

**Vinidex**  
by aliaxis



**Philmac**

**PUSH**

**Push. Done.**

Technical Manual



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Philmac is well renowned for quality products and services. Philmac manufactures pipe fittings and valves under a Quality Assurance System assessed and approved to ISO 9001. Philmac has a NATA accredited laboratory and tests fittings and valves to international and national standards. Third party accreditation is carried out by SAI Global.

**Disclaimer**  
Please note that the information, opinions, recommendations and advice given in this manual are supplied only to provide an improved understanding of the technical aspects of fitting systems.  
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Standards

|                                                                                                                                  |                                                                                                                                                                                                                                                                                                                                     |                                                                                                                                                                                                                                                                                                                     |
|----------------------------------------------------------------------------------------------------------------------------------|-------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|---------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|
| <p>Philmac Push is a complete range of mechanical fittings designed to make connections simple when joining metric PE pipes.</p> | <p>Philmac Push is designed to comply with the requirements of the following standards:</p> <p><b>AS/NZS4129</b><br/>Fittings for polyethylene pressure pipe systems.</p> <p><b>AS/NZS 4020</b><br/>Products for use in contact with water intended for human consumption with regards to their effect on the quality of water.</p> | <p><b>ISO7.1</b><br/>Pipe threads where pressure joints are made on the threads.</p> <p><b>Philmac Push connects pipe that conforms to - AS/NZS4130,</b><br/>Polyethylene pipes for pressure applications.</p> <p>Products comply with the lead-free requirements of the national construction code – volume 3.</p> |
|----------------------------------------------------------------------------------------------------------------------------------|-------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|---------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|

Product Specifications

|                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                             |                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                    |                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                        |
|-----------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|----------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|--------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|
| <p><b>Fittings For PE To PE Pipe Connection</b><br/>Guidelines for the specifications of Philmac Push compression fittings.</p> <p><b>Manufacturer Accreditation</b><br/>Fittings are manufactured to comply with the ISO9001 Quality System.</p> <p><b>Product Performance Accreditation</b><br/>Fittings for Polyethylene (PE) pipes meet the applicable performance requirements of AS/NZS 4129 with specific reference to:</p> <ul style="list-style-type: none"><li>a) Pressure Testing [ISO 3458]</li><li>b) External Pressure resistance testing [ISO 3459]</li><li>c) Resistance to pull out of test assemblies at 20 degrees C [ISO 3501]</li><li>d) Internal pressure resistance when subjected to bending stresses [ISO 3503]</li></ul> <p>Threaded ends of fittings are tapered and conform to ISO7.1 [specification for pipe threads for tubes and fittings where pressure tight joints are made on threads].</p> <p><b>Product Material Accreditation</b></p> | <p>Performance verification has been conducted according to test parameters outlined in Clause 1.12.2 and 2.4.3 if AS/ NZS 4129 – Verification of long term behaviour.</p> <p>Fittings are suitable for the conveyance of drinking water and conform to AS4020 [products for use in contact with water intended for human consumption with regards to their effect on the quality of water].</p> <p><b>Product Configuration/ Material Overview</b><br/>Fittings are of the compression fitting type.</p> <p>Fitting bodies are of polypropylene material and the collet, spacer and grip ring is acetal material. Each fitting are supplied complete and pre-assembled with captivated collet, spacer and grip ring and seal inside the body.</p> <p>O-rings shall be made of EPDM.</p> <p>Fitting body colour is black so as to minimise potential light transmission and/or UV degradation.</p> | <p><b>Method of Connection</b><br/>To achieve a leak proof joint, the pipe is pushed through the collet, grip ring and o-ring pre-assembled inside the fitting’s body, till it reaches the internal end stop which provides positive installation feedback. The collet and grip ring is engineered with a reverse-taper design providing axial end-load resistance by producing sharp indentations that effectively lock the pipe into the fitting body.</p> <p><b>Disassembly &amp; Reassembly</b><br/>To disassemble, simply loosen the nut. The only tool you might need is a standard wrench.</p> <p>Any pipe preparation will be limited to cutting and cleaning of pipe [for foreign material or burrs]. Fittings do not require the pipe to be lubricated or chamfered during installation.</p> |
|-----------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|----------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|--------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|

# Installation Instructions



1. Cut pipe square and to required length using the flange on the central body as a guide. Ensure end of connecting pipe is undamaged and clean.



2. The fitting is pre-assembled and ready to use.



3. Take the pipe and insert it into the fitting, you'll feel it hitting the internal stop once it pushes past o-ring, it's now fully installed.

