

Instructions for Use

Pressgun 6 B press machine with mains connection



for all Viega system press jaws, rings, chains and
(hinged) adapter jaws with PT2 interface

Model
2295.5

viega

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1 About these instructions for use

Trade mark rights exist for this document; for further information, go to viega.com/legal.

These instructions are a translation of the original operating instructions.

1.1 Target groups

The information in these operating instructions is directed at the following groups of people:

- Heating and plumbing experts and trained personnel

This product must not be used by persons who do not have the aforementioned training or qualifications.

1.2 Labelling of advisory text and safety symbols

Warning and advisory texts are set aside from the remainder of the text and are labelled with the relevant pictographs.



DANGER!

This symbol warns of possible life-threatening injury.



WARNING!

This symbol warns of possible serious injury.



CAUTION!

This symbol warns of possible injury.



NOTICE!



This symbol warns of possible damage to property.



This symbol gives additional information and hints.

Warning signs and symbols

Pay attention to the warning signs and symbols on the press machine and accessories:

	<p>Observe the operating instructions Read the operating and safety instructions carefully prior to the commissioning procedure.</p>
	<p>Protection class II (double insulated casing)</p>
	<p>The marked product must not be disposed of as household waste.</p>
	<p>Warning of flying fragments</p>
	<p>Use of the retaining bolt</p>
	<p>The maintenance label indicates the date of the next service.</p>
	<p>CE marking: Product safety in Europe</p>
	<p>EAC marking: Registration of products in the territory of the Eurasian Customs Union</p>

1.3 About this translated version

This instruction for use contains important information about the choice of product or system, assembly and commissioning as well as intended use and, if required, maintenance measures. The information about the products, their properties and application technology are based on the current standards in Europe (e.g. EN) and/or in Germany (e.g. DIN/DVGW).

Some passages in the text may refer to technical codes in Europe/Germany. These should serve as recommendations in the absence of corresponding national regulations. The relevant national laws, standards, regulations, directives and other technical provisions take priority over the German/European directives specified in this manual: The information herein is not binding for other countries and regions; as said above, they should be understood as a recommendation.

1.4 Note on use of abbreviated terms

For reading comfort, the following abbreviated terms are used in these instructions for use:

Term	Abbreviated form
Viega system press machine Pressgun 6 B	Press machine
Viega system press jaws	Press jaws
Viega system press rings	Press rings
Viega system press tool	Press tool Combinations of for example: <ul style="list-style-type: none"> ■ Press machine and press jaws ■ Press machine with hinged adapter jaws and press ring or press chain ■ Press machine and press-in attachment tool

2 Product information

2.1 Standards and regulations

The following standards and regulations apply to Germany / Europe and are provided as a support feature.

Regulations from section: Technical data

Scope / Notice	Regulations applicable in Germany
Oscillation emission value	EN 60745-1
Protection classes	

2.2 General safety advice for electrical tools

This section contains general safety instructions for numerous different products and electrical tools. Consequently, not every safety instruction will apply to this tool.



WARNING!

Read all safety warnings, instructions, illustrations and specifications provided with this power tool.

Failure to follow all instructions listed below may result in electric shock, fire and/or serious injury.

Save all warnings and instructions for future reference.

The term “power tool” in the warnings refers to your mains-operated (corded) power tool or battery-operated (cordless) power tool.

Work area safety

a) Keep work area clean and well lit.

Cluttered or dark areas invite accidents.

b) Do not operate power tools in explosive atmospheres, such as in the presence of flammable liquids, gases or dust.

Power tools create sparks which may ignite the dust or fumes.

c) Keep children and bystanders away while operating a power tool.

Distractions can cause you to lose control.

Electrical safety

a) Power tool plugs must match the outlet. Never modify the plug in any way. Do not use any adapter plugs with earthed (grounded) power tools. Unmodified plugs and matching outlets will reduce risk of electric shock.

b) Avoid body contact with earthed or grounded surfaces, such as pipes, radiators, ranges and refrigerators.

