Profile Press...

Blucher Press-Tools are calibrated to suit our products and although they may look similar to others, the tolerances of the systems are different.

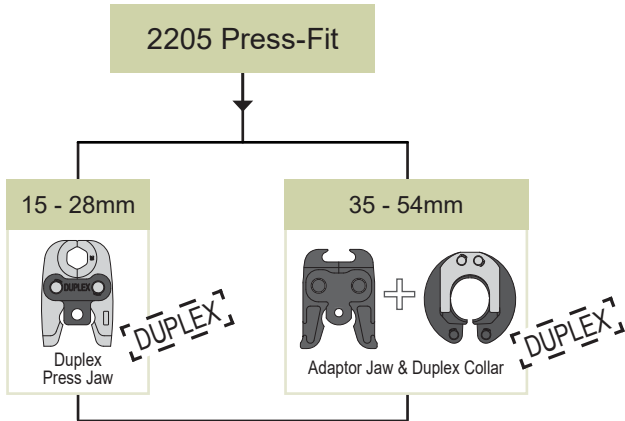
Our tooling recognises the difference and does not complete a full press. Any warranty or similar is void as a result.

Joint Log Book:  
For project QA



Now available

**OD** Press-Fit Diameters:



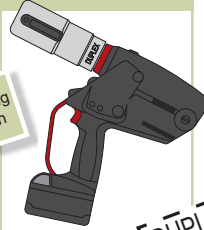
Max System Working Pressure\*: 1600 kPa 16 bar 232 psi

Subject to applicable approval and regulation maximum pressures.

Battery

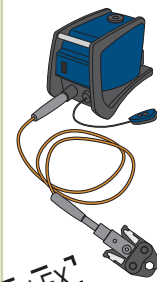
Press Tool Options:

SPM50



Coming Soon

CPN700



Duplex Press Cylinder

New!



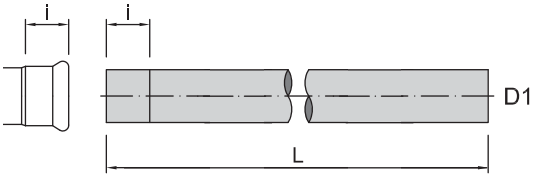
### Can DUPLEX 2205 stainless jaws and collars be used on Metric 316 stainless steel fittings?

Yes, but DUPLEX marked jaws and collars must be used on 2205 stainless fittings. Only DUPLEX jaws and collars are designed with the strength to press 2205 stainless press-fit correctly.

### Please Note:

This chart is a guide and full specifications and instructions are available on request.

## ■ Tube - Metric OD 2205 Stainless



2205 tube is supplied as TIG welded.

**DUPLEX**

**OD**

*i* = insertion depth. Tube must be inserted into the press socket a minimum distance to ensure the joint is pressed successfully.

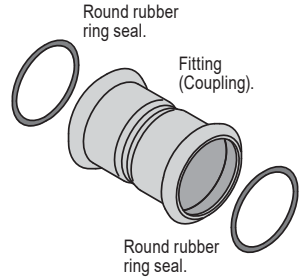
Material: 2205 stainless steel, 320 grit finish.

Product No	D1 (mm)	DN	<i>i</i> depth	Length (L)	t Wall	Tube Weights (kg)		
						dry/m	dry/6m	wet/m
2205.96.015	15	12	20	6m	1.0	0.4	2.1	0.5
2205.96.022	22	20	21	6m	1.2	0.6	3.8	0.9
2205.96.028	28	25	23	6m	1.2	0.8	4.9	1.3
2205.96.035	35	32	26	6m	1.5	1.3	7.6	2.1
2205.96.042	42	40	30	6m	1.5	1.5	9.2	2.7
2205.96.054	54	50	35	6m	1.5	2.0	11.9	4.0

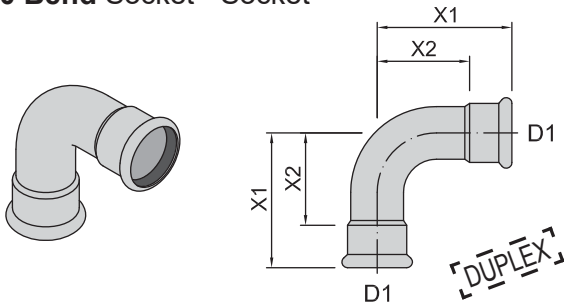
### Rubber Ring Seals

Depending on the application, the ring seals may need to be changed to a different type for higher chemical or temperature resistance.

More info in the ring seal product listing.