# Disassembly & Reassembly



4. To disassemble, simply loosen the nut. The only tool you might need is a standard wrench.



5. When you remove the nut all the components become loose and the pipe can be removed.



6. Firstly take the o-ring and place in the body



7. Then take your spacer and again place in fitting body.



8. Take the grip ring ensuring it is orientated correctly with the gripper teeth pointing downwards.



9. Take split ring, placing it on top of the grip ring with the taper facing up



10. Put the nut back onto the body, tighten up by hand.



11. Ensure the nut meets the flange. The fitting is now ready for re-use.



# System Design Considerations

There are generally three types of PE pipe fittings; mechanical, push and thermofusion. Philmac Push™ is a range of push fittings that offers three distinct advantages over thermofusion fittings;

- **Less insertion force enabling quick and easy installation**
- **Quick installation, hence more economical**
- **Disassembly and Reassembly enabling the reuse**
- **Depth of pipe installation till the end stop providing positive installation feedback**

This section highlights engineering considerations when designing a PE pipe system with Philmac Push™.

## Head losses

The following table offers a guide in estimating head losses in PE pipe systems based on the conveyance of water. Use the following formula to estimate this head loss;

$$L = F \times D$$

where F = fitting constant  
D = pipe inner diameter [m]  
L = head loss based on equivalent pipe length [m]

| Fitting                    | Fitting Constant [F] |
|----------------------------|----------------------|
| 90° elbow                  | 30                   |
| 90° tee - straight through | 12                   |
| 90° tee - side branch      | 60                   |

## Resistance to Impact

The thermoplastic materials used in the Philmac Push™ fitting have excellent impact properties

## Abrasion resistance

Philmac Push™ is suitable for the transportation of abrasive slurries and will withstand normal conditions found in urban, mining, industrial, rural water and waste water systems

## Weathering

The materials used contain pigments to provide excellent protection to degradation due to ultra-violet radiation. Continuous use of the Philmac Push™ fitting in systems above ground is therefore permissible without additional protection.

## Electrolytic Corrosion

Philmac Push™ is non magnetising and does not cause electrolytic deterioration.

## Thermal Insulation

Polypropylene has natural thermal insulation of 2000 times over copper and 200 times over steel.

## Light Transmission

The all black Philmac Push™ does not transmit light, thus protecting the water quality in potable water pipelines from growth of micro organisms.

## Effect on Water

Philmac Push™ does not impart to water any odour, taste, colour, or any constituents in concentrations that could be injurious to health.

## Fluids other than Water

Philmac Push™ may convey a wide variety of fluids. The following table is provided as a guide only for the compatibility of various chemicals to Philmac Push™. Contact Philmac for advice on specific applications.

## Temperature

Philmac Push fittings are designed for cold water applications only. Exposure to elevated temperatures has a significant impact on the lifetime of the fittings. The minimum 50 year life specification for the fitting is based on an operating temperature of 23 degrees Celsius.