There is an increased risk of electric shock if your body is earthed or grounded.

c) Do not expose power tools to rain or wet conditions.

Water entering a power tool will increase the risk of electric shock.

d) Do not abuse the cord. Never use the cord for carrying, pulling or unplugging the power tool. Keep cord away from heat, oil, sharp edges or moving parts.

Damaged or entangled cords increase the risk of electric shock.

e) When operating a power tool outdoors, use an extension cord suitable for outdoor use.

Use of a cord suitable for outdoor use reduces the risk of electric shock.

f) If operating a power tool in a damp location is unavoidable, use a residual current device (RCD) protected supply.

Use of an RCD reduces the risk of electric shock.

Personal safety

a) Stay alert, watch what you are doing and use common sense when operating a power tool. Do not use a power tool while you are tired or under the influence of drugs, alcohol or medication.

A moment of inattention while operating power tools may result in serious personal injury.

b) Use personal protective equipment. Always wear eye protection.

Protective equipment such as a dust mask, non-skid safety shoes, hard hat or hearing protection used for appropriate conditions will reduce personal injuries.

c) Prevent unintentional starting. Ensure the switch is in the off-position before connecting to power source and/or battery pack, picking up or carrying the tool.

Carrying power tools with your finger on the switch or energising power tools that have the switch on invites accidents.

d) Remove any adjusting key or wrench before turning the power tool on.

A wrench or a key left attached to a rotating part of the power tool may result in personal injury.

e) Do not overreach. Keep proper footing and balance at all times.

This enables better control of the power tool in unexpected situations.

f) Dress properly. Do not wear loose clothing or jewellery. Keep your hair and clothing away from moving parts.

Loose clothes, jewellery or long hair can be caught in moving parts.

g) If devices are provided for the connection of dust extraction and collection facilities, ensure these are connected and properly used.

Use of dust collection can reduce dust-related hazards.

h) Do not let familiarity gained from frequent use of tools allow you to become complacent and ignore tool safety principles.

A careless action can cause severe injury within a fraction of a second.

Power tool use and care

a) Do not force the power tool. Use the correct power tool for your application.

The correct power tool will do the job better and safer at the rate for which it was designed.

b) Do not use the power tool if the switch does not turn it on and off.

Any power tool that cannot be controlled with the switch is dangerous and must be repaired.

c) Disconnect the plug from the power source and/or remove the battery pack, if detachable, from the power tool before making any adjustments, changing accessories, or storing power tools.

Such preventive safety measures reduce the risk of starting the power tool accidentally.

d) Store idle power tools out of the reach of children and do not allow persons unfamiliar with the power tool or these instructions to operate the power tool.

Power tools are dangerous in the hands of untrained users.

e) Maintain power tools and accessories. Check for misalignment or binding of moving parts, breakage of parts and any other condition that may affect the power tool's operation. If damaged, have the power tool repaired before use.

Many accidents are caused by poorly maintained power tools.

f) Keep cutting tools sharp and clean.

Properly maintained cutting tools with sharp cutting edges are less likely to bind and are easier to control.

g) Use the power tool, accessories and tool bits etc. in accordance with these instructions, taking into account the working conditions and the work to be performed.

Use of the power tool for operations different from those intended could result in a hazardous situation.

h) Keep handles and grasping surfaces dry, clean and free from oil and grease.

Slippery handles and grasping surfaces do not allow for safe handling and control of the tool in unexpected situations.

Service

a) Have your power tool serviced by a qualified repair person using only identical replacement parts.

This will ensure that the safety of the power tool is maintained.

b) Never service damaged battery packs.

Service of battery packs should only be performed by the manufacturer or authorized service providers.

Basic safety rules

a) Use the correct tools.

Only use the tools and accessories listed in the operating instructions. Do not use electric tools for purposes or work they are not intended for.

b) Secure the workpiece.