## ■ 90 Bend Socket - Socket

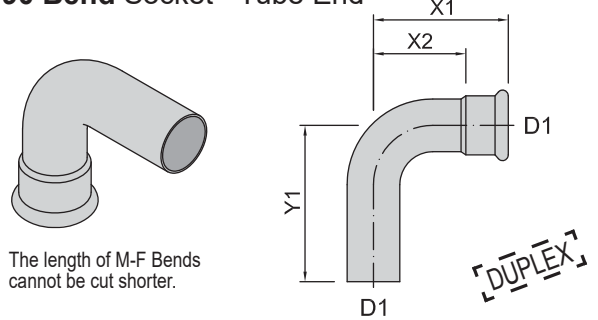


Material: 2205 stainless steel.

Ring Seal: EPDM x2 supplied.

Product No	D1	X1	X2
2205.31.090.015	15	48	28
2205.31.090.022	22	61	41
2205.31.090.028	28	71	48
2205.31.090.035	35	86	60
2205.31.090.042	42	112	82
2205.31.090.054	54	137	103

## ■ 90 Bend Socket - Tube End

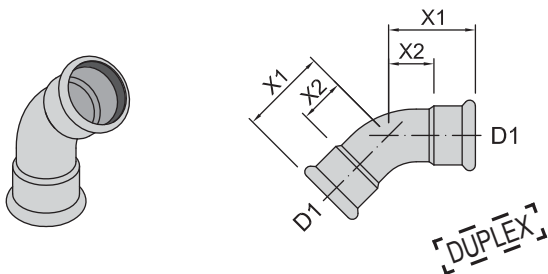


Material: 2205 stainless steel.

Ring Seal: EPDM x1 supplied.

Product No	D1	X1	X2	Y1
2205.32.090.015	15	48	28	60
2205.32.090.022	22	61	41	72
2205.32.090.028	28	71	48	83
2205.32.090.035	35	86	60	97
2205.32.090.042	42	112	82	122
2205.32.090.054	54	137	103	148

## ■ 45 Bend Socket - Socket

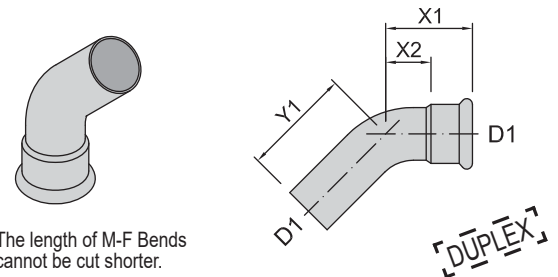


Material: 2205 stainless steel.

Ring Seal: EPDM x2 supplied.

Product No	D1	X1	X2
2205.31.045.015	15	34	14
2205.31.045.022	22	41	21
2205.31.045.028	28	46	23
2205.31.045.035	35	54	28
2205.31.045.042	42	67	37
2205.31.045.054	54	80	46

## ■ 45 Bend Socket - Tube End

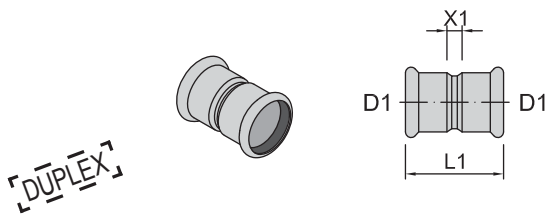


Material: 2205 stainless steel.

Ring Seal: EPDM x1 supplied.

Product No	D1	X1	X2	Y1
2205.32.045.015	15	34	14	47
2205.32.045.022	22	41	21	52
2205.32.045.028	28	46	23	58
2205.32.045.035	35	54	28	65
2205.32.045.042	42	67	37	77
2205.32.045.054	54	80	46	107

### ■ Coupling Socket - Socket

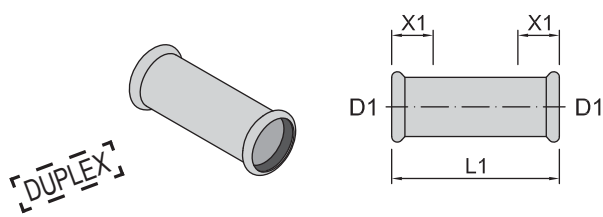


Material: 2205 stainless steel.

Ring Seal: EPDM x2 supplied.

Product No	D1	L1	X1
2205.21.015	15	48	8
2205.21.022	22	47	5
2205.21.028	28	52	6
2205.21.035	35	70	18
2205.21.042	42	78	18
2205.21.054	54	85	15

### ■ Slip (Repair) Coupling Socket - Socket

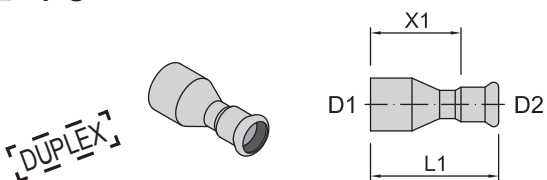


Material: 2205 stainless steel.

Ring Seal: EPDM x2 supplied.