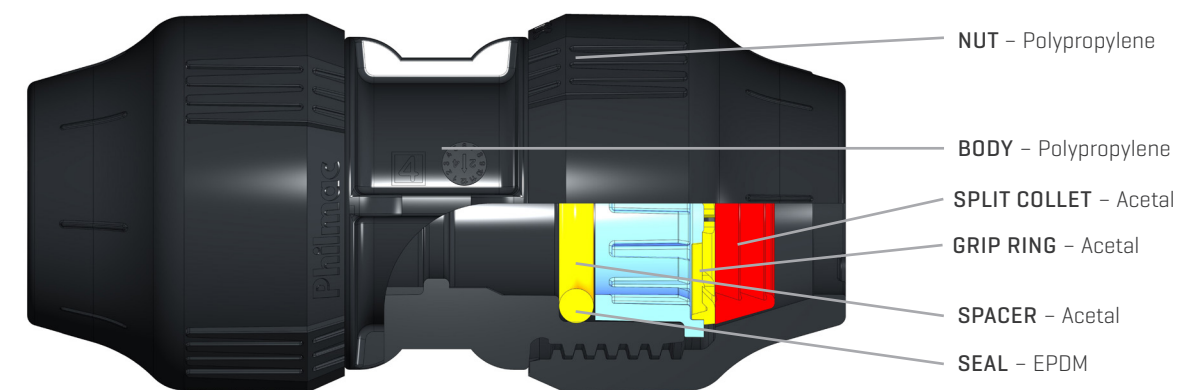
## Chemical Resistance

| Chemical                        | Compatibility | Chemical                       | Compatibility |
|---------------------------------|---------------|--------------------------------|---------------|
| Acetic Acid [10%]               | ✓             | Lubricating Oils               | ✗             |
| Acetone                         | ✓             | Magnesium Nitrate              | ✓             |
| Alcohol [Ethanol]               | ✓             | Magnesium Sulphate             | ✓             |
| Ammonium Hydroxide              | ✓             | Methane                        | ✗             |
| Ammonium Nitrate                | ✓             | Methylene Chloride             | ✗             |
| Antifreeze [<50% concentration] | ✗             | Mineral Oils                   | ✗             |
| Benzene                         | ✗             | Nitric Acid                    | ✗             |
| Brine                           | ✓             | Olive Oil                      | ✗             |
| Calcium Carbonate               | ✓             | Petroleum Oils                 | ✗             |
| Calcium Chloride                | ✓             | Phosphoric Acid [<30% aqueous] | ✓             |
| Calcium Nitrate                 | ✓             | Potable Water                  | ✓             |
| Calcium Sulphate                | ✓             | Potassium Chloride             | ✓             |
| Caustic Soda [<40% aqueous]     | ✓             | Potassium Nitrate              | ✓             |
| Chlorine Water                  | ✗             | Sewerage                       | ✓             |
| Citric Acid [10% aqueous]       | ✓             | Sodium Bicarbonate             | ✓             |
| Compressed Air                  | ✗             | Sodium Cyanide                 | ✓             |
| Copper Chloride                 | ✓             | Sodium Hypochlorite [<10%]     |               |
| Copper Sulphate <5%]            | ✓             | Sulphuric Acid [<40% aqueous]  | ✓             |
| Cresol                          | ✗             | Toluene                        | ✗             |
| Diesel                          | ✗             | Turpentine                     | ✗             |
| Formic Acid                     | ✓             | Urea [<30% aqueous]            | ✓             |
| Gasoline                        | ✗             | Zinc Nitrate                   | ✓             |
| Hydrochloric Acid [10%]         | ✓             | Zinc Sulphate                  | ✓             |
| Kerosene                        | ✗             |                                |               |