Use clamping devices or a vice to hold the workpiece. It is held more securely than it would be by hand and both your hands are free to operate the tool.

c) Leave protective equipment in place.

d) Hand-held devices must not to be used as stationary equipment.

e) Do not hold the device in the compression area.

f) Do not hold any body parts or foreign objects between the press jaws when activating the pressing cycle. Do not hold the jaw lever during the pressing cycle. Danger of crushing!

There is a danger of crushing the Fingers and hands.

g) Observe the safety instructions for the cleaning and corrosion protection agents used by you.

h) Ensure that the workpiece is not under tension.

2.3 Intended use

2.3.1 Areas of use

The Viega system press machine Pressgun 6 B is intended for pressing press connectors into the respective piping systems. In combination with Viega system press jaws, chains or rings, the press tool is suitable for use with all Viega plumbing and heating installation systems up to and including dimension 108, as well as Megapress press connectors in dimensions $\frac{3}{8}$ to 2 inches.

2.4 Product description

2.4.1 Overview

Scope of delivery

- Press machine Pressgun 6 B
- Operating instructions
- Transport case with case inlay

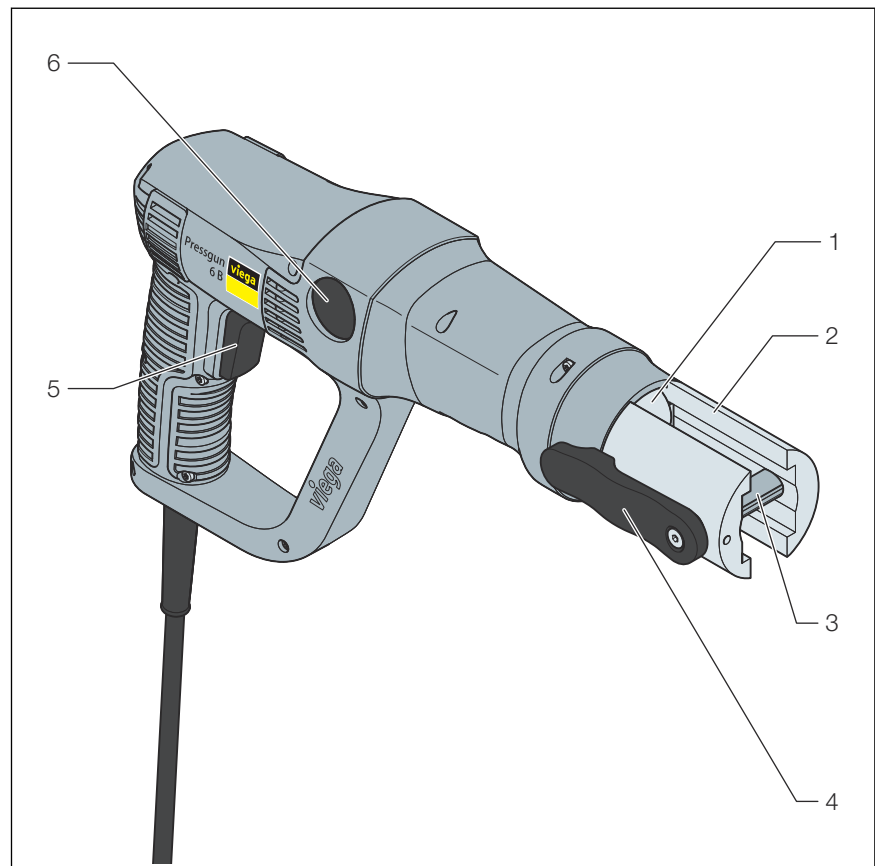
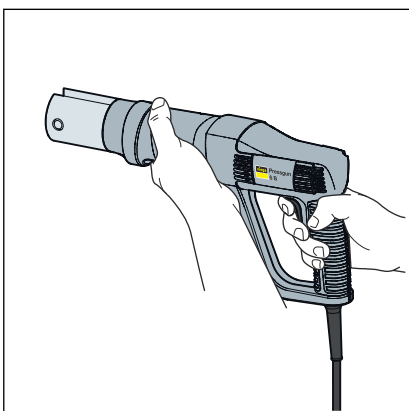


Fig. 1: Overview

- 1 Roller head
- 2 Cylinder head with press jaw fixture (180° rotatable)
- 3 Retaining bolt
- 4 Retaining bolt lever
- 5 Start button
- 6 Reset button

Gripping surfaces on the press machine



- To avoid injuries during pressing, hold the press machine in both hands as shown in the picture.