Product No	D1	L1	X1min
2205.22.015	15	80	27
2205.22.022	22	71	19
2205.22.028	28	89	22
2205.22.035	35	99	26
2205.22.042	42	114	30
2205.22.054	54	136	34

### ■ Spigot Reducer Socket - Tube End

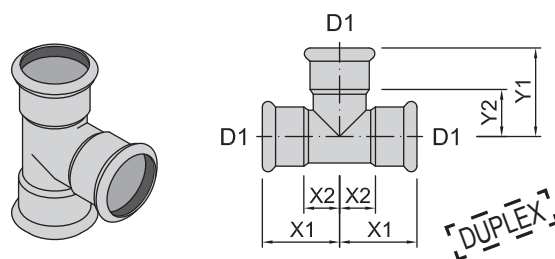


Material: 2205 stainless steel.

Ring Seal: EPDM x1 (D2) supplied.

Product No	D1	D2	L1	X1
2205.23.022.015	22	15	64	44
2205.23.028.015	28	15	68	48
2205.23.028.022	28	22	65	45
2205.23.035.022	35	22	81	61
2205.23.035.028	35	28	74	51
2205.23.042.028	42	28	82	59
2205.23.042.035	42	35	88	62
2205.23.054.028	54	28	93	70
2205.23.054.035	54	35	101	75
2205.23.054.042	54	42	101	71

### ■ Tee Equal Socket x3

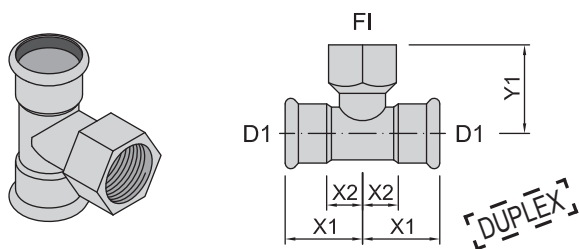


Material: 2205 stainless steel.

Ring Seal: EPDM x3 supplied.

Product No	D1	X1	X2	Y1	Y2
2205.51.015	15	32	12	39	19
2205.51.022	22	36	16	42	22
2205.51.028	28	41	18	47	24
2205.51.035	35	50	24	53	27
2205.51.042	42	57	27	60	30
2205.51.054	54	68	34	71	37

### ■ FI Tee Socket Ends - FI BSP Branch

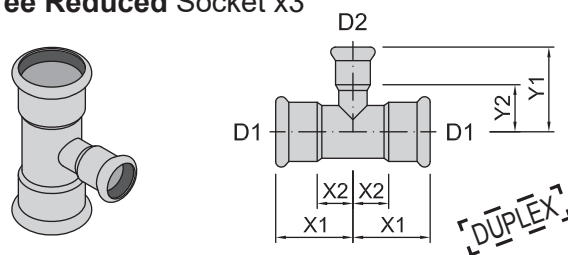


Material: 2205 stainless steel.

Ring Seal: EPDM x3 supplied.

Product No	D1	FI BSP	X1	X2	Y1
2205.53.015.015	15	1/2"	32	12	36
2205.53.022.015	22	1/2"	35	15	39
2205.53.022.020	22	3/4"	35	15	44
2205.53.028.015	28	1/2"	41	18	42
2205.53.028.020	28	3/4"	41	18	46
2205.53.035.015	35	1/2"	50	24	45
2205.53.035.020	35	3/4"	50	24	50
2205.53.042.015	42	1/2"	57	27	48
2205.53.042.020	42	3/4"	57	27	52
2205.53.054.015	54	1/2"	68	34	58
2205.53.054.020	54	3/4"	68	34	58
2205.53.054.050	54	2"	68	34	76

### ■ Tee Reduced Socket x3

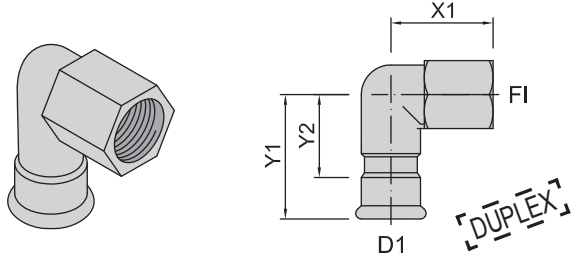


Material: 2205 stainless steel.

Ring Seal: EPDM x3 supplied.