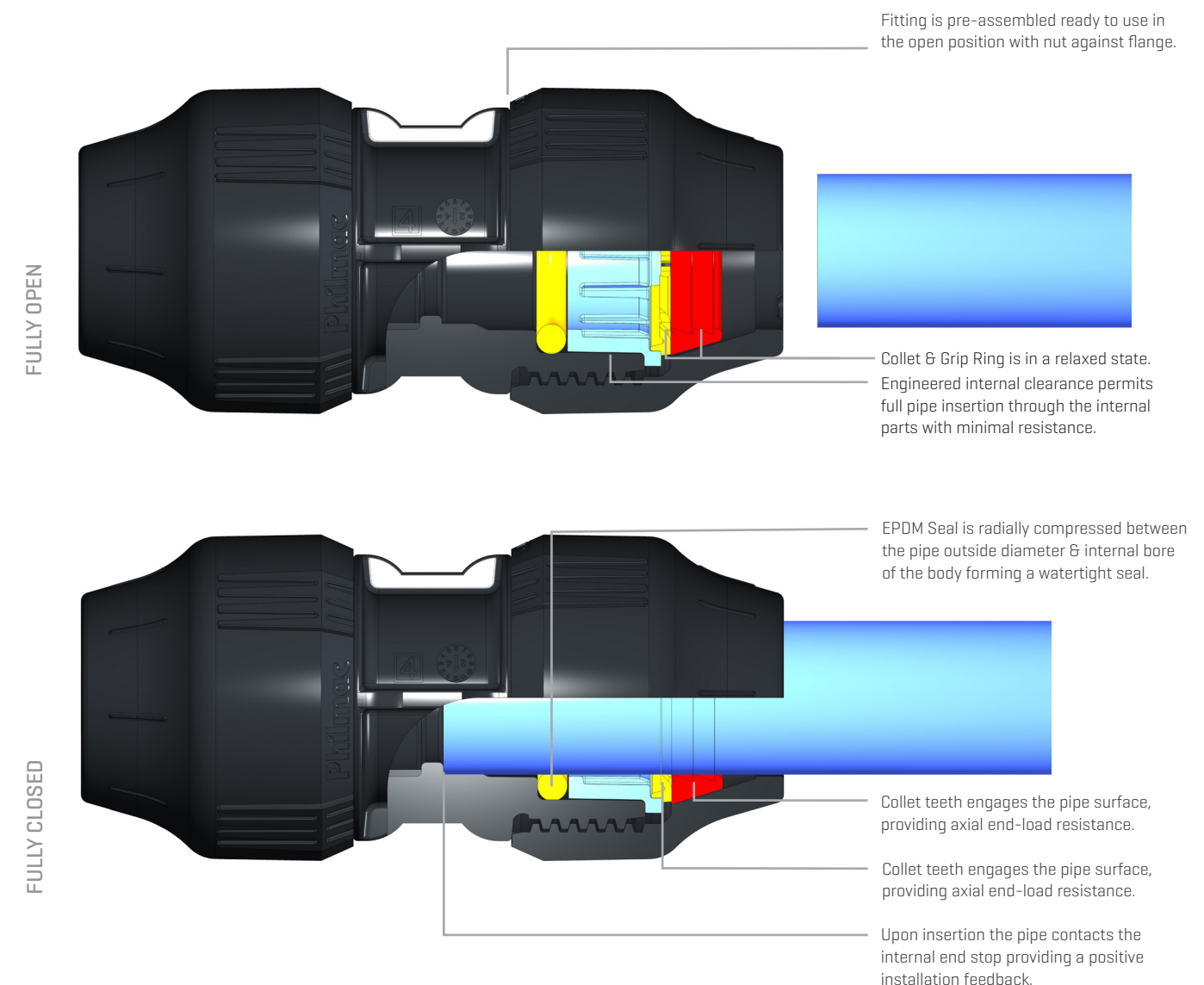


**Empty Cell=No data available**  
Note recommendations based on fluids at 20° C or less

## Materials & Components



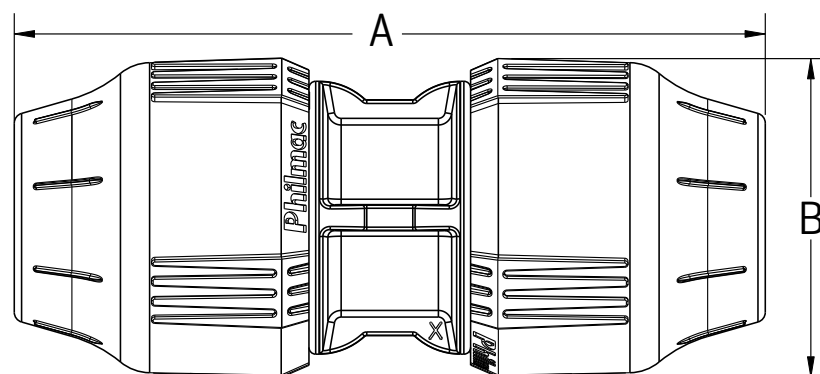
## Principals of Operation



## Range Dimensions & Weights

### JOINERS

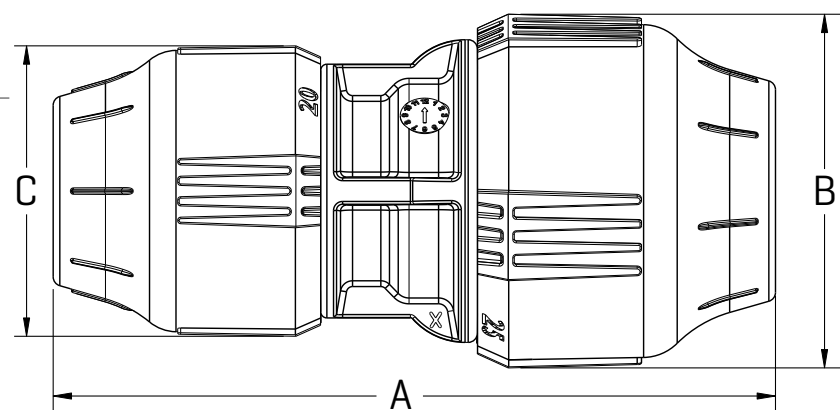
[Metric X Metric]



| Product No. | Size    | Dimensions mm. |       | kg.   |
|-------------|---------|----------------|-------|-------|
|             |         | A              | B     | Wt    |
| 74 7122 00  | 20 x 20 | 111.5          | 48.9  | 0.087 |
| 74 7133 00  | 25 x 25 | 119.2          | 57.8  | 0.129 |
| 74 7144 00  | 32 x 32 | 147.7          | 70.5  | 0.214 |
| 74 7155 00  | 40 x 40 | 173            | 84.2  | 0.384 |
| 74 7166 00  | 50 x 50 | 203.3          | 97.2  | 0.565 |
| 74 7177 00  | 63 x 63 | 234            | 112.2 | 0.848 |

### REDUCING JOINERS

[Metric X Metric]



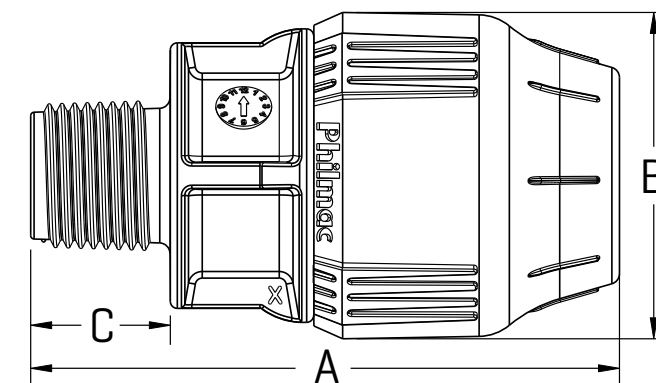
| Product No. | Size    | Dimensions mm. |       |      | kg.   |
|-------------|---------|----------------|-------|------|-------|
|             |         | A              | B     | C    | Wt    |
| 74 7132 00  | 25 x 20 | 118.2          | 57.8  | 48.9 | 0.114 |
| 74 7142 00  | 32 x 20 | 132.2          | 70.5  | 48.9 | 0.158 |
| 74 7143 00  | 32 x 25 | 134.3          | 70.5  | 57.8 | 0.181 |
| 74 7174 00  | 63 x 32 | 207.4          | 112.3 | 70.5 | 0.560 |



## Range Dimensions & Weights

### MALE END CONNECTORS

[Metric X MI BSP]