Data on the specification plate

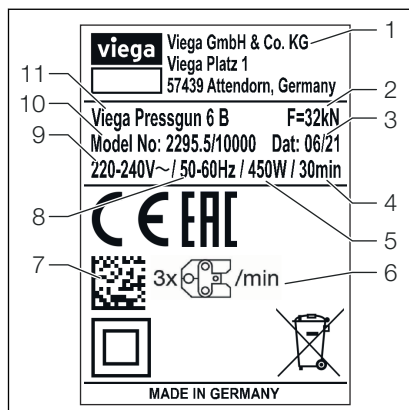


Fig. 2: Specification plate

- 1 Manufacturer logo with address
- 2 Nominal force
- 3 Year of manufacture
- 4 Permitted constant operation ≤ 30 min
- 5 Nominal output
- 6 Maximum three pressings per minute (\leq DN 54)
- 7 QR code
- 8 Permitted frequency range
- 9 Permitted voltage area
- 10 Article number / serial number
- 11 Type designation for the press machine

For explanations on the symbols, see [Chapter 1.2 'Labelling of advisory text and safety symbols'](#) on page 3

2.4.2 Technical data

Nominal output	450 W	
Voltage	220–240 VAC	
Frequency	50–60 Hz	
Machine monitoring	hydraulic	
Acoustic power level max.	87 dB(A)	¹⁾
Sound pressure on ear	76 dB(A)	¹⁾
Oscillation level	< 2.5 m/s ²	²⁾
Power transmission	hydraulic	
Thrust on piston	32 kN	
Switch-on duration	Maximum three pressings per minute	
Permitted continuous operation	≤ 30 min	

¹⁾ measurement uncertainty 3 dB(A)

²⁾ measurement uncertainty 1.5 m/s²

Weight	3000 g
Protection class	II
Permitted operating temperature	-10–50 °C

¹⁾ measurement uncertainty 3 dB(A)

²⁾ measurement uncertainty 1.5 m/s²



NOTICE!

Wear hearing protection.

The specified oscillation emission value was measured in accordance with a standardised test procedure and can be used to compare the machine with another device. The specified oscillation emission value can also be used for an initial assessment of the intermittent duty.

When the device is actually being used, the oscillation emission value may differ from specified value, depending on the manner in which the device is used. Depending on the actual conditions of use (intermittent duty), it may be necessary to specify safety measures to protect the user.

2.4.3 Operating mode

The Viega Pressgun 6 B is an electro-hydraulically operated press machine. Pressing the start button and keeping it pressed triggers pressing. The hydraulically operated roller head moves forwards into the press jaw and closes it with a power of 32 kN.

Power is supplied via a mains connection 220–240 V AC with 50–60 Hz.

Positively controlled process


The press machine operates by a positively controlled process. This means:

- During the pressing, even when the Start button is temporarily released, the roller head of the press machine stays in the position reached.
- The pressing must be completed in order for the roller head to return.

For safety reasons, the positive control is enabled only after the press machine has reached a minimum force.

2.4.4 Control elements and indicators at the press machine

Start button

Use the Start button to trigger a pressing; see  Chapter 3.3 'Carrying out the pressing process' on page 16.

Reset button

Press the Reset button to abort pressing at any time, see [↪ Chapter 3.4 'Aborting the pressing process' on page 17.](#)

Rotatable cylinder head

The press jaw fixture in the front part of the cylinder head is 180° rotatable to allow for flexible alignment of the press jaws to the pressing point.

3 Handling

3.1 Transport and storage



NOTICE!
Risk of damage to and malfunctioning of the press machine due to improper use!

Use a transport case for storage and transport.