Product No	D1	D2	X1	X2	Y1	Y2
2205.52.022.015	22	15	35	16	42	22
2205.52.028.015	28	15	41	19	45	25
2205.52.028.022	28	22	41	19	46	25
2205.52.035.015	35	15	50	24	48	28
2205.52.035.022	35	22	50	24	49	28
2205.52.035.028	35	28	50	24	51	28
2205.52.042.022	42	22	57	27	51	31
2205.52.042.028	42	28	57	27	53	31
2205.52.042.035	42	35	57	27	57	31
2205.52.054.022	54	22	68	34	57	37
2205.52.054.028	54	28	68	34	60	38
2205.52.054.035	54	35	68	34	63	37
2205.52.054.042	54	42	68	34	67	37

### FI 90 Bend Socket - FI BSP

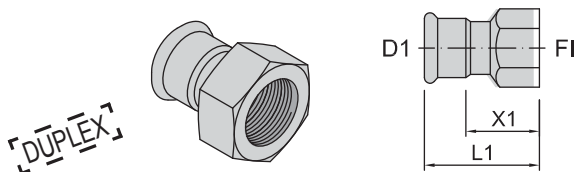


Material: 2205 stainless steel.

Ring Seal: EPDM x1 supplied.

Product No	D1	FI BSP	X1	Y1	Y2
2205.34.015.015	15	1/2"	37	57	37
2205.34.022.015	15	1/2"			
2205.34.022.020	22	3/4"	46	59	39
2205.34.028.025	28	1"	54	67	44
2205.34.035.032	35	1 1/4"	63	75	49

### FI Adaptor Socket - FI BSP

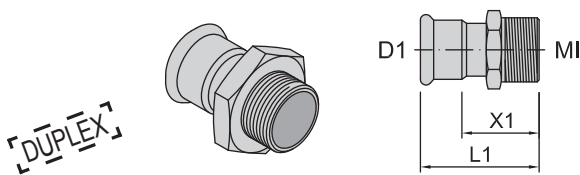


Material: 2205 stainless steel.

Ring Seal: EPDM x1 supplied.

Product No	D1	FI BSP	L1	X1
2205.73.015.015	15	1/2"	54	34
2205.73.022.015	22	1/2"	52	32
2205.73.022.020	22	3/4"	55	35
2205.73.028.025	28	1"	60	37
2205.73.035.032	35	1 1/4"	69	43
2205.73.042.040	42	1 1/2"	77	47
2205.73.054.050	54	2"	90	56

### MI Adaptor Socket - MI BSP

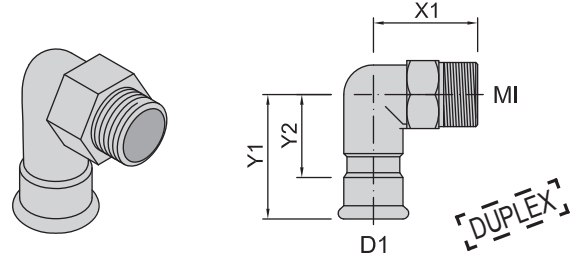


Material: 2205 stainless steel.

Ring Seal: EPDM x1 supplied.

Product No	D1	MI BSP	L1	X1
2205.74.015.015	15	1/2"	53	33
2205.74.022.020	22	3/4"	57	37
2205.74.028.025	28	1"	63	40
2205.74.035.032	35	1 1/4"	71	45
2205.74.042.040	42	1 1/2"	78	48
2205.74.054.050	54	2"	84	50

### MI 90 Bend Socket - MI BSP



Material: 2205 stainless steel.

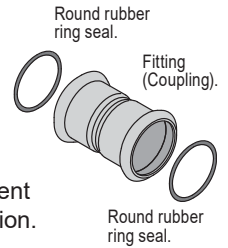
Ring Seal: EPDM x1 supplied.

Product No	D1	MI BSP	X1	Y1	Y2
2205.35.015.015	15	1/2"	37	57	37
2205.35.022.020	22	3/4"	46	59	39
2205.35.028.025	28	1"	54	67	44
2205.35.035.032	35	1 1/4"	63	75	49
2205.35.042.040	42	1 1/2"	67	84	54
2205.35.054.050	54	2"	78	93	59

### Ring Seals

Fittings with a press-fit socket are fitted with a EPDM rubber ring seal as standard.

Depending on the media, this ring seal should be changed to a different rubber material to suit the application.



Refer to our relevant **Technical Media Chart** for suitability or contact us for more information.

Type:	Pre-fitted in fitting socket*	Optional extra	Optional extra
	EPDM Standard	FKM (Viton) High Temp	NBR Oil & Gas
	<b>Black</b> -20°C to +110°C	<b>Red or Green</b> -20°C to +200°C	<b>Yellow or Grey</b> -20°C to +70°C
D1	Product No	Product No	Product No
10	see note...	FKM.11.010	-
15	EPDM.11.015	FKM.11.015	NBR.11.015
22	EPDM.11.022	FKM.11.022	NBR.11.022
28	EPDM.11.028	FKM.11.028	NBR.11.028
35	EPDM.11.035	FKM.11.035	NBR.11.035
42	EPDM.11.042	FKM.11.042	NBR.11.042
54	EPDM.11.054	FKM.11.054	NBR.11.054