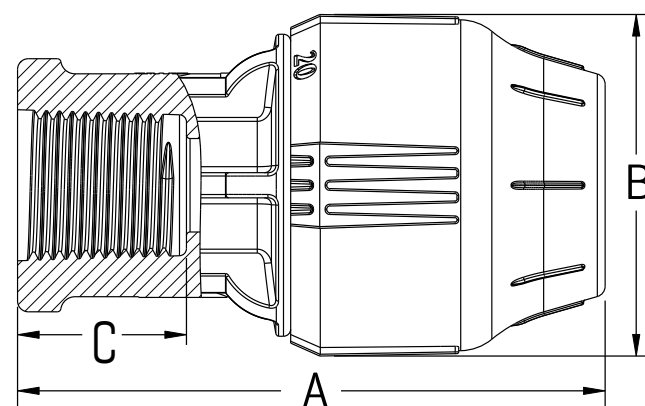
| Product No. | Size        | Dimensions mm. |       |      | kg.   |
|-------------|-------------|----------------|-------|------|-------|
|             |             | A              | B     | C    | Wt    |
| 74 7221 00  | 20 x 1/2"   | 84.3           | 48.9  | 20.0 | 0.052 |
| 74 7222 00  | 20 x 3/4"   | 85.3           | 48.9  | 21.0 | 0.053 |
| 74 7231 00  | 25 x 1/2"   | 93.3           | 57.8  | 20.0 | 0.081 |
| 74 7232 00  | 25 x 3/4"   | 89.1           | 57.8  | 18.0 | 0.075 |
| 74 7233 00  | 25 x 1"     | 98.9           | 57.8  | 24.7 | 0.085 |
| 74 7242 00  | 32 x 3/4"   | 105.0          | 70.5  | 21.0 | 0.127 |
| 74 7243 00  | 32 x 1"     | 108.0          | 70.5  | 24.0 | 0.124 |
| 74 7244 00  | 32 x 1-1/4" | 111.0          | 70.5  | 27.0 | 0.136 |
| 74 7245 00  | 32 x 1-1/2" | 110.2          | 70.5  | 26.7 | 0.138 |
| 74 7253 00  | 40 x 1"     | 124.5          | 84.2  | 24.0 | 0.222 |
| 74 7254 00  | 40 x 1-1/4" | 127.5          | 84.2  | 26.7 | 0.225 |
| 74 7255 00  | 40 x 1-1/2" | 127.0          | 84.2  | 26.7 | 0.226 |
| 74 7265 00  | 50 x 1-1/2" | 137.9          | 97.2  | 26.7 | 0.325 |
| 74 7266 00  | 50 x 2"     | 142.9          | 97.2  | 31.0 | 0.335 |
| 74 7275 00  | 63 x 1-1/2" | 156.0          | 112.2 | 26.7 | 0.509 |
| 74 7276 00  | 63 x 2"     | 162.0          | 112.2 | 31.0 | 0.515 |



## Range Dimensions & Weights

### FEMALE END CONNECTORS

[Metric X FI BSP]



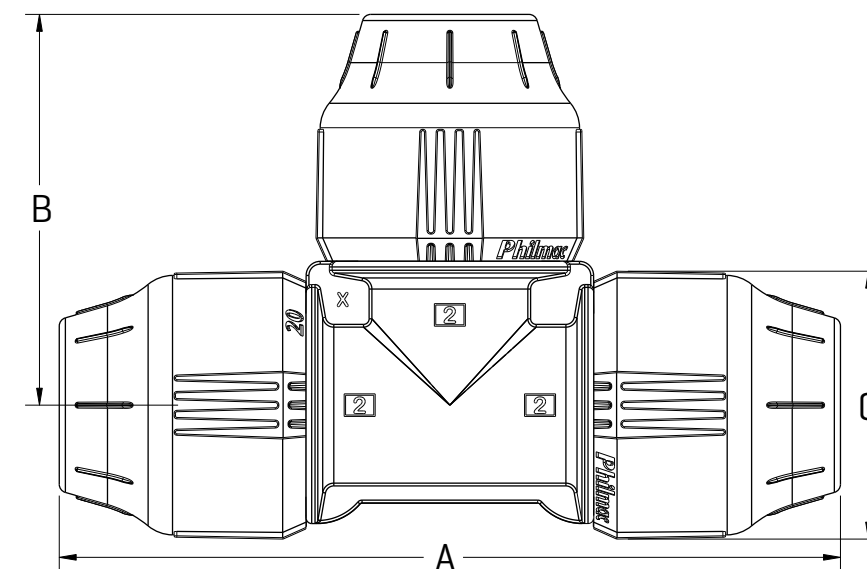
| Product No. | Size        | Dimensions mm. |       |      | kg.   |
|-------------|-------------|----------------|-------|------|-------|
|             |             | A              | B     | C    | Wt    |
| 74 7821 00  | 20 x 1/2"   | 81.75          | 48.9  | 23.5 | 0.058 |
| 74 7822 00  | 20 x 3/4"   | 80.25          | 48.9  | 22.5 | 0.058 |
| 74 7831 00  | 25 x 1/2"   | 86.6           | 57.8  | 22.5 | 0.077 |
| 74 7832 00  | 25 x 3/4"   | 85.8           | 57.8  | 24   | 0.078 |
| 74 7833 00  | 25 x 1"     | 89.75          | 57.8  | 27.4 | 0.089 |
| 74 7842 00  | 32 x 3/4"   | 106.5          | 70.5  | 24.1 | 0.148 |
| 74 7843 00  | 32 x 1"     | 101.95         | 70.5  | 27.4 | 0.139 |
| 74 7844 00  | 32 x 1-1/4" | 104.45         | 70.5  | 30.2 | 0.141 |
| 74 7854 00  | 40 x 1-1/4" | 118.5          | 84.2  | 30.2 | 0.228 |
| 74 7855 00  | 40 x 1-1/2" | 118.5          | 84.2  | 30   | 0.234 |
| 74 7865 00  | 50 x 1-1/2" | 126.92         | 97.2  | 27   | 0.308 |
| 74 7866 00  | 50 x 2"     | 127.9          | 97.2  | 28   | 0.326 |
| 74 7876 00  | 63 x 2"     | 146.84         | 112.2 | 30.4 | 0.478 |



