PIPE TOOLS & VISES
SINCE 1896

# Recommended Procedures for Using Rerounding Tools

## RR 3/4, RR1, RR1 1/2 and RR2

**Necessary Tools & Equipment**

1. Tubing Cutter (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. Smooth Jaw Wrenches
6. Rat tail, flat files and deburring tool (DEBO or DEB3)
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 RR 3/4, RR1, RR 1 1/2 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, with smooth jaw wrench.
10. If using flare connection, proceed with correct flaring tool and follow instructions. REED HF flaring tools must only be struck with a soft-faced BRASS hammer to prevent flying chips.
11. Inspect rerounding tool and hammer per instructions and repair or replace if necessary.

**TIP:** To extract rerounder from tubing, insert a rod through top hole and turn.

**Proper Care and Maintenance**

Numerous blows or off-center blows to the REED RR series 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.

**Reed Manufacturing**
**1425 West 8th Street**
**Erie, PA 16502 USA**

**Phone +1-814-452-3691 or 800-666-3691**
**reedsales@reedmfgco.com**
**www.reedmfgco.com**

BEST SERVICE QUALITY PEOPLE EQUALS LOWEST TOTAL COST

0520-50495