Protect the press machine and accessories from the following external influences:

- Impacts
- Moisture and humidity
- Dust and dirt
- Frost and extreme heat
- Chemical solutions and vapours

3.2 Commissioning



CAUTION!
Risk of crushing by operating the press machine without press jaws!

If no press jaw is inserted, your fingers may get caught in the danger zone and get crushed when the press machine starts up.

- Do not use the press machine without a press jaw inserted.
- Do not put your fingers in the danger zone.



CAUTION!
Risk of device damage due to failure to fully lock the retaining bolt!

If the retaining bolt is not fully inserted and locked, the cylinder may tear during pressing.

- Ensure that the retaining bolt is locked before starting pressing.

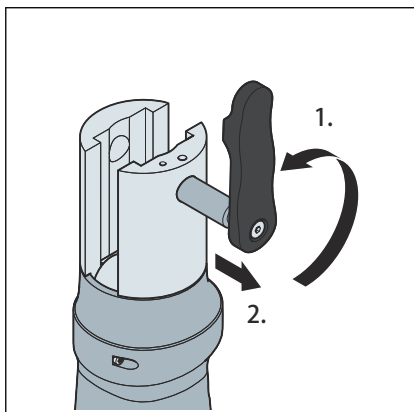


NOTICE!
Cooling phases during constant operation

The press machine is not suitable for constant operation.

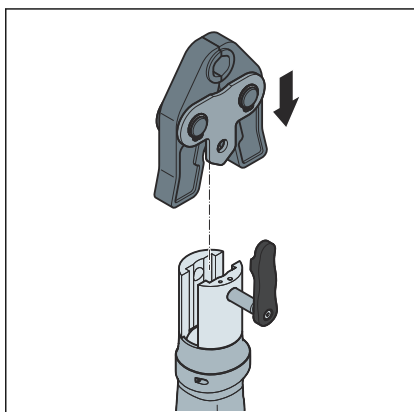
- After 30 min of constant operation, stop using it for at least 15 minutes to allow the device to cool down.

- Check the scope of delivery.
- Turn the retaining bolt lever of the retaining bolt by 180° to release it from the lock position.
- Pull out the retaining bolt.

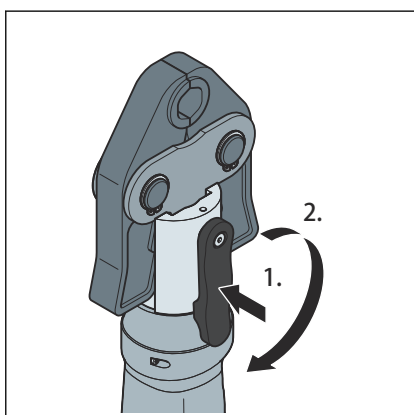


- Insert the press jaw in the press jaw fixture of the cylinder head.

INFO! The figures show the typical use of a press jaw. Use the hinged adapter jaws in the same way.



- Slide the retaining bolt in as far as it will go and turn the retaining bolt lever by 180° to return it to its snap-in position.



3.3 Carrying out the pressing process



CAUTION!
Risk of crushing due to improper use!

- Do not start the press machine without a press jaw inserted.
- Do not reach into the area of the moving roller head or press jaws during pressing.
- In order to operate it safely, firmly hold the press machine on both the handle and behind the press machine head.



NOTICE!
Risk of property damage due to damaged press jaws!

Using a damaged, incorrectly dimensioned, or worn press jaw may result in an incorrect pressing.

- Check the press jaw before use for any visible defect, and if applicable replace the press jaw.
- Only use press jaws that are the right dimension and are compatible with the press connector system.