## Range Dimensions & Weights

### TEES

[Metric X Metric X Metric]



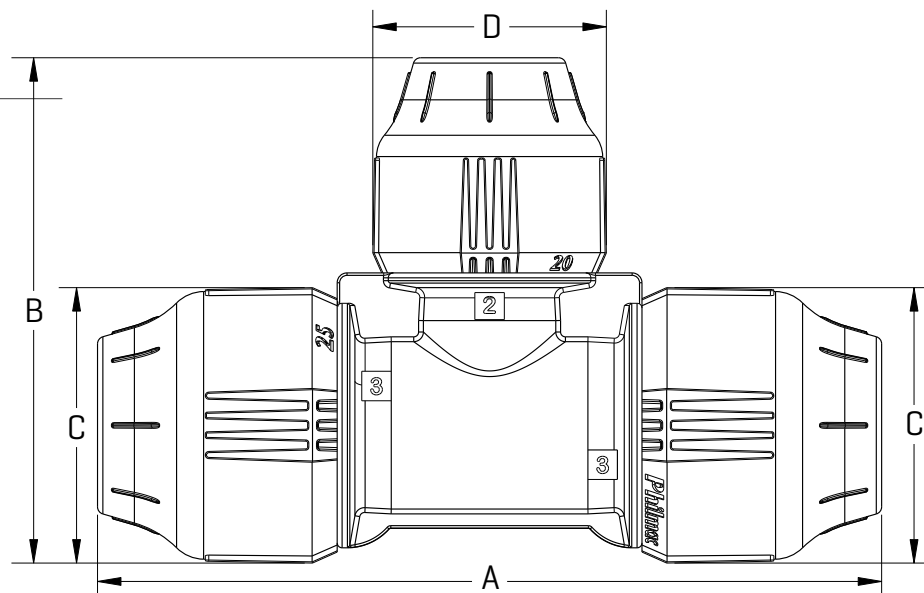
| Product No. | Size         | Dimensions mm. |        |       | kg.   |
|-------------|--------------|----------------|--------|-------|-------|
|             |              | A              | B      | C     | Wt    |
| 74 7322 00  | 20 x 20 x 20 | 138.58         | 69.3   | 48.9  | 0.142 |
| 74 7333 00  | 25 x 25 x 25 | 156.2          | 78.1   | 57.8  | 0.212 |
| 74 7344 00  | 32 x 32 x 32 | 182.71         | 91.36  | 70.5  | 0.345 |
| 74 7355 00  | 40 x 40 x 40 | 218.5          | 110    | 84.2  | 0.618 |
| 74 7366 00  | 50 x 50 x 50 | 245.05         | 122.2  | 97.2  | 0.851 |
| 74 7377 00  | 63 x 63 x 63 | 289.64         | 144.82 | 112.2 | 1.417 |



## Range Dimensions & Weights

### REDUCING TEES

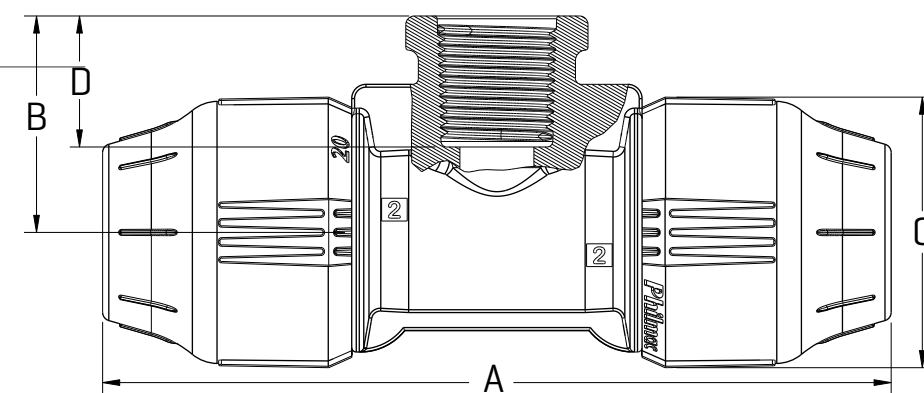
[Metric X Metric X Metric]



| Product No. | Size         | Dimensions mm. |        |      |      | kg.   |
|-------------|--------------|----------------|--------|------|------|-------|
|             |              | A              | B      | C    | D    | Wt    |
| 74 7332 00  | 25 x 25 x 20 | 159.5          | 102.75 | 57.8 | 48.9 | 0.197 |
| 74 7343 00  | 32 x 32 x 25 | 187.9          | 121    | 70.5 | 57.9 | 0.321 |

