



Pipe Tools & Vises  
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# Recommended Procedures for Using Reed Rerounding Tools

RR<sup>3</sup>/<sub>4</sub>, RR1, RR 1<sup>1</sup>/<sub>2</sub> and RR2

## Necessary Tools & Equipment

1. Reed tubing cutter (Reed T20 equipped with "O" wheel for cutting copper)
2. Proper size rerounding tool
3. Proper size hammer flaring tool (if necessary)
4. Soft-faced BRASS hammer (HAM3)
5. Two pipe wrenches
6. Rat tail, flat files and deburring tool (Reed DEB0)
7. Safety goggles and gloves

**WARNING:** Before rerounding, all instructions must be read, understood and followed. Safety goggles must be worn during all work to prevent serious eye injury.



Reed HF flaring tools must only be struck with a soft-faced BRASS hammer to prevent flying chips. The Reed RR<sup>3</sup>/<sub>4</sub>, RR1, RR 1<sup>1</sup>/<sub>2</sub> and RR2 rerounding tools are intended for use with type "K" copper tubing only. Use proper size rerounding tool. These rerounding tools are to be used only for rerounding operations.

## Procedure

1. Wear safety goggles per OSHA regulations.
2. Using a tubing cutter, cut copper tubing to desired length. Be sure cut is square.
3. Using a deburring tool or a file, remove all burrs from the inside and outside of the pipe. Unburred tubing could cause leakage.
4. Inspect rerounding tool and hammer per the following instructions and make necessary repairs before using.
5. Place some potable grease on the shank of the tool to lubricate during rerounding procedure.
6. Insert rerounding tool in end of tubing.

7. Using a soft-faced BRASS hammer (DO NOT USE A HARDENED STEEL HAMMER), strike the rerounding tool a few light blows, rotating the tool a small amount after each blow until the edge of the tool reaches the end of the tubing.
8. Remove the rerounding tool and inspect the joint surfaces of the tubing to be sure they are clean and that no scratches or blemishes are present that could cause a leak. If scratches or blemishes are present, redo steps 1-8.
9. Place tubing end into compression fitting and tighten nut.
10. If using flare connection, proceed with correct flaring tool and follow instructions.
11. Inspect rerounding tool and hammer per instructions below and repair or replace if necessary.

Proper Care and Maintenance of Reed Rerounding Tools  
Numerous blows or off-center blows to the Reed RR<sup>3</sup>/<sub>4</sub> through RR2 rerounding tools may cause "mushrooming" of the striking surface.

**IF THE STRIKING SURFACE BEGINS TO MUSHROOM, THE TOOL SHOULD BE REMOVED FROM SERVICE AND REPAIRED OR REPLACED.**

Reed rerounding tools should be inspected after each use and not used until repaired.

Repair would consist of grinding or filing the striking surface to its approximate original shape, maintaining a slight crown on the end. The soft-faced brass hammer should be inspected after each use and if the striking face surface is mushroomed, the deformed material should be removed.

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