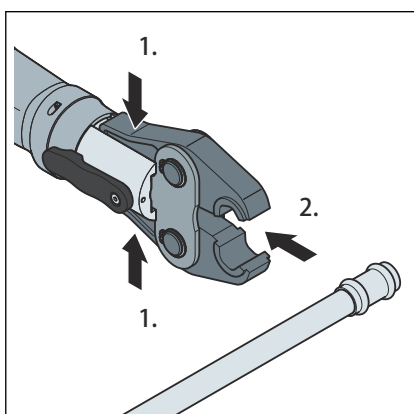
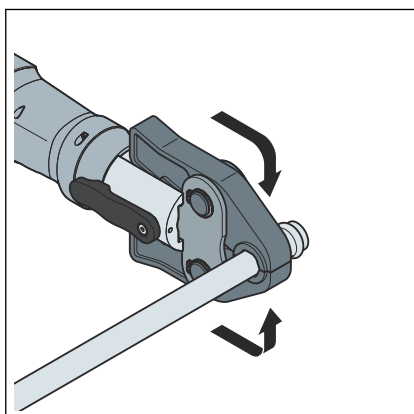
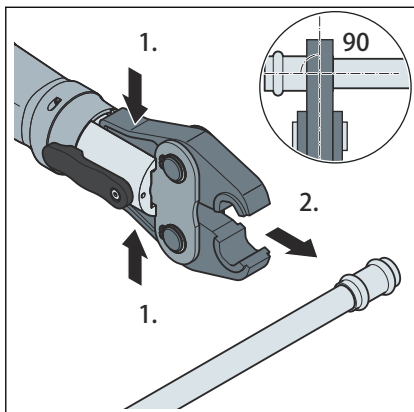


The press jaw must be able to lock properly during pressing.

- Ensure that there is enough space on the press point.
- Keep the press jaw contour and the area around the press point free from dirt and any objects that could hinder complete pressing.

Requirements:

- There is a mains connection.
- A press jaw has been correctly inserted.
- Check whether the nominal width of the press connector matches the nominal width of the press jaw.
- Fit the press machine with the press jaw inserted accurately and at a right angle to the pipe axis on the press connector.



- Keep the start button pressed until you note a speed increase of the motor and a visible removal of the load off the press jaw.
- The pressing process has terminated.

- To retract the roller head to its initial position, release the Start button.
- After full retraction of the roller head, open the press jaw and loosen it from the press connector.



In case of interruption of the power supply during pressing, press the Reset button to return the roller head to its initial position.

Then remove the incompletely pressed press connector from the installation and use a new press connector.

3.4 Aborting the pressing process

When the roller head has not touched the press jaw yet and the press machine has not yet built up any pressing force:

- Release the Start button to interrupt the pressing.

If the press machine is in positive control mode:

- In order to abort the pressing, release the Start button and press the Reset button.

3.5 Care and maintenance

The tools are subject to normal wear and tear; for this reason, they must be maintained in regular intervals. The maintenance and servicing of the tools must be carried out by service partners authorised by Viega.

Maintenance interval

- The next maintenance date is indicated on the press machine. **Have the machine maintained at least every two years.**

3.5.1 Cleaning the press tools

Press machine



NOTICE! **Damage due to fluids!**

Make sure that no fluids get inside the press machine.
Never dip the press machine into fluids.

Requirements:

- The press machine is not energised (mains plug has been unplugged).
- No press jaw is inserted.
- Wipe the press machine down with a slightly damp cloth.
- Clean the press rolls of the roller head dry and then treat with maintenance oil (art. no. 667 924).

Press jaws and press rings

- Remove dirt and metallic residues from the press jaw or the press ring.
- Remove residues from the press jaw contour (e.g. using Viega cleaning fleece, art. no. 104 412).
- Apply maintenance oil to the hinges and all moving parts (art. no. 667 924).
- Then thinly spray the press jaw or press ring with maintenance oil (art. no. 667 924) and let it work for a short time before wiping off with a lint-free cloth.

3.5.2 Performing checks

To ensure trouble-free operation, perform checks at regular intervals:

- Check the press machine for externally identifiable damage, torn material, or visible wear. Do not use the machine unless it is free of faults.
- At the end of each use, check the press contour of the press jaws and press rings for damage or visible wear.
- Check the press jaws and press rings for smooth operation.
- Check all press jaws and press rings for proper function by carrying out a test pressing with press connector inserted.



NOTICE!