### FEMALE TEES

[Metric X Metric X FI BSP]



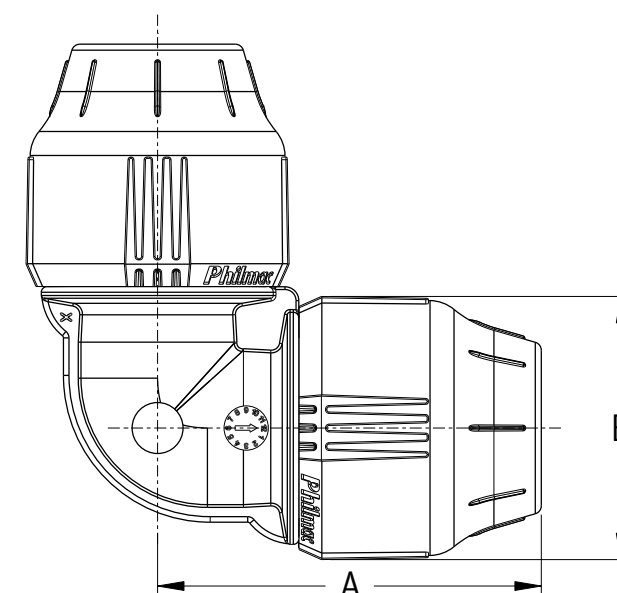
| Product No. | Size             | Dimensions mm. |      |      |      | kg.   |
|-------------|------------------|----------------|------|------|------|-------|
|             |                  | A              | B    | C    | D    | Wt    |
| 74 7421 00  | 20 x 20 x 1/2"   | 138.5          | 38   | 48.9 | 23   | 0.072 |
| 74 7422 00  | 20 x 20 x 3/4"   | 138.5          | 38   | 48.9 | 23.5 | 0.077 |
| 74 7431 00  | 25 x 25 x 1/2"   | 143.5          | 39.5 | 57.8 | 22.5 | 0.147 |
| 74 7432 00  | 25 x 25 x 3/4"   | 159.9          | 40.5 | 57.8 | 24   | 0.169 |
| 74 7433 00  | 25 x 25 x 1"     | 159.5          | 43.9 | 57.8 | 27   | 0.174 |
| 74 7442 00  | 32 x 32 x 3/4"   | 187.9          | 43.6 | 70.5 | 24   | 0.263 |
| 74 7443 00  | 32 x 32 x 1"     | 187.9          | 46.5 | 70.5 | 27   | 0.271 |
| 74 7444 00  | 32 x 32 x 1-1/4" | 187.9          | 50   | 70.5 | 29.5 | 0.280 |



## Range Dimensions & Weights

### ELBOWS

[Metric X Metric]



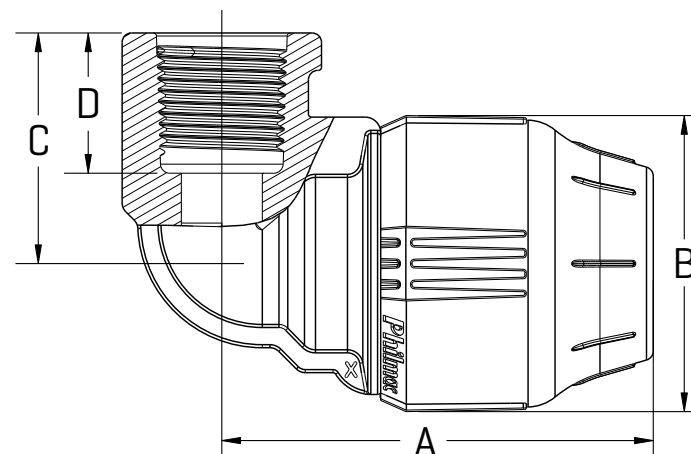
| Product No. | Size    | Dimensions mm. |       | kg.   |
|-------------|---------|----------------|-------|-------|
|             |         | A              | B     | Wt    |
| 74 7522 00  | 20 x 20 | 69.3           | 48.9  | 0.093 |
| 74 7533 00  | 25 x 25 | 79.8           | 57.8  | 0.152 |
| 74 7544 00  | 32 x 32 | 91.4           | 70.5  | 0.237 |
| 74 7555 00  | 40 x 40 | 109.5          | 84.2  | 0.417 |
| 74 7566 00  | 50 x 50 | 122.6          | 97.2  | 0.593 |
| 74 7577 00  | 63 x 63 | 144.8          | 112.2 | 0.934 |



