

PexFittings™ CRIMPING INSTRUCTIONS FOR PEX INSERT FITTING & VALVES

CRIMP MECHANICS

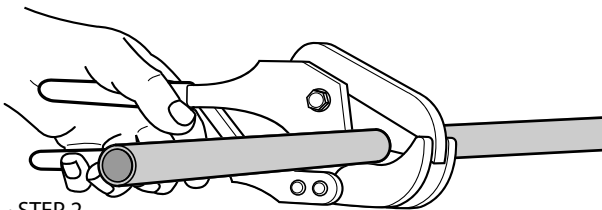
Proper crimp ring placement is essential. The crimp ring forces the tubing between the ribs creating a permanent seal. A smooth crimp ensures a proper seal. Any dimples or misalignment of the crimp ring may cause leaks.

HOW TO MAKE CRIMP CONNECTIONS

Please read the instructions thoroughly before beginning.

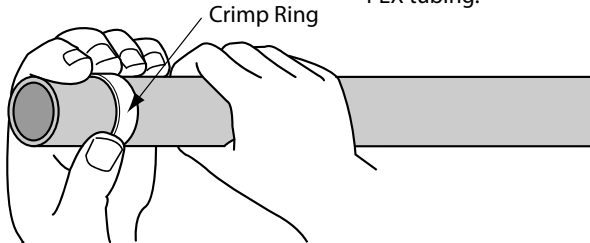
• STEP 1

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



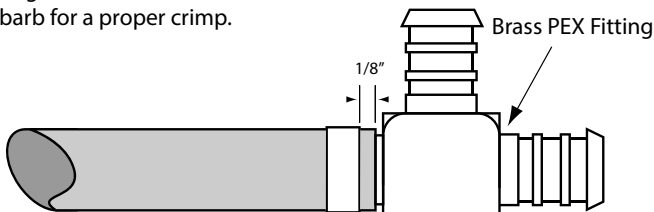
• STEP 2

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



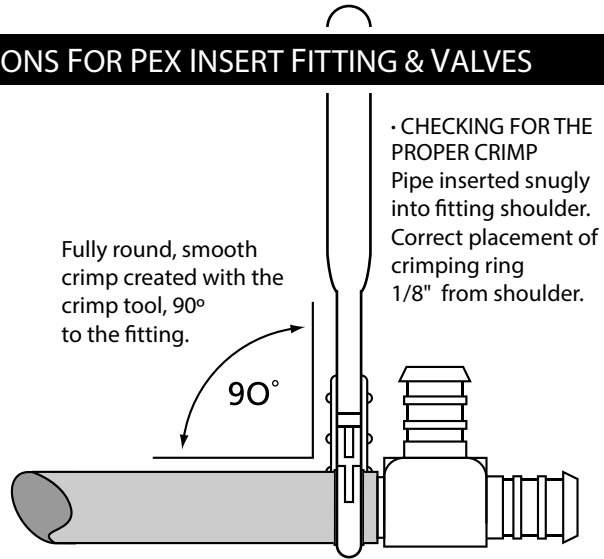
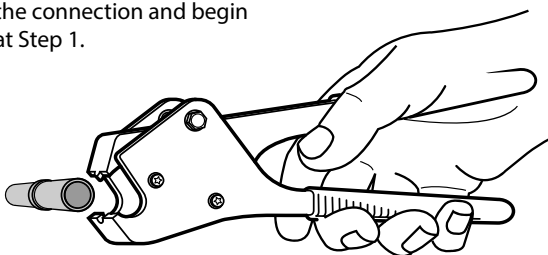
• STEP 3

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.



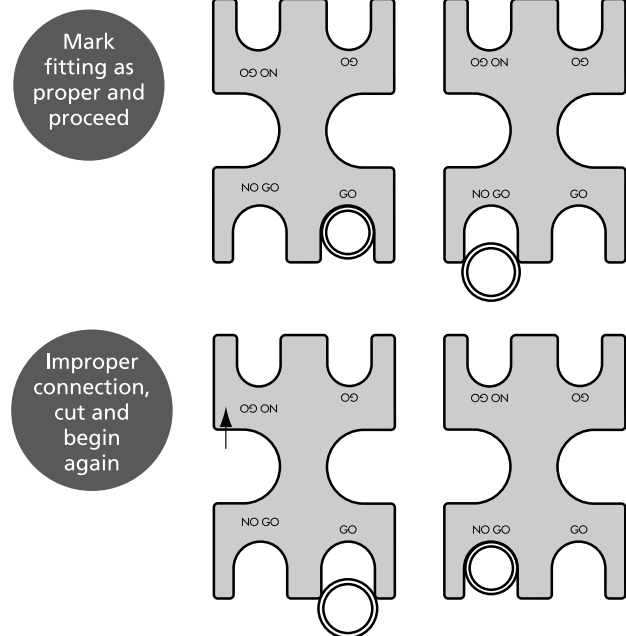
* CAUTION : Angled crimp connections can damage the pex tubing and place severe stress on the fitting barb.

*** 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.



* 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.