

**PexFittings™** CRIMPING INSTRUCTIONS FOR PEX INSERT FITTING & VALVES

**CRIMP MECHANICS**

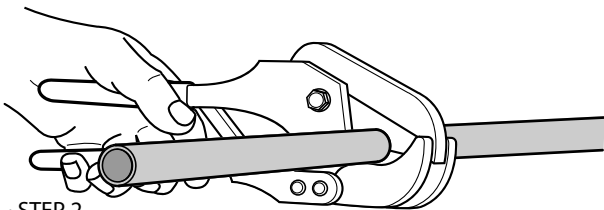
Proper crimp ring placement is essential. The crimp ring forces the tubing between the ribs creating a permanent seal. A smooth crimp ensures a proper seal. Any dimples or misalignment of the crimp ring may cause leaks.

**HOW TO MAKE CRIMP CONNECTIONS**

Please read the instructions thoroughly before beginning.

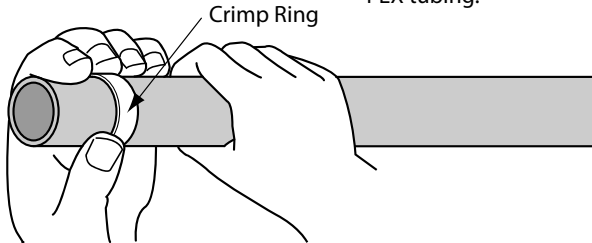
**• STEP 1**

Squarely cut tubing with the pipe cutter. Burrs, jagged or irregular cuts may result in an improper connection.



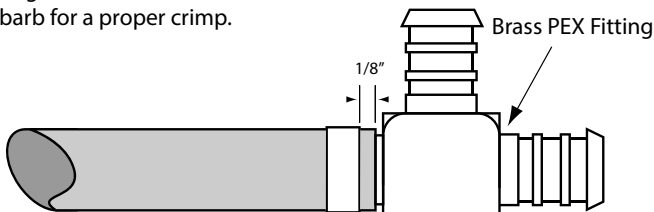
**• STEP 2**

Slide the correct sized copper crimp ring over the PEX tubing.



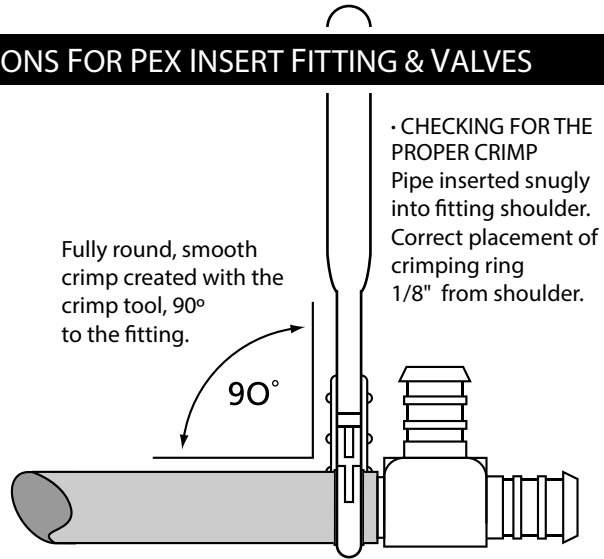
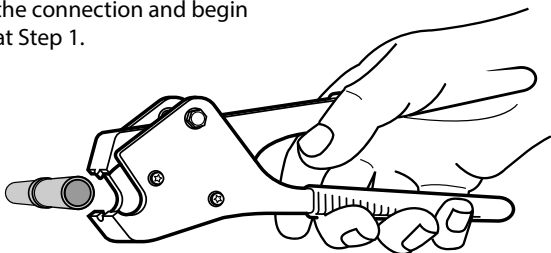
**• STEP 3**

Insert the fitting into the tubing up to the fitting shoulder. Position the crimp ring 1/8" from the end of the tube. The crimp ring must cover the ribs on the barb for a proper crimp.



**• STEP 4**

Using a calibrated crimp tool for the correct size, centre the crimping tool jaws over the ring. HOLD THE TOOL AT 90° to the fitting and close the jaws completely. Crimp only one time. If crimped more than once, you must cut out the connection and begin at Step 1.



\* CAUTION : Angled crimp connections can damage the pex tubing and place severe stress on the fitting barb.

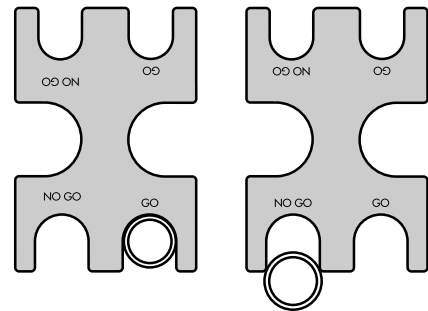
**\* STEP 5**

**CHECK EVERY CRIMP!**

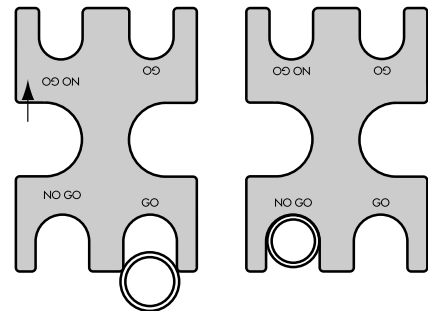
Each crimp connection should be checked with a 'Go / No Go' gauge to ensure proper installation. When checking the crimp with the 'Go / No Go' gauge, make sure to push straight down on the crimp ring.

A proper crimp has been established if the 'Go' side of the gauge fits over and can rotate around the circumference of the crimp ring.

Mark fitting as proper and proceed



Improper connection, cut and begin again



\* Do not use tools which produce an eared clamp. A bad crimp must be cut out of the tubing and replaced.

**'GO' / 'NO GO' GAUGE**

Normal wear and tear can effect gauge accuracy so periodically check gauge with a measuring device or change to a new gauge regularly to ensure accuracy.

An improper crimp is when (1) the 'Go' side does not fit over the ring -OR- (2) the 'No Go' side does fit over the crimp ring.