In case of malfunctions, contact an authorised service partner. Do not attempt to carry out repairs yourself.

3.6 Disposal

Do not dispose of the press machine in household waste and do not scrap it. For environmentally compatible disposal, send the press machine to your local service partner or pass it to a recycling company.

4 Appendix

4.1 Warranty

The warranty period for Viega system tools, such as press tools, press jaws, press rings, Steptec punches, pipe cutters, calibration devices, etc., is governed by the national statutory provisions of the country in which you are headquartered. However, it is at least two years after purchase and transfer of risk.

Please keep the proof of purchase in the event that repairs are required during the warranty period. The warranty does not apply in cases of incorrect and non-professional use. If the defect is due to incorrect and non-professional use, or normal wear and tear of wearing parts, warranty claims are excluded.

4.2 Declaration of Conformity

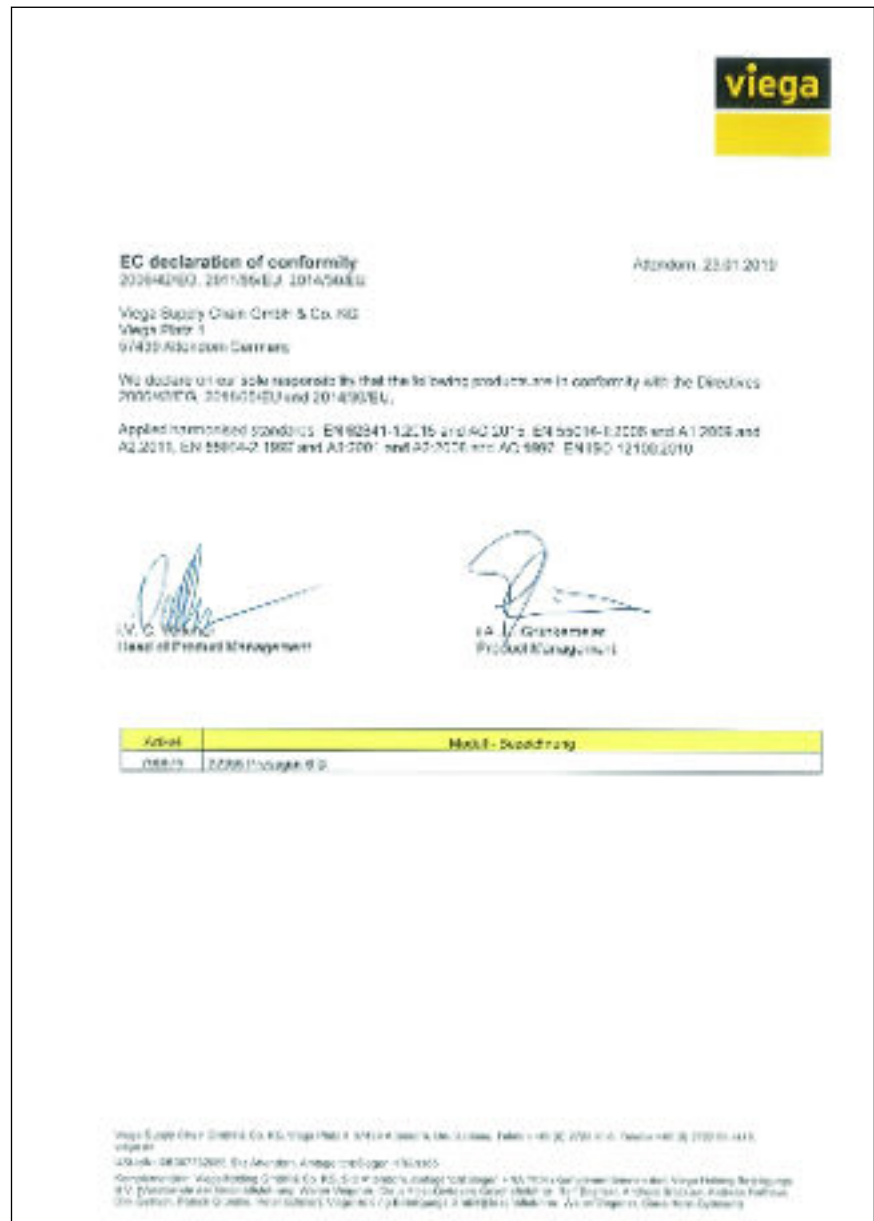


Fig. 3: EC Declaration of Conformity Pressgun 6 B

4.3 Service partners

For maintenance and repair of the press tools, contact the service partner in your country.