## Range Dimensions & Weights

### FEMALE ELBOWS

[Metric X FI BSP]

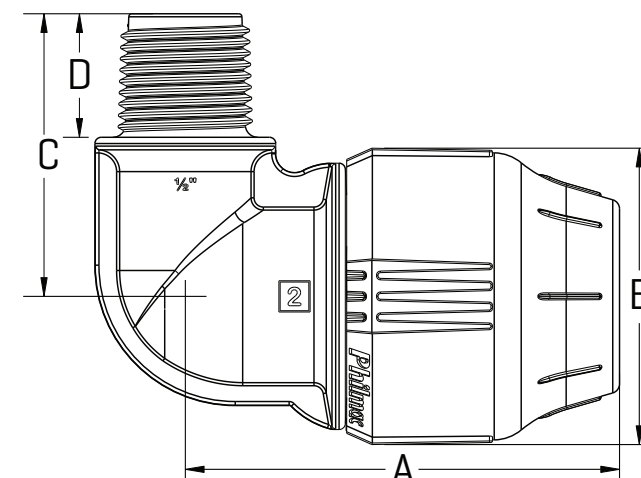


| Product No. | Size        | Dimensions mm. |      |       |       | kg.   |
|-------------|-------------|----------------|------|-------|-------|-------|
|             |             | A              | B    | C     | D     | Wt    |
| 74 7621 00  | 20 x 1/2"   | 69.25          | 48.9 | 37    | 22.5  | 0.056 |
| 74 7622 00  | 20 x 3/4"   | 69.25          | 48.9 | 38    | 24    | 0.062 |
| 74 7631 00  | 25 x 1/2"   | 75.11          | 57.8 | 39.5  | 22.8  | 0.079 |
| 74 7632 00  | 25 x 3/4"   | 79.75          | 57.8 | 40.63 | 24    | 0.092 |
| 74 7633 00  | 25 x 1"     | 79.75          | 57.8 | 43.93 | 27    | 0.102 |
| 74 7643 00  | 32 x 1"     | 93.95          | 70.5 | 47    | 27    | 0.146 |
| 74 7644 00  | 32 x 1-1/4" | 94.6           | 70.5 | 50.55 | 30.55 | 0.156 |

## Range Dimensions & Weights

### MALE ELBOWS

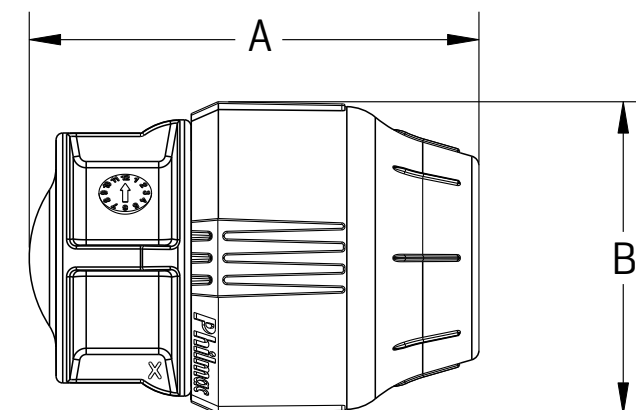
[Metric X MI BSP]



| Product No. | Size        | Dimensions mm. |      |      |      | kg.   |
|-------------|-------------|----------------|------|------|------|-------|
|             |             | A              | B    | C    | D    | Wt    |
| 74 7721 00  | 20 x 1/2"   | 69.2           | 48.9 | 43.5 | 19.8 | 0.058 |
| 74 7731 00  | 25 x 1/2"   | 77.8           | 57.8 | 49.8 | 20.4 | 0.089 |
| 74 7732 00  | 25 x 3/4"   | 77.8           | 57.8 | 51.1 | 20.6 | 0.083 |
| 74 7733 00  | 25 x 1"     | 77.8           | 57.8 | 49.5 | 24.5 | 0.093 |
| 74 7743 00  | 32 x 1"     | 89.8           | 70.5 | 56   | 20.4 | 0.147 |
| 74 7744 00  | 32 x 1-1/4" | 94             | 70.5 | 63.7 | 26.7 | 0.168 |
| 74 7755 00  | 40 x 1-1/2" | 109.5          | 84.2 | 69.7 | 27   | 0.275 |

### END CAP

[Metric]



| Product No. | Size | Dimensions mm. |       | kg.   |
|-------------|------|----------------|-------|-------|
|             |      | A              | B     | Wt    |
| 74 7029 00  | 20   | 68.4           | 48.9  | 0.050 |
| 74 7039 00  | 25   | 80.7           | 57.8  | 0.078 |
| 74 7049 00  | 32   | 92.0           | 70.5  | 0.125 |
| 74 7059 00  | 40   | 110.6          | 84.2  | 0.216 |
| 74 7069 00  | 50   | 126.1          | 97.2  | 0.318 |
| 74 7079 00  | 63   | 150.3          | 112.2 | 0.488 |





# Vinidex

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