Country code	Company	Address/contact
AT	König & Landl GmbH	Döblinger Hauptstrasse 15, 1190 Vienna https://www.koenig-landl.at / office@koenig-landl.at +43 1 4797484-13
AU	Nepean Boltmaster	42 Borec Road, 2750 Penrith +61 (2) 4722 3034 / sales@nepbolt.com.au
	Allied Power Tools	12/76 Rushdale St, Knoxfield, VIC 3180 +61 (3) 9764 2911 / sales@alliedpowertools.com.au
BE	OMICRON-Benelux	Grote Steenweg 116, 3454 Rummen-Geetbets +32 (11) 58 43 50 / info@omicronwt.com
CN	德房家(中国)管道系统有限公司	无锡市锡山区万全路 30 号平谦国际现代产业园 P 栋 +400 0688 668 / tao.wu@viega.cn
	Viega (China) Plumbing Systems Co., Ltd.	Building P, Pingqian International Modern Industrial Park, No. 30 Wanquan Road, Xishan District, Wuxi, China (214107) +400 0688 668 / tao.wu@viega.cn
CZ / SK	Mátl & Bula	Stará pošta 750, 66461 Rajhrad u Brna +420 5 4723 0048 / info@matl-bula.cz
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ES	Tecno Izquierdo	Avda. del Manzanares 222, 28026 Madrid +34 (914) 759158 / tecno.izquierdo@telefonica.net
FR	Plasti Pro	245 boulevard de l'Europe, 62118 Monchy-le-Preux +33 (361) 47 40 45 / contact@sarl-plastipro.fr
FI	Sähköhuolto Tissari Oy	Pojjutie 3, 70460 Kuopio +358 44 3038400 / info@sht.fi
GR	Ergon Equipment A.E.T.E.	102 Kleisthenous & Papafiessa Str, 153 44 Athens +30 (210) 604945 4 / astathis@ergon.com.gr
IT	Elmes KG	Via Artigianale Nord, 6, 39044 Neumarkt +39 (0471) 813399 / info@elmes.it

Country code	Company	Address/contact
IT	O.R.E. s.r.l.	Via Sassonia, 16/G, 47900 Rimini +39 (0541) 741003 / info@oreutensili.com
JP	Toyo Kiko Inc.	717-5 Shimokuya-machi, 378-0061 Numata-shi +81 (278) 24 41 77 / r.adachi@toyo-fit.co.jp
NO	Grønvold Maskinservice A/S	Brobekkveien 104 A, 0613 Oslo +47 (23) 05 06 40 / Terje@gronvoldmaskin.no
NL	MG Service	Canadabaan 2, 5388 RT Nistelrode +31 (412) 617 299 / info@mgservice.nl
RU	KONTURS-SDM	Московская область, Солнечногорский район, Ленинградское шоссе, 34 км., стр. 15 (полигон МАДИ) +7 (499) 155 07 11 / info@konturs-sdm.ru
SE	AGB Service	Flottiljvägen 22, 39241 Kalmar +46 (0)480 281 74 / order@agbservice.se
SE	AGB Service	Rosstigen 2, 16952 Solna +46 (0)8 20 22 45 / order@agbservice.se
UK	MEP Hire	Unit K, Ashley Drive Bothwell, G71 8BS Glasgow +44 800 587 5121 / hire@mephire.co.uk
	Broughton Plant Hire & Sales	Unit 10, Trade City, Ashton Road, RM3 8UJ Romford, Essex +44 (1708) 383350 / hire@mbroughtonltd.co.uk



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